



THE HARRIS PRODUCTS GROUP

ALINCOLNELECTRIC COMPANY

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TECHNICAL SPECIFICATION SHEET

HARRIS L-Ag25Sn BRAZING FILLER METAL

STATEMENT OF LIABILITY- DISCLAIMER

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NOMINAL CHEMICAL COMPOSITION:	
Silver	25%
Zinc	33 %
Copper	40%
Tin	2%
Other Totals	0.15%

PHYSICAL PROPERTIES:

Meelting range	680°- 760 C
Working temperature	750°C
Density	Aprox. 8,7 g/cm3

BRAZING PROPERTIES:

Low melting silver based brazing alloy for joining steels, copper to copper and copper and nickel to nickel. This alloy has excellent flow properties. It can be used for flame or induction brazing procedures. Recommended joint clearance is 0.05MM – 0.13MM.

AVAILABLE FORMS:

Standard wire diameters, preformed rings, rods and foils.

SPECIFICATION COMPLIANCE:

EN 1044 AG 108

RECOMMENDED FLUX:

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.

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