



BRAZING



PHOS COPPER



These brazing filler metals are primarily used to join copper to copper, copper to brass, and brass to brass. The phosphorus content serves as a "self-fluxing" agent in joining copper to copper. When brazing brass to copper or brass to brass, use Stay-Silv® White Brazing Flux. The phos/copper and silver/phos/copper filler metals are not recommended for brazing steel or nickel alloys. The amount of phosphorus in the phos/copper filler metals (AWS-BCuP series) is critical in determining precise melting range and performance. Proprietary computer based technology is used to accurately control the phosphorus content to exacting standards.

Each heat of metal is precisely checked before pouring to assure users a phosphorus content to within + or - 1/10 of a percent. Even more significant, a liquidus variation of no more than +or- 6°F. The advantages of this precise control is apparent in automated brazing operations, where even modest variations in flow temperatures can significantly increase the incidence of rejects. Equally important, manual operators no longer need to make adjustments in heating practice from one batch of filler metal to the next to achieve uniform results.

PART NO.	SIZE
D520R	3/32" DIA x 20" - 25# PKG
D536R	3/32" DIA x 36" - 25# PKG
D620F	.050" x 1/8" x 20" - 25# PKG
D620F1	.050" x 1/8" - 28 STICK TUBE
D636S	1/8" SQ x 36" - 25# PKG
D620FMPOP	.050" x 1/8" MINI PAK - 8 STICKS

DYNAFLOW®

HARRIS EXCLUSIVE

Dynaflow melts and flows at temperatures very close to Stay Silv 15, and provides comparable brazed mechanical properties. This makes Dynaflow an excellent cost effective alternative to the 15% silver alloys. This premium, medium range silver alloy has been meticulously formulated to even tighter specifications than our standard copper-to-copper alloys.



PN: D620FMPOP
.050 x 1/8" MINI PAK 8 STICKS

USA MADE IN

RoHS COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance
Silver-6% Phosphorus-6.1% Copper-87.9	1190° F 643° C	1465° F 796° C	3	.003" / .006"

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PART NO.	SIZE
BK220R	2MM DIA x 20" - 25# PKG
BK220R1	2MM DIA - 20 STICK TUBE
BK520R	3/32" DIA x 20" - 25# PKG
BK536R	3/32" DIA x 36" - 25# PKG
BK636R	1/8" DIA x 36" - 25# PKG
BKFC2500R1	2MM DIA x 500MM - 20 STICK TUBE

BLOCKADE®

HARRIS EXCLUSIVE

Blockade is a proprietary phosphorus-tin-silicon alloy engineered to provide a low cost alternative to silver bearing filler metals. It is self fluxing on copper and its lower melting temperature makes it an excellent choice for brass. Blockade flows rapidly but can be used to "cap" brazed joints.



PN: BK220R1
2MM Dia. - 20 STICKS

USA MADE IN

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-0% Phosphorus-6% Copper-94%	1178° F 637° C	1247° F 674° C	***	.002" / .005"	BCuP-9

*The higher the fluidity rating, the faster the alloy flows within the melting range.

***Blockade has good fluidity, yet it has the unique ability to form a cap at the joint.

PART NO.	SIZE
0320R	1/16" DIA x 20" - 25# PKG
0320R1	1/16" DIA - 51 STICK TUBE
0336R	1/16" DIA x 36" - 25# PKG
0520R	3/32" DIA x 20" - 25# PKG
0520R1	3/32" DIA - 24 STICK TUBE
0536R	3/32" DIA x 36" - 25# PKG
0536S	3/32" SQ x 36" - 25# PKG
0620F	.050" x 1/8" x 20" - 25# PKG
0620F1	.050" x 1/8" - 28 STICK TUBE
0620FMPOP	.050" x 1/8" MINI PAK - 8 STICKS
0620R	1/8" DIA X 20" - 25# PKG
0620R1	1/8" DIA - 14 STICK TUBE
0620S	1/8" SQ x 20" - 25# PKG
0620S1	1/8" SQ - 11 STICK TUBE
0636F	.050" x 1/8" x 36" - 25# PKG
0636R	1/8" DIA x 36" - 25# PKG
0636S	1/8" SQ x 36" - 25# PKG
0936RK	1/4" DIA x 36" - 25# PKG BLANK



PN: 0620FMPOP
.050 x 1/8" - 8 STICKS

HARRIS O

This low cost alloy is suitable for most copper-to-copper or brass joints where good fit-up exists, and the assemblies are not subject to excessive vibration nor movement.

