PHOS COPPER

These brazing filler metals are primarily used to join copper to copper, copper to brass, and brass to brass. The phosphorus content serves as a "self-fluxing" agent in joining copper to copper. When brazing brass to copper or brass to brass, use Stay-Silv® White Brazing Flux. The phos/copper and silver/phos/copper filler metals are not recommended for brazing steel or nickel alloys. The amount of phosphorus in the phos/copper filler metals (AWS-BCuP series) is critical in determining precise melting range and performance. Proprietary computer based technology is used to accurately control the phosphorus content to exacting standards.

Each heat of metal is precisely checked before pouring to assure users a phosphorus content to within + or - 1/10 of a percent. Even more significant, a liquidus variation of no more than +or- 6°F. The advantages of this precise control is apparent in automated brazing operations, where even modest variations in flow temperatures can significantly increase the incidence of rejects. Equally important, manual operators no longer need to make adjustments in heating practice from one batch of filler metal to the next to achieve uniform results.

PART NO.	SIZE
D520R	3/32" DIA x 20" - 25# PKG
D536R	3/32" DIA x 36" - 25# PKG
D620F	.050" x 1/8" x 20" - 25# PKG
D620F1	.050" x 1/8" - 28 STICK TUBE
D636S	1/8" SQ x 36" - 25# PKG
D620FMPOP	.050" x 1/8" MINI PAK - 8 STICKS

DYNAFLOW®

HARRIS EXCLUSIVE

Dynaflow melts and flows at temperatures very close to Stay Silv 15, and provides comparable brazed mechanical properties. This makes Dynaflow an excellent cost effective alternative to the 15% silver alloys. This premium, medium range silver alloy has been meticulously formulated to even tighter specifications than our standard copper-to-copper alloys.

PN: D620FMPOP
.050 x 1/8" MINI PAK 8 STICKS

USA MADE IN

RoHS COMPLIANT

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance
Silver-6% Phosphorus-6.1% Copper-87.9	1190° F 643° C	1465° F 796° C	3	.003" / .006"

*The higher the fluidity rating, the faster the alloy flows within the melting range.

PART NO.	SIZE
BK220R	2MM DIA x 20" - 25# PKG
BK220R1	2MM DIA - 20 STICK TUBE
BK520R	3/32" DIA x 20" - 25# PKG
BK536R	3/32" DIA x 36" - 25# PKG
BK636R	1/8" DIA x 36" - 25# PKG
BKFC2500R1	2MM DIA x 500MM - 20 STICK TUBE

BLOCKADE®

HARRIS EXCLUSIVE

Blockade is a proprietary phosphorus-tin-silicon alloy engineered to provide a low cost alternative to silver bearing filler metals. It is self fluxing on copper and its lower melting temperature makes it an excellent choice for brass. Blockade flows rapidly but can be used to "cap" brazed joints.

PN: BK220R1
2MM Dia. - 20 STICKS

USA MADE IN

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-0% Phosphorus-6% Copper-94%	1178° F 637° C	1247° F 674° C	***	.002" / .005"	BCuP-9

*The higher the fluidity rating, the faster the alloy flows within the melting range.

***Blockade has good fluidity, yet it has the unique ability to form a cap at the joint.

PART NO.	SIZE
0320R	1/16" DIA x 20" - 25# PKG
0320R1	1/16" DIA - 51 STICK TUBE
0336R	1/16" DIA x 36" - 25# PKG
0520R	3/32" DIA x 20" - 25# PKG
0520R1	3/32" DIA - 24 STICK TUBE
0536R	3/32" DIA x 36" - 25# PKG
0536S	3/32" SQ x 36" - 25# PKG
0620F	.050" x 1/8" x 20" - 25# PKG
0620F1	.050" x 1/8" - 28 STICK TUBE
0620FMPOP	.050" x 1/8" MINI PAK - 8 STICKS
0620R	1/8" DIA X 20" - 25# PKG
0620R1	1/8" DIA - 14 STICK TUBE
0620S	1/8" SQ x 20" - 25# PKG
0620S1	1/8" SQ - 11 STICK TUBE
0636F	.050" x 1/8" x 36" - 25# PKG
0636R	1/8" DIA x 36" - 25# PKG
0636S	1/8" SQ x 36" - 25# PKG
0936RK	1/4" DIA x 36" - 25# PKG BLANK

PN: 0620FMPOP
.050 x 1/8" - 8 STICKS

HARRIS 0

This low cost alloy is suitable for most copper-to-copper or brass joints where good fit-up exists, and the assemblies are not subject to excessive vibration nor movement.

Chemical Composition	Solidus	Liquidus	Fluidity Rating*	Recommended Joint Clearance	AWS A5.8 Class
Silver-0% Copper- 92.9 Phosphorus-7.1%	1310° F 710° C	1475° F 802° C	5	.002" / .007"	BCuP-2

*The higher the fluidity rating, the faster the alloy flows within the melting range.

USA MADE IN

RoHS COMPLIANT