



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 9002
 Cert. No. 31598

HARRIS STAY SILV® WHITE POWDER 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.

DESCRIPTION/DIRECTIONS:

A brazing flux in powder form designed for torch brazing aluminum. It is typically used to braze common aluminum base materials such as 1100, 3003, and 6061. It has a working temperature range of 915 to 1115 degrees F. It is recommended for use with aluminum brazing filler metals 4047 (718) and 4145. Flux can be sprinkled dry on the part or can be mixed with water or methyl, ethyl or isopropyl alcohol to form a paste.

NOMINAL COMPOSITION:

- Potassium Borates
- Boric Acid
- Copper Wetting Agent

Physical Properties:

Active Range 1050 -1600°F (566-871°C)

BRAZING]PROPERTIES:

Harris Stay Silv white powder brazing flux is an all-purpose flux for use in silver brazing most ferrous and non-ferrous metals except aluminum, magnesium, and titanium. Copper wetting agent has been added to enhance the wetting action. Recommended filler metals for use with Stay Silv white powder brazing flux includes those of BAg and BCuP classification of the AWS A5.8 specification. Mix approximately 20% water to form a paste or by dipping a heated rod into the powdered flux.

AVAILABLE FORMS:

250 Gram jars, ¼ lb. jars, 25 & 40 lb. Pails

SPECIFICATIONS:

Meets AWS A5.31 FB3-F

WARNING: CONTAINS CHLORIDES . 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.

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Additional information available at our web site: www.harrisproductsgroup.com

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