



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 LCuP6 BRAZING FILLER METAL

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.

NOMINAL CHEMICAL COMPOSITION:

Phosphorus 6.50 %
Copper Remainder
Other Totals .15 % max.

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)	Color	Bright Shiny Copper
Liquidus	1545-1549°F (841-843°C)	Specific Gravity	8.11
Brazing Temperature Range	1350-1550°F (732-843°C)	Elongation in 2"	32 %

BRAZING PROPERTIES:

This is an economical filler metal designed for joining of copper, brass, and bronze. When joining brass or bronze, a chemical flux, such as Stay-Silv® white, should be employed. This is a sluggish alloy useful in applications where joint tolerance cannot be maintained. Recommended joint clearance is .002"-.006".

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

DIN 8513, Part 1 Class LCuP-6

RECOMMENDED FLUX:

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

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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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