



...better ways to join metals

®

# TECHNICAL SPECIFICATION SHEET

J.W. HARRIS CO., INC.  
10930 DEERFIELD ROAD  
CINCINNATI, OHIO 45242  
TEL. (513) 891-2000  
FAX (513) 891-2461  
www.jwharris.com

ISO 9002  
Cert. No. 31598

## HARRIS STAY SILV<sup>®</sup> 15 BRAZING FILLER METAL

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 (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.
- 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. J.W. Harris Co., Inc. and its affiliates shall have no liability in respect thereof.

### CHEMICAL COMPOSITION:

Silver	14.5 -15.5 %
Phosphorus	4.8 - 5.2 %
Copper	Remainder
Other Totals	.15 % maximum

### PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1475°F (802°C)
Brazing Temperature Range	1300-1500°F (704-816°C)
Color	Bright Shiny Copper
Specific Gravity	8.44
Electrical Conductivity	9.9
Electrical Resistivity	17.40
Tensile Strength – brazed copper tube (tube alloy C122 annealed)	35,000 PSI (nominal) (242 N/mm <sup>2</sup> )

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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.jwharris.com](http://www.jwharris.com)

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# HARRIS STAY SILV<sup>®</sup> 15 BRAZING FILLER METAL

### BRAZING PROPERTIES:

Designed primarily for copper to copper brazing application, Stay-Silv 15 may also be used in brazing brass with the use of Stay-Silv brazing flux.

### AVAILABLE FORMS:

Standard wire diameters, Preformed rings, Strip

### SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8, Class BCuP-5 , ASME SFA 5.8, Class BCuP-5  
QQB 650C, Class BCuP-5 , QQB 654A, Class BCuP-5  
QQB 654, Grade III

### RECOMMENDED FLUX:

No flux required on copper  
Stay Silv<sup>®</sup> white or black brazing flux with brass

J.W. Harris Co., Inc.      Fax      513-891-2461  
10930 Deerfield Road      Tel.      513-891-2000  
Cincinnati, Ohio 45242-4178      800-733-4533

Harris Welco      Fax      704-739-2801  
1051 York Road      Tel      704-739-6421  
Kings Mountain, NC 28086      800-438-6476