



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
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TECHNICAL SPECIFICATION SHEET

ISO 9001
Cert. No. 31598

HARRIS 0 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

| | |
|--------------|----------------|
| Phosphorus | 7.0-7.5 % |
| Copper | Remainder |
| Other Totals | 0.15 % Maximum |

PHYSICAL PROPERTIES:

| | | | |
|---------------------------|-------------------------|-------------------------|--------------|
| Solidus | 1310°F (710°C) | Specific Gravity | 8.76 |
| Liquidus | 1473-1476°F (800-802°C) | Electrical Conductivity | (IACS%) 9.91 |
| Brazing Temperature Range | 1300-1500°F (704-816°C) | Electrical Resistivity | 19.20 |

BRAZING PROPERTIES:

Designed primarily for copper to copper brazing application, Harris 0 is an economical alloy for use where joint clearances are close; less than 0.005". Harris 0 flows quickly, and may be used in brazing brass with the use of Stay-Silv® brazing flux. Harris 0 is not recommended for brazing steel or other ferrous metals.

AVAILABLE FORMS:

Standard wire diameters, preformed rings,

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8, Class BCuP-2, ASME SFA 5.8, Class BCuP-2
QQB 650C, Class BCuP-2

RECOMMENDED FLUX:

No flux required on copper Stay-Silv white or black brazing flux with brasses

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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