



TECHNICAL INFORMATION SHEET

SAFETY SILV® 25 BRAZING FILLER METAL

CHEMICAL COMPOSITION %:

| | |
|---------------|---------|
| Silver | 24-26 |
| Copper | 39-41 |
| Zinc | 31-35 |
| Tin | 1.5-2.5 |
| Other (Total) | 0.15 |

TYPICAL PHYSICAL PROPERTIES:

| | |
|-------------------------|-----------------------------|
| Solidus | 1265°F (685°C) |
| Liquidus | 1400°F (760°C) |
| Electrical Conductivity | 24.4 (%IACS) |
| Electrical Resistivity | 7.06 |
| Density | 4.71 (Troy ounces./cu.in.). |

BRAZING PROPERTIES:

An economical brazing alloy used to join copper, brass, and steel. Safety Silv 25 is a cadmium free alloy with good flow properties and excellent fillet forming qualities. It is often chosen as a cost reduction approach vs. lower melting, higher silver alloys.

AVAILABLE FORMS:

Standard wire diameters in preform rings, coils, & rod.

RECOMMENDED FLUX:

Stay-Silv® white flux is suitable for many applications. Stay-Silv® black brazing flux is often used if brazing stainless steel or where heating cycles are prolonged or focused as in induction brazing. Harris ECO SMART® boric acid free flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

AWS A5.8 BAg-37, ASME SFA 5.8 BAg-37, ISO 17672 Ag 125

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, Material Safety Data Sheets (MSDS), 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:

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.

THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY



4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

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