



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 LAg2PA BRAZING FILLER METAL

STATEMENT OF LIABILITY- DISCLAIMER

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NOMINAL CHEMICAL COMPOSITION:

Silver	1.6-1.8 %
Phosphorus	6.36 %
Copper	Balance
Other Totals	.15 %

PHYSICAL PROPERTIES:

Solidus	1190° (643°C)
Liquidus	1510°-1520°F (821-827°C)
Color	Bright Shiny Copper

BRAZING PROPERTIES:

An economical brazing filler metal, designed with a broader melting range than the "0" alloys for joining copper to copper and copper to brasses. This alloy is very ductile, and has a wide plastic range suitable for joining loose connections. However, at brazing temperature this alloy is quite fluid and suitable for tight fit ups as well. Recommended joint clearance is .002" - .005".

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

The Harris Products Group 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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