



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

TECHNICAL SPECIFICATION SHEET

ISO 9002
Cert. No. 31598

HARRIS STAY SILV® 99 POWDER BRAZING FLUX

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.

MINIMAL COMPOSITION

Stay-Silv is an organic fluoride type flux.

Physical Properties:

Active Range 150-1600°F (566-871°C)

BRAZING PROPERTIES:

Harris Stay Silv 99 powder brazing flux is an all-purpose flux for use in silver brazing most ferrous and non-ferrous metals except aluminum, magnesium, and titanium.

Recommended filler metals for use with Stay Silv 99 powder brazing flux includes those of BAg and BCuP classification of the AWS A5.8 specification.

The flux may be used by mixing with approximately 20% water to form a paste or by dipping a heated rod into the powdered flux. After brazing flux residue should be removed with a hot water wash.

AVAILABLE FORMS:

250 Gram jars, ¼ lb. jars, 25 & 40 lb. Pails

SPECIFICATIONS:

Harris Internal

WARNING: CONTAINS FLUORIDES. PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. Burns eyes and skin on contact. CAN BE FATAL IF SWALLOWED

- 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.
- Avoid contact of flux with eyes and skin.
- Do not take internally.
- Keep children away when using
- 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

First Aid: If contact in eyes, flush immediately with water for 15 minutes. If swallowed, induce vomiting. Never give anything by mouth to an unconscious person. Call a physician.

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

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