



TECHNICAL INFORMATION SHEET

PREMIUM SILVER™ Lead-Free Solder

CHEMICAL COMPOSITION RANGE %:

Copper	3.0 – 5.0
Silver	0.25 – 0.75
Tin	Remainder

TYPICAL PHYSICAL PROPERTIES:

Melting Temperature
Solidus 440°F (225°C)
Liquidus 660°F (349°C)

DESCRIPTION:

Premium Silver lead-free solder has a wide melting point that will bridge loose fit ups ideal for filling larger and capping solder connections. Premium Silver is lead and antimony free.

APPLICATION:

Prior to soldering, de-burr tube and fitting, then clean with a brush or Scotch Brite® to remove surface oxide. Brush a light coating of flux on parts. Avoid excess flux that might collect inside the connection.

Apply heat. For plumbing applications, an air/fuel torch is typically used. We recommend a Harris air-fuel hand torch using propane or MAP-Pro® gas. When additional heat is required, a Harris Inferno® torch with a swirl combustion tip provides rapid and controlled heat input. The Inferno uses air/acetylene, (or other fuel gases) to provide increased heating capability.

Parts should be at soldering temperature prior to solder application. Apply flux, preheat tube and fitting, then apply solder. Avoid melting the solder with just the torch flame. Remove flux residue after soldering.

RECOMMENDED FLUX:

Harris Water Soluble Plumbing Flux, (ASTM B813), - for copper and brass plumbing applications.

SPECIFICATION COMPLIANCE:



ASTM B32 Alloy Grade E,



National Sanitation Foundation

- NSF/ANSI Standard 61, Drinking Water System Components.
- NSF/ANSI 372 & US Safe Drinking Water Act amendments

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, Safety Data Sheets (SDS), and your employer's safety practices.
- Flux is corrosive and may be harmful or fatal if inhaled or swallowed.
- Flux may cause skin and eye burns.
- 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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