



TECHNICAL INFORMATION SHEET

STAY-SILV[®] 5HP BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Phosphorus	6.6 - 6.7
Copper	Remainder
Silver	4.8 - 5.2
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1420°F (771°C)
Brazing Range	1320°F- 1500°F (716°C -816°C)

BRAZING PROPERTIES:

Stay-Silv[®] 5HP is a medium melting range silver brazing alloy designed for joining copper to copper and copper to brass. The alloy has a wider melting range suitable for joining loose connections. When heated above its liquidus, however, the alloy is fluid and suitable for connections with close fit-ups. Joint clearance recommendation is .003"-.006", (0.076 – 0.152) mm.

CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv 5HP, should not be used if the braze is exposed to sulfur or sulfur compounds in service.

AVAILABLE FORMS

Standard wire diameters, rod, preform rings, and spools.

RECOMMENDED FLUX:

No flux is required for copper to copper applications. Stay-Silv[®] white flux is suitable for brass. When flux is required Harris ECO SMART™ boric acid free flux is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCuP-7, ASME SFA 5.7 BCuP-7
ISO 17673 CuP 282,

SAFETY INFORMATION:

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 Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, 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, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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