HARRIS QUICKSILVER™ BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

<table>
<thead>
<tr>
<th>Element</th>
<th>%</th>
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<tbody>
<tr>
<td>Phosphorus</td>
<td>7.20</td>
</tr>
<tr>
<td>Copper</td>
<td>Remainder</td>
</tr>
<tr>
<td>Other (Total)</td>
<td>0.15</td>
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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.

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