



TECHNICAL INFORMATION SHEET

CDA 102 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Copper	99.95%
Oxygen	0.0010%

TYPICAL PHYSICAL PROPERTIES:

Solidus	1981°F (1083°C)
Liquidus	1981°F (1083°C)
Brazing Range	2000°F-2100°F (1093°C-1149°C)
Density	0.323 (lbs./cu/in)
Electrical Conductivity	101 (%IACS)

BRAZING PROPERTIES:

Harris CDA102 is an oxygen free copper filler metal primarily used in protective atmosphere furnace brazing of steel, stainless steel, nickel, and copper nickel. It provides good corrosion resistance as well as excellent electrical and thermal conductivity

The eutectic melting temperature provides rapid flow and tight part clearance is recommended - a press fit to 0.002", (0.000 – 0.051 mm).

AVAILABLE FORMS

Preform rings,

RECOMMENDED FLUX:

For atmosphere furnace braze a flux is generally not required.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCu-3, UNS C10200

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.

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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.

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