



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® BLACK BRAZING FLUX

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.

MINIMAL COMPOSITION

Water	15-25%	Potassium Fluorides	10-20%
Potassium Borates	50-75%	Boron	1-3%
Boric Acid	1-3%		

Physical Properties:

Active Range 1050-1800°F (566-982°C)

BRAZING PROPERTIES:

Harris Stay-Silv black brazing flux is formulated for those brazing applications where the work is subjected to rapid, localized heating or where longer brazing times are encountered. It is particularly useful in applications where large amounts of refractory oxides may form, such as with stainless steel alloys. Suggested filler metals would include those of the BAg and BCuP classifications of AWS A5.8 specification. The black high-temp flux is an inorganic fluoride-type flux with small additions of boron. The active range is 1050°-1800°F. Flux residue may be removed with a hot water rinse. This material has a suggested shelf life of 1 year from the time of manufacture.

AVAILABLE FORMS:

¼ lb. jars , ½ lb. jars, 1 lb. jars, 30& 60 lb. Pails

SPECIFICATIONS:

AWS TYPE FB3C
AMS 3411-D
O-F-499 Type B

WARNING: CONTAINS FLUORIDES. PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. Burns eyes and skin on contact. CAN BE FATAL IF SWALLOWED

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheet (MSDSs), 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.
- Avoid contact of flux with eyes and skin.
- Do not take internally.
- Keep children away when using
- 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

First Aid: If contact in eyes, flush immediately with water for 15 minutes. If swallowed, induce vomiting. Never give anything by mouth to an unconscious person. Call a physician.

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

5/99 DC