



TECHNICAL INFORMATION SHEET

HARRIS SAFETY SILV® 45T FLUX CORED BRAZING FILLER METAL

DESCRIPTION:

Safety Silv® 45T brazing filler metal is a flux cored version of the 45T solid wire. It is often specified in place of the popular Safety Silv 45, (AWS BAg-5), as the tin addition lowers the melting temperature to improve flow characteristics. This flux cored alloy contains an inner core of brazing flux which eliminates the cost and labor of a separate fluxing operation. It is cadmium free and is an excellent replacement for many of the hazardous cadmium containing brazing products. Safety Silv flux cored 45T is primarily used to braze copper, brass, bronze, and steel.

FLUX CORE:

This alloy contains a continuous internal core of brazing flux. No additional flux is typically required.

CHEMICAL COMPOSITION RANGE % (metal):

Silver	44.0-46.0
Tin	2.5-3.5
Copper	26.0-28.0
Zinc	23.0 – 27.0
Other elements	AWS/ISO requirements

MELTING TEMPERATURE:

Solidus 1195°F (646°C)
Liquidus 1265°F (685°C)

AVAILABLE FORMS:

Standard wire diameters in coil, rod, preform shapes, or wound on spools for automated feeding.

SPECIFICATION COMPLIANCE (metal component of cored wire):

AWS A5.8 BAg-34

RoHS (Reduction of Hazardous Substances):

Conforms to the EU hazardous substance directive.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health. FLUX CONTAINS FLUORIDES – avoid breathing fumes generated during brazing.

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