



TECHNICAL INFORMATION SHEET

SAFETY SILV® 54 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Silver	53.0 – 55.0
Copper	39.0 – 41.0
Zinc	4.0 – 6.0
Nickel	0.5-1.5
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1325°F (718°C)
Liquidus	1575°F (857°C)
Brazing Range	1575°F- 1775°F (860°C -970°C)
Electrical Conductivity	49.3 (%IACS)
Density	5.05 (t.o./cu.in.).

BRAZING PROPERTIES:

A cadmium-free braze alloy with a fairly long melting range. The reduced zinc content makes it suitable for furnace brazing applications, and it is often used to braze stainless steel. When oxy-fuel brazing with this filler metal it should be rapidly heated through its melting range to avoid liquation.

AVAILABLE FORMS

Standard wire diameters,

RECOMMENDED FLUX:

Stay-Silv® black brazing flux is typically chosen due to this filler metal's higher melting point. Harris ECO SMART® boric acid free flux, high temperature flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8 BAg-13, ASME SFA 5.8 BAg-13, AMS 4772

SAFETY INFORMATION:

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, Safety Data Sheets (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, 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, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

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