



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
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TECHNICAL SPECIFICATION SHEET

ISO 9001
Cert. No. 31598

HARRIS SAFETY SILV® 0XHP BRAZING FILLER METAL

STATEMENT OF LIABILITY- DISCLAIMER

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NOMINAL CHEMICAL COMPOSITION:

Phosphorus	7.63 %
Copper	Remainder
Other Totals	.15 % max

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1414 -1416°F (767-769°C)
Specific Gravity	8.19
Brazing Temperature	1300-1500°F (704-816°C)

BRAZING PROPERTIES:

This is an economical medium-low brazing alloy used for joining copper, brass, and bronze. At brazing temperature this alloy is very fluid, but has very good fillet forming qualities. Although this alloy is very fluid, moderate gaps can be bridged using the plastic range of this alloy. If brass or bronze is to be joined, a chemical flux, such as Stay-Silv® white, should be employed. Recommended joint clearance .005" or less.

AVAILABLE FORMS:

Standard wire diameters, preformed rings,

SPECIFICATION COMPLIANCE:

Harris Internal

RECOMMENDED FLUX:

No flux required on copper
Stay-Silv® white or black brazing flux with Brasses

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

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- 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 arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts. 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.

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