



TECHNICAL INFORMATION SHEET

HARRIS O BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Copper	Remainder
Phosphorus	7.1
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1460°F (793°C)
Brazing Range	1345°F- 1500°F (730°C -816°C)
Electrical Conductivity	9.9 (%IACS)
Electrical Resistivity	19.2

BRAZING PROPERTIES:

Harris O is an economical alloy designed for brazing copper to copper connections. This alloy flows quickly at brazing temperature so requires close joint tolerance, less than 0.005". is a frequent choice for copper brazing.

Harris O is also a suitable choice for brazing brass. In this application operators should take care to avoid over heating the brass and use Harris Stay Silv® white brazing flux.

Harris O is not recommended for brazing steel or other ferrous base metals. The phosphorus content will form a low ductility intermetallic with the base metal

CORROSION RESISTANCE

Generally similar to the copper base metal, but zinc containing alloys, including Safety Silv 56, should not be used if the braze is exposed to concentrated corrosive liquid for a long period of time.

AVAILABLE FORMS

Standard wire diameters, preform rings, coils, strip in solid metal and also as Ag Clad.

RECOMMENDED FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass, use Stay-Silv® white flux.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCuP-2, ASME Section IIC SFA 5.8 BCuP-2, ISO 17672 CuP 181

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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