



# HARRIS 34T

## Brazing Filler Metal

### TECHNICAL DATA SHEET

#### BRAZING PROPERTIES

Harris 34T brazing filler metal is often specified as an economical replacement for higher silver content braze alloys. Harris 34T has a wide melting range so it's useful in filling connections where tight clearance cannot be held. It is cadmium free and is an excellent replacement for many of the hazardous cadmium containing brazing products. Harris 34T is primarily used to braze copper, brass, bronze, and steel.

#### CHEMICAL COMPOSITION

Silver	34,0%
Copper	36,0%
Zinc	27,5%
Tin	2,5%
Other	ISO Requirements



#### MELTING TEMPERATURE

Solidus	630°C (1166°F)
Liquidus	730°C (1346°F)

#### CORROSION RESISTANCE

Generally similar to the copper base metal, but zinc containing alloys, including Harris 34T, should not be used if the braze is exposed to concentrated corrosive liquid for a long period of time.

#### AVAILABLE FORMS

Standard wire diameters in coil, rod, preform rings and shapes, layer wound spools, and flux coated.

#### RECOMMENDED FLUX

Harris ECO SMART® boric acid free brazing fluxes (green or black) are an excellent choice to promote sound brazed assemblies, and comply with European REACH requirements. Stay Silv brazing fluxes (white or black) are also recommended. All fluxes above are available in paste or powder form.

#### SPECIFICATION COMPLIANCE

ISO 17672 Ag 134 Si (No applicable AWS classification).



A LINCOLN ELECTRIC COMPANY

## **SAFETY INSTRUCTIONS**

**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.
- EN WARNING Use of this product may produce fumes containing hazardous compounds. Use local exhaust to keep fumes and gases from all breathing zones.

Use respirator unless exposure is below exposure limits. Infrared radiation from flame or hot metal can injure eyes. Overexposure to copper fumes may cause fever, chills, congestion and headaches. Consult SDS.

## **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 noninfringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.