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-0% Copper- 92.9 Phosphorus-7.1%	1310° F 710° C	1475° F 802° C	5	.002" / .007"	BCuP-2

*The higher the fluidity rating, the faster the alloy flows within the melting range.

USA MADE IN

RoHS COMPLIANT

BRAZING PRODUCTS



PHOS COPPER

STAY-SILV® 2

This economical, low silver alloy, is designed to broaden the melting range of Harris O, and has proven useful in some specific applications where mechanical properties are less critical.



PN: 2620F1
.050 x 1/8" - 28 STICKS

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COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-2% Phosphorus-7% Copper-91%	1190° F 643° C	1450° F 788° C	4	.003" / .005"	BCuP-6

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PART NO.	SIZE
2520R	3/32" DIA x 20" - 25# PKG
2536R	3/32" DIA x 36" - 25# PKG
2620F	.050" x 1/8" x 20" - 25# PKG
2620F1	.050" x 1/8" - 28 STICK TUBE
2620R	1/8" DIA x 20" - 25# PKG
2636F	.050" x 1/8" x 36" - 25# PKG
2636R	1/8" DIA x 36" - 25# PKG

STAY-SILV® 5

This medium-range alloy is well suited where close fit-up cannot be maintained. This filler metal is somewhat more ductile than Harris O or Stay-Silv 2.

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COMPLIANT



PN: 5620FMPOP
Stay-Silv 5
.050 x 1/8" MINI PAK - 8 STICKS

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-5% Phosphorus-6% Copper-89%	1190° F 643° C	1500° F 816° C	3	.003" / .006"	BCuP-3

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PART NO.	SIZE
5320R	1/16" DIA x 20" - 25# PKG
5320R1	1/16" DIA - 51 STICK TUBE
5336R	1/16" DIA x 36" - 25# PKG
5520R	3/32" DIA x 20" - 25# PKG
5520R1	3/32" DIA - 24 STICK TUBE
5536R	3/32" DIA x 36" - 25# PKG
5536S	3/32" SQ x 36" - 25# PKG
5620F	.050" x 1/8" x 20" - 25# PKG
5620F1	.050" x 1/8" - 28 STICK TUBE
5620F5	.050" x 1/8" x 20" - 5# TUBE
5620R	1/8" DIA x 20" - 25# PKG
5620R1	1/8" DIA - 14 STICK TUBE
5636F	.050" x 1/8" x 36" - 25# PKG
5636R	1/8" DIA x 36" - 25# PKG
5636S	1/8" SQ x 36" - 25# PKG
5620FMPOP	.050" x 1/8" - 8 STICKS

STAY-SILV® 6

This medium-range alloy is well suited where close fit-up cannot necessarily be maintained. This filler metal is somewhat more ductile than Phos Copper or Stay-Silv 2.



PN: 6620F1
.050 x 1/8" - 28 STICKS

PART NO.	SIZE
6536R	3/32" DIA x 36" - 25# PKG
6620F	.050" x 1/8 x 20" - 25# PKG
6620F1	.050" x 1/8 - 28 STICK TUBE
6636R	1/8" DIA x 36" - 25# PKG
6636S	1/8" SQ x 36" - 25# PKG
6836R	3/16" DIA x 36" - 25# PKG SPECIAL ORDER

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-6% Phosphorus-6.5% Copper-87.5%	1190° F 643° C	1425° F 774° C	5	.002" / .005"	

*The higher the fluidity rating, the faster the alloy flows within the melting range.

USA
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RoHS
COMPLIANT

STAY-SILV® 6HP

This is a higher phosphorus version of Stay-Silv 6. The increased phosphorus content lowers the liquidus temperature approximately 90° F. This provides a smooth flowing filler metal that is self fluxing on copper. The lower liquidus makes it an excellent choice for brass where lower temperatures are preferable.



