



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
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TECHNICAL SPECIFICATION SHEET

ISO 9001
 Cert. No. 31598

HARRIS 0 LOW PHOSPHORUS BRAZING FILLER METAL

STATEMENT OF LIABILITY- DISCLAIMER

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NOMINAL CHEMICAL COMPOSITION:

Phosphorus 6.80 %
 Copper Remainder
 Other Totals .15% max

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)	Specific Gravity	8.11
Liquidus	1510-1514°F (821-823°C)		
Brazing Temperature Range	1350-1550°F (732-843°C)		
Color	Bright Shiny Copper		

BRAZING PROPERTIES:

This is economical filler metal designed for joining copper, brass and bronze. When joining brass or bronze, a chemical flux, such as Stay Silv white brazing flux should be employed. This is a fairly sluggish alloy useful in applications where joint tolerance cannot be maintained. Recommended joint clearance .003"-.006"

AVAILABLE FORMS:

Standard wire diameters, Preformed rings,

SPECIFICATION COMPLIANCE:

Harris Internal

RECOMMENDED FLUX:

No flux required on copper
 Stay Silv white or black brazing flux with Brasses

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3/08 MK



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

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- 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 arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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