



**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**  
 4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

**TECHNICAL SPECIFICATION SHEET**

ISO 9002  
 Cert. No. 31598

**HARRIS STAY-SILV® 2 BRAZING FILLER METAL**

**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. The Harris Products Group and its affiliates shall have no liability in respect thereof.

**NOMINAL CHEMICAL COMPOSITION:**

Silver 1.8-2.2 %  
 Phosphorus 6.8-7.2 %  
 Copper Balance  
 Other Totals .15 %

**PHYSICAL PROPERTIES:**

Solidus	1190° (643°C)	Color	Bright Shiny Copper
Liquidus	1440°-1456°F (782-791°C)	Electrical Conductivity ( IACS %)	9.1
Brazing Temperature Range	1350°-1500°F (732-816°C)		

**BRAZING PROPERTIES:**

An economical alloy used in joining copper to copper. It can also be used to join copper to low zinc brasses with the aid of Stay-Silv® brazing flux. This alloy has good flow quality and produces strong leak-proof joints.

**AVAILABLE FORMS:**

Standard wire diameters, Preformed rings

**SPECIFICATION COMPLIANCE:**

ANSI/AWS A5.8, Class BCuP-6, ASME SFA 5.8, Class BCuP-6  
 QQB 650C, Class BCuP-6

**RECOMMENDED FLUX:**

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

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

4/99 DC



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.

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)

4/99 DC