



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

DYNAFLOW[®] BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Silver	5.9-6.1%	Copper	Balance
Phosphorus	6.08%	Others (total)	0.15 % max

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Electrical Conductivity (%IACS)	8.80
Liquidus	1459-1471°F (787-794°C)	Electrical Resistivity	19.7
Color	Bright Shiny Copper	Tensile Strength-Brazed Copper tube	35,000 psi nominal, based on (242 mm ² -tube alloy C122 annealed.)
Brazing Temperature Range	1300-1500°F (704-816°C)		
Elongation in 2"	25%		

BRAZING PROPERTIES:

Designed for copper or brass applications, DynafLOW is self fluxing on copper but requires use of Stay-Silv[®] white or black brazing flux when joining brass.

DynafLOW mirrors the brazing characteristics of Stay-Silv 15. The melting range is wide enough to alloy filling gaps, necessary to braze loose connections or "cap" a finished joint. When heated to its liquidus temperature the filler metal flows quickly to fill tight gaps or standard connections.

AVAILABLE FORMS:

Standard wire diameters in 20" or 36" lengths, on layer wound spools, formed rings

SPECIFICATION COMPLIANCE:

Harris Products Group internal specification.

RECOMMENDED FLUX:

No flux required on copper

Stay Silv white or black brazing flux with brass

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

4/04 DC