



A LINCOLN ELECTRIC COMPANY

## TECHNICAL INFORMATION SHEET

### HARRIS SPEEDY® LEAD FREE SOLDER

#### NOMINAL CHEMICAL COMPOSITION%:

Cu 2.5 –3.5  
Sn Remainder

#### PHYSICAL PROPERTIES:

Solidus 450°F (232°C)  
Liquidus 550°F (290°F)

#### SOLDERING PROPERTIES:

Speedy has a faster melting range which allows operators to rapidly fill small, tight-fitting pipe connections. Speedy's low temperature and free flowing properties reduce cycle time and required heat input. Speedy is a lead-free solder primarily used for joining copper pipe in potable water systems. This tin-based alloy conforms to the 1986 Federal Safe Drinking Water Act Amendment.

#### AVAILABLE FORMS:

Standard diameters x spools

#### FLUX:

Bridgit® Past Flux  
Bridgit® Water Soluble Paste Flux  
Stay Clean® Paste Flux  
Stay Clean® Liquid Flux (suggested for steel)

Note: remove all flux residue after soldering

#### SPECIFICATION COMPLIANCE:

Harris Internal

#### 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.

**SOLDER FLUXES** may contain chlorides, acids, or other ingredients that are considered hazardous via inhalation, ingestion, or skin or eye contact.

- 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

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