



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 0HHP® BRAZING FILLER METAL

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.

NOMINAL CHEMICAL COMPOSITION:

Phosphorus	7.51 %
Copper	Remainder
Other Totals	.15 % max

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1429 -1431°F (767-769°C)

Brazing Temperature Range	1300 -1500°F (704-816°C)
Specific Gravity	8.21

BRAZING PROPERTIES:

An economical brazing filler metal (very fluid medium temperature brazing alloy) for joining copper, brass, and bronze. The phosphorus addition makes the alloy "self-fluxing" on copper. When joining brass to brass, or to copper, a separate chemical flux, such as Stay-Silv® white must be used. This alloy can withstand moderate vibration. The recommended joint clearance is 0.005" or less.

AVAILABLE FORMS:

Standard wire diameters, Preformed rings

SPECIFICATION COMPLIANCE:

Harris Internal

RECOMMENDED FLUX:

No flux required on copper
Stay-Silv® white or black brazing flux with brasses

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.

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

02/09 MK