



## TECHNICAL INFORMATION SHEET

### HARRIS QUICKSILVER™ BRAZING FILLER METAL

#### NOMINAL CHEMICAL COMPOSITION%:

Phosphorus	7.20
Copper	Remainder
Other (Total)	0.15

#### TYPICAL PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1476°F- 1480°F (802-804°C)
Brazing Range	1350°F- 1500°F (704°C -816°C)
Electrical Conductivity	9.91 (%IACS)
Electrical Resistivity	19.20

#### BRAZING PROPERTIES:

Quicksilver is an economical brazing filler metal primarily used to braze copper to copper. It can also be used to braze copper to brass. Quicksilver, like other phosphorus bearing brazing filler metals, is not recommended for brazing steel or other ferrous base metals.

Quicksilver is self-fluxing on copper but requires use of appropriate flux when brazing brass. Quicksilver is fluid at brazing temperature with a recommended joint clearance below 0.005".

#### CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including Quicksilver, should not be used if the braze is exposed to sulfur or sulfur compounds in service.

#### AVAILABLE FORMS

Standard wire diameters, Preformed rings

#### RECOMMENDED FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass Stay-Silv® white flux is suitable for most applications. Harris ECO SMART® boric acid free flux, (powder or paste), is also an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

#### SPECIFICATION COMPLIANCE:

The Harris Products Group Engineering Standards

#### 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 Dorland 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](http://www.harrisproductsgroup.com)