PN: 6H336R
1/16" Dia. x 36" - 25# PKG

PART NO.	SIZE
6H336R	1/16" DIA x 36" - 25# PKG
6H536R	3/32" DIA x 36" - 25# PKG
6H636R	1/8" DIA x 36" - 25# PKG

USA
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RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-6% Phosphorus-7.2% Copper-86.8%	1190° F 643° C	1335° F 724° C	7	.001" / .004"	BCuP-4

*The higher the fluidity rating, the faster the alloy flows within the melting range.



STAY-SILV® 15

For many years the standard of the industry, the 15% silver alloy has proven its value. This filler metal is excellent for situations in which close fit-up does not exist, and where thermal expansion and service vibration are involved.



PN: 15636F
.050 x 1/8" x 36" - 25# PKG

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COMPLIANT**

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class**
Silver-15% Phosphorus-5% Copper-80%	1190° F 643° C	1480° F 804° C	3	.002" / .006"	BCuP-5
*The higher the fluidity rating, the faster the alloy flows within the melting range.					
** Stay-Silv 15 also meets Fed. Spec. QQ-B-654A, Grade III.					

PART NO.	SIZE
15320F	.050" x 1/16" x 20" - 25# PKG
15320F1	.050" x 1/16" x 20" - 51 STICK TUBE
15320R	1/16" DIA x 20" - 25# PKG
15320R1	1/16" DIA - 51 STICK TUBE
15336R	1/16" DIA x 36" - 25# PKG
15520R	3/32" DIA x 20" - 25# PKG
15520R1	3/32" DIA - 24 STICK TUBE
15520S	3/32" SQ x 20" - 25# PKG
15536R	3/32" DIA x 36" - 25# PKG
15536S	3/32" SQ x 36" - 25# PKG
15620F	.050" x 1/8" x 20" -25# PKG
15620F1	.050" x 1/8" - 28 STICK TUBE
15620F5	.050" x 1/8" x 20" - 5# TUBE
15620R1	1/8" DIA - 14 STICK TUBE
15620S	1/8" SQ x 20" - 25# PKG
15620S1	1/8" SQ - 11 STICK TUBE
15636F	.050" x 1/8" x 36" - 25# PKG
15636R	1/8" DIA x 36" - 25# PKG
15636S	1/8" SQ x 36" - 25# PKG
15636S10	1/8" SQ x 36" - 10# TUBE
1520FMPOP	.050" x 1/8" - 8 STICKS

RINGS & RETURN BENDS

A popular method of filler metal placement is by using brazing rings. Braze rings can be made in a variety of alloy compositions and are sized to fit your specific part. When heated, the brazing ring melts and flows into the capillary space to make a complete bond. Braze rings are often used with automated brazing equipment to ensure braze filler metal placement at the exact location. Since each size ring is designed for a specific part, there is no waste from excess filler metal applications. Rings can be located on the external surface, or "buried" inside and drawn out during heating. Our engineers can assist with ring size and application details. Our Autobraze ring division combines its unique control of chemistry with highly advanced manufacturing capabilities to fabricate precision brazing rings. This means brazing rings with exact dimensional tolerances and reliable flow characteristics.



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COMPLIANT**



HIGH SILVER

Harris silver brazing alloys are produced with precise wire size and chemical composition. Safety-Silv® brazing alloys are offered in coil, straight lengths, and bare or flux coated rods. To protect the health of operators the use of cadmium-bearing filler metals should be discontinued. Cadmium oxide fumes produced during brazing operations are highly toxic and a listed carcinogen. Harris offers no silver brazing alloys containing cadmium.

SAFETY-SILV® 25

A low cost, general purpose silver brazing alloy. Exhibits moderate ductility and slightly higher melting temperature than alloys containing higher percentages of silver and / or tin.

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COMPLIANT**

PART NO.	SIZE
25350	1/16" - 50 t.o. COIL
25550	3/32" - 50 t.o. COIL

Chemical Composition	Solidus	Liquidus	Fluidity Rating*
Silver-25% Copper-43% Zinc-30% Tin-2%	1270° F 688° C	1435° F 779° C	5
*The higher the fluidity rating, the faster the alloy flows within the melting range.			



PN: 25350
1/16" - 50 t.o. COIL



HIGH SILVER

SAFETY-SILV® 30

A moderate temperature filler metal with flow characteristics useful for wider gaps.

