

## Safety-Silv® Silver Brazing Rods

Harris silver brazing alloys are produced with precise wire size and chemical composition. Harris offers no silver brazing alloys containing cadmium. Chemical Composition: Silver-45%, Copper-30%, Zinc-25%.

- Good ductility and capillary flow
- Color is silver to light yellow
- RoHS Compliant

Part No.	Diameter	Length	Weight
0864122	3/32"	18"	1 lb

## STAY-Silv® Silver Brazing Rods

Harris' STAY-Silv® 5 is a medium-range alloy is well suited where close fit-up cannot be maintained. This filler metal is somewhat more ductile than Harris 0 or Stay-Silv 2.

Chemical Composition: Silver-5%, Phosphorus-6%, Copper-89%. Conforms to AWS A5.8

- Convenient 8 Stick Pack
- Made in the USA
- RoHS Compliant
- Solidus 1190°F, Liquidus 1500°F

Use when close fit-ups cannot be maintained.

Part No.	Diameter	Length	Weight
0864191	0.050" x 1/8"	20"	1 lb

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Part No.	Diameter	Length	Weight
0864193	1/8"	20"	0.33 lb

## Copper Dynaflow® Brazing Rod

These brazing filler metals are primarily used to join copper to copper, copper to brass, and brass to brass. The phosphorus content serves as a "self-fluxing" agent in joining copper to copper. When brazing brass to copper or brass to brass, use Stay-Silv® White Brazing Flux. The phos/copper and silver/phos/copper filler metals are not recommended for brazing steel or nickel alloys. The amount of phosphorus in the phos/copper filler metals (AWS-BCuP series) is critical in determining precise melting range and performance. Proprietary computer based technology is used to accurately control the phosphorus content to exacting standards.

- Dynaflow is a premium, medium range silver alloy that has been meticulously formulated to even tighter specifications than Harris' standard copper-to-copper alloys.
- RoHS Compliant
- Solidus 1190°, Liquidus 1465°F.
- Chemical Composition: Silver-6%, Phosphorus-6.1%, Copper-87.9%.

Primarily used to join copper to copper, copper to brass, and brass to brass.

Part No.	Diameter	Length	Weight
0864305	1/8"	20"	1 lb

## Lead Free GAL VIZ® Solder

Harris' Gal Viz is a special self-fluxing lead-free solder alloy for repairing damaged galvanized coatings. Gal Viz provides excellent corrosion resistance. It has a working temperature of about 600° F. Apply while base metal is hot. A clean wire brush will aid in tinning the surface with Gal Viz. It can also be tinned with a paddle or cloth. Do not direct flame on the alloy.

- Excellent Corrosion Resistance
- Lead Free

Part No.	Diameter	Length	Weight
0864528	1/4"	14"	5 lb

## Copper Low Fuming Bronze Brazing Rods

Harris Low Fuming Bronze is a copper/zinc alloy developed for braze welding steel, cast iron, and copper. Harris American LFB flows faster with less build up compared to #15 bronze. It can also be used for build up and overlay. Harris American Bronze flows easily with minimal fuming. Deposits can be machined and have excellent ductility. Harris bronze can be deposited using standard oxy-fuel torches, or with Harris Power Torch acetylene or MAPP® swirl tip equipment.

- Melting temperature: 1590° F - 1630° F
- Developed for braze welding steel, cast iron, and copper

Part No.	Diameter	Length	Weight
0864531	1/8"	36"	50 lb
0864532	5/32"	36"	50 lb

## Solder

### Lead Free Solder

Tin-antimony solder well suited for applications where moderately elevated temperature is a factor. With higher electrical conductivity and high fluidity, 95/5 is recommended for lead free installation of small diameter, tight fitting connections. Not recommended for use on brass or HVAC connections.

Chemical Composition: Sn-95%, Sb-5%

- Made in USA
- RoHS Compliant
- Solidus 452°F, Liquidus 464°F

Well suited for applications where moderately elevated temperature is a factor.

Part No.	Size	Core Type	Weight
0862624	1/8"	Solid	1 lb

### 40/60 Solder

With some exceptions, these tin-lead solders can be used to join copper and most copper alloys, lead, nickel alloys and steel. Tin-lead solders are not recommended for joints subject to high stress or vibration in the cooling industry due to lack of sufficient elongation properties. These solders are also available with rosin or acid core.

It is illegal to use lead solders in both public and private potable water systems.

Chemical Composition: Sn-40%, PB-60%

- Solidus 360°F
- Liquidus 460°F

Not for use in Potable Water Systems

Part No.	Size	Core Type	Weight
0862638	1/8"	Solid	1 lb

### 50/50 Solder

Harris' 50/50 Solder Wire is a tin-lead solder that can be used to join copper and most copper alloys, lead, nickel alloys and steel. Tin-lead solders are not recommended for joints subject to high stress or vibration in the cooling industry due to lack of sufficient elongation properties. These solders are also available with rosin or acid core.

CAUTION: Lead-bearing solders are not to be used in potable water systems. It is illegal to use lead solders in both public and private potable water systems.

Chemical Composition: Sn-50%, PB-50%.

- Solidus 360°F
- Liquidus 420°F
- Made in the USA

Can be used to join copper and most copper alloys, lead, nickel alloys and steel.

Part No.	Size	Core Type	Weight
0862643	1/8"	Solid	1 lb

