



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
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

ISO 9002
Cert. No. 31598

HARRIS SAFETY-SILV® 45 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:

Silver	44 -46 %	Other Totals	.15 %
Copper	29 -31 %		
Zinc	24- 26 %		

PHYSICAL PROPERTIES:

Solidus	1225°F (662°C)	Specific Gravity	9.12
Liquidus	1370°F (743°C)	Electrical Conductivity (% I.A.C.S)	18.9
Density (Troy oz./ cu. In.)	4.81	Electrical Resistivity (Microhm-cm)	9.09
Color	Bright Shiny Yellow White		

BRAZING PROPERTIES:

Cadmium free alloy which has a plastic range of 145°F (63°C) with good flow and fillet forming qualities. This filler offers good joint strength and ductility at a moderately higher temperature. The plastic range of this alloy is an advantage when filling loose connections.

AVAILABLE FORMS:

- Standard wire diameters
- Preformed Rings
- Strip
- Flux coated rods

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8, ASME SFA 5.8, QQB 654A Class BAg-5

RECOMMENDED FLUX:

Stay-Silv white flux, or where heating cycles are extended, Stay-Silv black flux.

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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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