PN: 3031
1/16" - 1 t.o. PKG



PART NO.	SIZE
30250	3/64" - 50 t.o. COIL
3031	1/16" - 1 t.o. PKG SPECIAL ORDER
30318L	1/16" x 18" - 15 t.o. TUBE
30350	1/16" - 50 t.o. COIL
30650	1/8" - 50 t.o. COIL

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COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-30% Copper-38% Zinc-32%	1250° F 677° C	1410° F 766° C	6	BAg-20

*The higher the fluidity rating, the faster the alloy flows within the melting range.

SAFETY-SILV® 35

A good selection for replacing the cadmium alloys. Safety-Silv 35 joints are strong, ductile with brazing temperatures only slightly higher than cadmium-bearing 30 and 35 silver alloys.

PN: 3533
1/16" - 3 t.o. PKG



PART NO.	SIZE
3531	1/16" - 1 t.o. PKG
35318L	1/16" x 18" - 15 t.o. TUBE
35325	1/16" - 25 t.o. COIL
3533	1/16" - 3 t.o. PKG
3535	1/16" - 5 t.o. PKG
35350	1/16" - 50 t.o. COIL
3551	3/32" - 1 t.o. PKG
35518L	3/32" x 18" - 15 t.o. TUBE
35550	3/32" - 50 t.o. COIL
35618L	1/8" x 18" - 15 t.o. TUBE
35650	1/8" - 50 t.o. COIL

USA
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RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-35% Copper-32% Zinc-33%	1250° F 677° C	1350° F 732° C	5	BAg-35

*The higher the fluidity rating, the faster the alloy flows within the melting range.

SAFETY-SILV® 38T

This tin-bearing alloy combines excellent fillet-forming characteristics with good flow properties. The addition of a small amount of tin provides qualities normally associated with alloys containing greater quantities of silver.

PN: 38T350
1/16" - 50 t.o. COIL



PART NO.	SIZE
38T336L	1/16" x 36 - 50 t.o. TUBE
38T350	1/16" - 50 t.o. COIL
38T550	3/32" - 50 t.o. COIL

USA
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RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-38% Copper-32% Zinc-28% Tin-2%	1220° F 660° C	1325° F 718° C	7	BAg-34

*The higher the fluidity rating, the faster the alloy flows within the melting range.

SAFETY-SILV® 40

Ductile, free-flowing alloy that offers economy, good penetration into tight connections and medium temperature. Silver to light yellow color as in polished brass.

PN: 4033
1/16" - 3 TO PKG



PART NO.	SIZE
4031	1/16" - 1 t.o. PKG
4033	1/16" - 3 t.o. PKG
4035	1/16" - 5 t.o. PKG
40350H	1/16" - 50 t.o. COIL
40550H	3/32" - 50 t.o. COIL
40F3184	FC - 1/16" x 18" - 4 OZ TUBE

USA
MADE IN

RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*
Silver-40% Copper-30.5% Zinc-29.5%	1250° F 677° C	1350° F 732° C	5

*The higher the fluidity rating, the faster the alloy flows within the melting range.

SAFETY-SILV® 40T

Similar to 38T in its ability to form excellent fillets and maintain good mechanical properties.

PART NO.	SIZE
40T318L	1/16" x 18" - 15 t.o. TUBE
40T350	1/16" - 50 t.o. COIL
40T518L	3/32" x 18" - 15 t.o. TUBE
40T550	3/32" - 50 t.o. COIL

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PN: 40T350
1/16" - 50 t.o. COIL



SAFETY-SILV® 40NI2

For stainless steel, nickel alloy for corrosion resistance and strength, and a good choice for tungsten carbide tool tipping.

PART NO.	SIZE
40N250	3/64" - 50 t.o. COIL
40N318L	1/16" x 18" - 15 t.o. TUBE
40N325	1/16" - 25 t.o. COIL
40N350	1/16" - 50 t.o. COIL
40N518L	3/32" x 18" - 15 t.o. TUBE

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PN: 40N325
1/16" - 25 t.o. COIL



Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-40% Copper-30% Zinc-28% Nickel%-2	1220° F 660° C	1310° F 710° C	6.5	BAG-28

*The higher the fluidity rating, the faster the alloy flows within the melting range.

