



TECHNICAL INFORMATION SHEET

HARRIS SAFETY SILV® 34T FLUX CORED BRAZING FILLER METAL

BRAZING PROPERTIES:

Safety Silv® 34T brazing filler metal is often specified as an economical replacement for higher silver content braze alloys. Compared to Safety Silv 38T the lower silver content is offset by small increases in the tin and copper percentages. This provides a filler metal with a slightly higher liquidus temperature but reduced cost.

This flux cored alloy contains an inner core of brazing flux which eliminates an additional fluxing operation. Safety Silv 34T flux cored wire has a wide melting range so it is useful in filling connections where tight clearance cannot be maintained. It is cadmium free and is an excellent replacement for many of the hazardous cadmium containing brazing products. Safety Silv flux cored 34T is primarily used to braze copper, brass, bronze, and steel.

FLUX CORE:

This alloy contains a continuous internal core of brazing flux. No additional flux is required.

CHEMICAL COMPOSITION RANGE % (metal):

Silver	33.0-35.0
Tin	1.5-2.5
Copper	35.0-37.0
Zinc	25.5 – 29.5
Other elements	ISO requirements

MELTING TEMPERATURE:

Solidus 1166°F (630°C)
Liquidus 1346°F (730°C)

AVAILABLE FORMS:

Standard wire diameters in coil, rod, preformed rings, or wound on spools for automated feeding.

SPECIFICATION COMPLIANCE (metal component):

ISO 17672 Ag 134, (No applicable AWS classification).

RoHS (Reduction of Hazardous Substances):

Conforms to the EU hazardous substance directive.

SAFETY INFORMATION:

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

FUMES AND GASES can be hazardous to your health. FLUX CONTAINS FLUORIDES – avoid breathing fumes generated during brazing.

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.

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