



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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HARRIS AMERICAN BRAZING FILLER METAL (LOW FUMING BRONZE)

TECHNICAL SPECIFICATION SHEET

ISO 9001
 Cert. No. 31598

BRAZING PROPERTIES:

Designed for repair and fabrication on steel, copper, copper alloys nickel and nickel alloys.

RECOMMENDED PROCEDURE:

Clean all areas to be joined or built-up thoroughly. Paint weld area with Welco 600 bronze brazing flux. Using a neutral flame, heat the part until the flux liquefies. The flux can also be applied directly to the rod, by heating the rod and dipping into the powdered flux. Add a drop of the alloy and flow it out using the torch flame. If a large area is to be surfaced or a number of passes are required to restore the part to the original size, 15 or Nickel Silver flux coated rods should be used. There is no need to remove the flux between passes. The torch should be held at a low angle to prevent excessive heat build-up in the part.

NOMINAL CHEMICAL COMPOSITION:

Copper	60.0-60.5 %	Zinc	Balance
Tin	0.35-0.45 %	Manganese	0.10-0.15 %
Silicon	0.08-0.12 %		

PHYSICAL PROPERTIES:

Melting Point	1670° F (882° C)
Working Temperature	1600-1750° F(871-938° C)
Tensile Strength	60,000-65,000 psi
Brinell Hardness	80-90
Machinability	Excellent

AVAILABLE FORMS:

Standard wire diameters performed rings, Flux coated rods.

SPECIFICATION COMPLIANCE:

INTERNAL

RECOMMENDED FLUX:

Welco 600 Powder Flux

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.

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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