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-40% Copper-30% Zinc-28% Nickel%-2	1220° F 660° C	1435° F 779° C	4.5	BAG-4

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PART NO.	SIZE
4511	1/32" - 1 t.o. PKG
4513	1/32" - 3 t.o. PKG
4515	1/32" - 5 t.o. PKG
45150H	1/32" - 50 t.o. COIL
4521	3/64" - 1 t.o. PKG
4525	3/64" - 5 t.o. PKG
45250H	3/64" - 50 t.o. COIL
4531	1/16" - 1 t.o. PKG
45318L	1/16" x 18" - 15 t.o. TUBE
45318LMPOP	1/16" x 18" MINI PAK - 5 STICKS
45F318MPOP	1/16" x 18" FLUX CTD. MINI PAK - 3 STICKS
45325H	1/16" - 25 t.o. COIL
4533	1/16" - 3 t.o. PKG
45336L	1/16" x 36" - 50 t.o. TUBE
4535	1/16" - 5 t.o. PKG
45350H	1/16" - 50 t.o. COIL
4551	3/32" - 1 t.o. PKG
45518L	3/32" x 18" - 15 t.o. TUBE
45518LMPOP	3/32" x 18" MINI PAK - 3 STICKS
4553	3/32" - 3 t.o. PKG
45536L	3/32" x 36" - 50 t.o. TUBE
4555	3/32" - 5 t.o. PKG
45550H	3/32" - 50 t.o. COIL
45618L	1/8" x 18" - 15 t.o. TUBE
45650H	1/8" - 50 t.o. COIL
45F3184	1/16" x 18" - 4OZ 9 STICKS
45F318L	1/16" x 18" - (2) 1# BAG IN TUBE
45F5184	3/32" x 18" - 4 OZ TUBE
45F518L	3/32" x 18" - (2) 1# BAG IN TUBE
45F6184	1/8" x 18" - 4 OZ TUBE
45F618L	1/8" x 18" - (2) 1# BAG IN TUBE

SAFETY-SILV® 45

Excellent general purpose brazing alloy. Good ductility and capillary flow. Color is silver to light yellow.

**USA
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**RoHS
COMPLIANT**

**AVAILABLE IN KIT
WITH FLUX**



PN: 45F3184
Safety-Silv® 45 1/16" x 18"
FLUX COATED - 9 STICKS



SAFETY-SILV® 45 MINI PAK

General purpose filler for steel and copper alloys. Melting range useful for wide clearances.

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PN: 45318LMPOP
Safety-Silv® 45
1/16" x 18"
MINI PAK



PN: 45F318MPOP
Safety-Silv® 45 1/16" x 18"
FLUX COATED

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-45% Copper-30% Zinc-25%	1225° F 663° C	1370° F 743° C	6.5	BAG-5

*The higher the fluidity rating, the faster the alloy flows within the melting range.



HIGH SILVER

SAFETY-SILV® 45 BRAZING KIT

General purpose filler for steel and copper alloys. Melting range useful for wide clearances. Kit contains 1 oz. of braze wire and 1.75 oz. of Stay-Silv White Flux.

PART NO.	SIZE
45KPOP	1/16" BRAZING KIT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-45% Copper-30% Zinc-25%	1225° F 663° C	1370° F 743° C	6.5	BAG-5

*The higher the fluidity rating, the faster the alloy flows within the melting range.

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COMPLIANT



SAFETY-SILV® 45T



Performs like a 45% silver cadmium-bearing alloy but is cadmium-free. Lower melting temperature than Safety-Silv 45. Excellent fillet-forming qualities produces high-strength, ductile joints. NSF Certified to NSF 51.

USA
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RoHS
COMPLIANT

PART NO.	SIZE
45T225SP	3/64" - 25# SPOOL
45T31	1/16" - 1 t.o. PKG
45T318L	1/16" x 18" - 15 t.o. TUBE
45T33	1/16" - 3 t.o. PKG
45T35	1/16" - 5 t.o. PKG
45T350	1/16" - 50 t.o. COIL
45TF3184	1/16" x 18" - 4 OZ TUBE
45TF318L	1/16" x 18" - (2) 1# BAG IN TUBE

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-45% Copper-27% Zinc-25% Tin-3%	1195° F 646° C	1265° F 685° C	7	BAG-36

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PN: 45T31
Safety-Silv® 45T
1/16" - 1 t.o. PKG



SAFETY-SILV® 50

Useful in brazing electrical connections and as a cadmium-free replacement for 50% silver alloys. It has a wide melting range suitable for bridging gaps where poor fit-ups are encountered.

