



TECHNICAL SPECIFICATION SHEET

J.W. HARRIS CO., INC.
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ISO 9002
Cert. No. 31598

HARRIS PHOSON[®] BRAZING FILLER METAL

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 Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, 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, 550 N.W. LeJeune Road, Miami, Florida 33126; 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. J.W. Harris Co., Inc. and its affiliates shall have no liability in respect thereof.

NOMINAL CHEMICAL COMPOSITION:

Silver	.08-.12 %
Phosphorus	7.30 %
Copper	Remainder
Other Totals	.15 % max.

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1445-1455°F (785-791°C)
Brazing Temperature Range	1350-1500°F (732-815°C)
Color	Bright Shiny Copper



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BRAZING PROPERTIES:

Harris Phoson[®] is a high quality, low cost, lead-free filler metal produced through proprietary Harris Technology which results in the added advantage of accurate control of density and melting characteristics. Phoson[®] is designed with a nominal addition of silver to help enhance its flow and handling properties. The newly formulated brazing filler metal is ideally suited for brazing copper, brass and bronze where its high fluidity permits penetration into the close fit ups encountered in most applications.

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

J.W. Harris Co., Inc.
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Additional information available at our web site:

www.jwharris.com

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