



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

HARRIS LCuP 7 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. The Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL CHEMICAL COMPOSITION:

Phosphorus 7.40%
Copper Remainder
Other Totals .15% max.

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)	Brazing Temperature Range	1350-1500°F (732-816°C)
Liquidus	1441-1446°F (782°-786°C)	Specific Gravity	8.21
Color	Bright Shiny Copper	Elongation in 2"	32%

BRAZING PROPERTIES:

An economical, very fluid, medium temperature brazing filler metal for joining copper, brass and bronze. When joining brass to brass, or to copper, a chemical flux, such as Stay-Silv® white must be used. Recommended joint clearance is .002"-.005".

AVAILABLE FORMS:

Standard wire diameters and preformed rings.

SPECIFICATION COMPLIANCE:

DIN 8513, Part 1 Class LCuP-7, ANSI/AWS A5.8, Class BCuP-2, ASME SFA 5.8 Class BCuP-2 QQB 650C, Class BCuP-2

RECOMMENDED FLUX:

No flux required on copper
Stay Silv® white or black brazing flux with brass or bronze.

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 (MSDSs), 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.

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.

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3/08 MK



- 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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