USA
MADE IN

RoHS
COMPLIANT

PART NO.	SIZE
5031	1/16" - 1 t.o. PKG
50318L	1/16" x 18" - 15 t.o. TUBE
5035	1/16" - 5 t.o. PKG
50350H	1/16" - 50 t.o. COIL
50550H	3/32" - 50 t.o. COIL
50650H	1/8" - 50 t.o. COIL

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-50% Copper-34% Zinc-16%	1270° F 688° C	1425° F 774° C	5.5	BAG-6

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PN: 5031
Safety-Silv® 50
1/16" - 1 t.o. PKG



SAFETY-SILV® 50N

This 50% silver alloy is a good replacement for the 3% nickel, cadmium alloy (AWS BAg3). It is especially helpful where low brazing temperature must be maintained. It can be used to braze tungsten carbide, stainless steel, as well as other steel, copper, and nickel alloys.



PN: 50N250
3/64" - 50 t.o. COIL

USA
MADE IN

RoHS
COMPLIANT

PART NO.	SIZE
50N150	1/32" - 50 t.o. COIL
50N250	3/64" - 50 t.o. COIL
50N318L	1/16" x 18" - 15 t.o. TUBE
50N325	1/16" - 25 t.o. COIL
50N325SP	1/16" - 25# SPOOL SPECIAL ORDER
50N336L	1/16" x 36" - 50 t.o. TUBE
50N35	1/16" - 5 t.o. PKG
50N350	1/16" - 50 t.o. COIL
50N518L	3/32" x 18" - 15 t.o. TUBE
50N536L	3/32" x 36" - 50 t.o. TUBE
50N550	3/32" - 50 t.o. COIL

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class
Silver-50% Copper-20% Zinc-28% Nickel-2%	1220° F 660° C	1305° F 707° C	7	BAG 24

*The higher the fluidity rating, the faster the alloy flows within the melting range.

BRAZING PRODUCTS



SAFETY-SILV® 56



High silver content alloy; makes premium-quality brazes. Free-flowing with unsurpassed capillary attraction and deep penetration with high ductility. Suitable for use in the food processing industry. Silver color is excellent match for stainless steel and silverware applications. NSF Listed.



PN: 5631
1/6" DIA. - 1 TO PKG

USA
MADE IN

RoHS
COMPLIANT

PART NO.	SIZE
5611	1/32" - 1 t.o. PKG
5615	1/32" - 5 t.o. PKG
56150	1/32" - 50 t.o. COIL
56225SP	3/64" - 25# SPOOL
5625	3/64" - 5 t.o. PKG
56250	3/64" - 50 t.o. COIL
5631	1/16" - 1 t.o. PKG
56318L	1/16" x 18" - 15 TO TUBE
56318LMPOP	1/16" x 18" MINI PAK - 5 STICKS
56F318MPOP	1/16" x 18" FLUX COATED MINI PAK - 3 STICKS
56325	1/16" - 25 t.o. COIL
5633	1/16" - 3 t.o. PKG
56336L	1/16" x 36" - 50 t.o. TUBE
5635	1/16" - 5 t.o. PKG
56350	1/16" - 50 t.o. COIL
56518L	3/32" x 18" - 15 t.o. TUBE
5653	3/32" - 3 t.o. PKG
5655	3/32" - 5 t.o. PKG
56550	3/32" - 50 t.o. COIL
56618L	1/8" x 18" - 15 t.o. TUBE
56650	1/8" - 50 t.o. COIL
56F3184	1/16" x 18" - 4 OZ TUBE
56F318L	1/16" x 18" - (2) 1# BAG IN TUBE
56F5184	3/32" x 18" - 4 OZ TUBE
56F518L	3/32" x 18" - (2) 1# BAG IN TUBE

SAFETY-SILV® 56 MINI PAK

For ferrous and nonferrous alloys. Often used to braze stainless steel for food service.



PN: 56318LMPOP
1/16" x 18" MINI PAK



PN: 56F318MPOP
1/16" x 18" MINI PAK
FLUX COATED

USA
MADE IN

RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class	NSF
Silver-56% Copper-22% Zinc-17% Sn-5%	1145° F 618° C	1205° F 652° C	8	BAg-7	51

*The higher the fluidity rating, the faster the alloy flows within the melting range.

