



HARRIS PRODUCTS GROUP  
4501 QUALITY PLACE  
MASON, OHIO 45040  
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[www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

## TECHNICAL SPECIFICATION SHEET

### ALLOY PROPERTIES – **BLOCKADE®**:

**BLOCKADE®** is the first of a new family of silicon/tin alloyed brazing filler metals. **BLOCKADE®** is engineered to join copper, brass or bronze. **BLOCKADE®**'s innovative composition provides the following brazing features:

- The ability to form a large shoulder, or cap, at the braze connection.
- Excellent for the air-conditioning and refrigeration industry.
- A highly visible silver-gray cap, (fillet). This allows quick, accurate, and visual confirmation of a leak-free seal.
- Improved ductility over BCuP-2, (non-silver bearing), alloys.
- Significant reduction in brazing temperature over other BCuP braze alloys.

### 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 Sheet (MSDS) and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, 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, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

#### 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 non-infringement of the rights of others. Harris Products Group. and its affiliates shall have no liability in respect thereof.



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### NOMINAL CHEMICAL COMPOSITION:

Silicon	0.01 – 0.4%
Phosphorus	6.0 – 7.0%
Tin	6.0 – 7.0%
Copper	Balance
Others (total)	0.15 %

### PHYSICAL PROPERTIES:

Solidus	1178°F (637°C)
Liquidus	1247°F (674°C)
Braze Color	Silver-gray

### AVAILABLE FORMS:

Bare rod in standard wire diameters.  
Flux coated rod.

### SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8, Class BCuP-9

### RECOMMENDED FLUX:

No flux required on copper  
For brass or bronze, use Stay Silv® white or black brazing flux  
or flux-coated Blockade rod.

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