



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

HARRIS STAY SILV[®] 18 BRAZING FILLER METAL

ISO 9001
Cert. No. 31598

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. Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL CHEMICAL COMPOSITION:

Silver	17.2-18.0 %
Phosphorus	6.3-6.9%
Copper	Balance
Other Totals	.15 % max

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Electrical Conductivity (%IACS)	5.9
Liquidus	1220°F (720°C)	Electrical Resistivity	29.40
Brazing Temperature Range	1275-1450°F (691-788°C)	Color	Bright Shiny Copper
Specific Gravity	8.80	Density (oz./cu in)	4.27

BRAZING PROPERTIES:

This is a medium range silver brazing alloy designed for copper to copper applications, or copper to brass, using Stay-Silv[®] white brazing flux. The higher phosphorus, which creates a low temperature, highly fluid alloy, makes this alloy well suited for automated operations such as those with brazing rings.

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

Harris Products Group Internal spec

RECOMMENDED FLUX:

No flux required on copper
Stay Silv white or black brazing flux with Brass

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied. Additional information available at our web site: www.harrisproductsgroup.com

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 (MSDS), 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