



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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TECHNICAL SPECIFICATION SHEET

ISO 9001
Cert. No. 31598

STAY-SILV® 5 BRAZING FILLER METAL

Description

Stay-Silv® 5 brazing filler metal is a frequent choice for brazing copper. It has a wide melting range which allows the operator to fill loose connections. It can be used to braze brass with the use of Stay-Silv® white brazing flux. Stay-Silv® 5 is not recommended for brazing steel or other ferrous metals.

NOMINAL CHEMICAL COMPOSITION:

Silver	4.8-5.2 %
Phosphorus	5.8-6.2%
Copper	Balance
Other Totals	0.15 % maximum

PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Electrical Conductivity	9.6
Liquidus	1494 -1506°F (812-819°C)	Electrical Resistivity	18.1
Brazing Temperature Range	1320 - 1500°F (716 - 816°C)	Specific Gravity	8.14

Available forms

Standard wire and rod diameters and formed rings.

Specification Compliance

ANSI/AWS A5.8 Class BCuP-3, ASME SFA 5.8 Class BCuP-3, QQ-B-650C Class BCuP-3

Recommended Flux

No flux required for copper to copper connections. Stay-Silv® white brazing flux for brass or bronze.

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 flame, 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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