



TECHNICAL INFORMATION SHEET

STAY SILV® 2HP BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Silver	1.8 - 2.2 %
Copper	Remainder
Phosphorus	7.3 - 7.4%
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1405°F (763°C)
Brazing Range	1300°F- 1455°F (704°C -788°C)

BRAZING PROPERTIES:

Stay Silv 2HP features a higher phosphorus content which provides a narrower melting range and quicker flow. This alloy is designed for use on applications where close, uniform clearance can be maintained.

CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv 2HP, should not be used if the braze is exposed to sulfur or sulfur compounds in service

AVAILABLE FORMS

Standard wire diameters; rods and preform rings.

RECOMMENDED FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass, use Stay-Silv® white flux. Harris ECO SMART® boric acid free flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

Harris internal specification range.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

Additional information available at our web site: www.harrisproductsgroup.com