SAFETY-SILV® 56 BRAZING KIT



Safety-Silv 56 in a convenient kit containing 1 oz. of braze wire and 1.75 oz. of Stay-Silv white flux.

PART NO.	SIZE
56KPPOP	BRAZING KIT WITH FLUX

USA
MADE IN

RoHS
COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	AWS A5.8 Class	NSF
Silver-56% Copper-22% Zinc-17% Sn-5%	1145° F 618° C	1205° F 652° C	8	BAg-7	51

*The higher the fluidity rating, the faster the alloy flows within the melting range.





ALUMINUM BRAZING

AL-BRAZE 1070

A superior brazing alloy for the joining of aluminum to aluminum. Al-Braze is free-flowing with unequalled capillary attraction, ductility and penetration. Not recommended for brazing Aluminum directly to non-Aluminum alloys as the joint may be brittle.

Procedure:

- Clean the braze area
- Remove all plating or anodized finish
- Heat the wire and dip into dry flux for extra coverage
- Mix powdered flux with water to form a paste
- Use a reducing flame
- Keep torch in constant motion
- Melt the alloy with the heat from the work piece not with the torch

Features:

- Tensile strength - Up to 35,000 PSI
- Solidus - 1070°F / 577°C
- Liquidus - 1080°F / 582°C
- Excellent corrosion resistance
- Specific gravity - 2.66

**USA
MADE IN**



Description	Chemical Composition	Solidus	Liquidus	Typical Application
Al-Braze 1070 Aluminum Brazing Kit	88% Al 12% Si	1070° F 577° C	1080° F 582° C	Superior brazing alloy for joining aluminum to aluminum. Excellent capillary attraction.

PART NO.	SIZE
1070K	ALBRAZE 1070 KIT

ALCOR

A very easy to use aluminum alloy with non-corrosive flux inside the wire; no external flux is required with this product. Designed for the repair of heat exchangers, air conditioners, aluminum alloy condensers and other applications. Very good fluidity with good capillary attraction. Post-braze cleaning unnecessary. Better than tin-zinc and aluminum silicon alloys for aluminum coil repair.

Procedure:

- Clean the surface of the aluminum to be joined
- Use a stainless steel brush
- Heat the surface evenly, apply ALCOR

Features:

- Tensile strength - Up to 35,000 psi
- Melts at 824°F / 440°C

**USA
MADE IN**



Description	Chemical Composition	Solidus	Liquidus	Typical Application
Alcor Flux-Cored Aluminum Alloy	Zn Al	824° F 440° C	824° F 440° C	A new approach to joining aluminum. A low temperature, free flowing, flux-cored solder for aluminum joining or repair.

PART NO.	SIZE
AL200RC	ALCOR-2MM DIA. - COIL

CORAL

Flux cored aluminum torch alloy which is able to produce either thin flowing of bead forming characteristics. Aluminum to aluminum; Not recommended for brazing aluminum directly to non-aluminum alloys.

CORAL is a tubular aluminum rod with an extremely active flux formulation inside the tube. The ratio of the flux to the filler material is precisely calibrated, assuring versatile performance. By adjustment of the temperature of the torch flame, it can be applied out-of-position with absolute control.

Procedure:

- Clean the braze area
- Remove all plating or anodized finish
- Leave a gap of 1/16" to 1/8"
- Bevel 60° to 70° for butt joints or cracks
- It is not necessary to melt the base metal
- Use a carburizing flame
- Keep the flame 1" to 3" from the surface
- Touch to the braze area under the flame until the filler metal flows
- Deposit small amounts of alloy & allow it to flow out on the braze area
- For build up work, reduce the heat play the flame on the filler rod above the workpiece
- Melt drops of the CORAL onto the workpiece and a stiff brush
- For greater flowability, use Al-Braze flux
- Remove the flux residue with warm water
- Crimp the end of the rod after use to seal in flux

Features:

- Tensile strength - Up to 30,000 PSI
- Solidus - 1055°F / 568°C
- Liquidus - 1155°F / 623°C
- Good color match (will darken if anodized)
- Good corrosion resistance
- Can be applied out-of-position



PART NO.	SIZE
CORAL60	CORAL 1/8" - 3# PKG