

FILLER METALS SELECTION CHART

PRODUCTS	QQ-B-654A	AMS	AWS A5.8	Ag	Cu	Zn	Ni	Sn	OTHER	SOLIDUS		LIQUIDUS		FLUIDITY RATING*	TYPICAL APPLICATION	
										°F	°C	°F	°C			
DYNAFLOW®				6	87.9					6.1P	1190	643	1465	796	3	Premium alloy for copper or brass. Excellent strength and ductility, use as replacement for 15.
BLOCKADE®			BCuP-9			REM		6.5		6.5P Si	1178	637	1247	674		For copper or brass. Lower brazing temperature, excellent replacement for many silver bearing BCuP alloys.
HARRIS 0			BCuP-2		92.9					7.1P	1310	710	1475	802	5	For copper. Requires medium fit-up, .002-.007" clearance.
STAY-SILV® 2			BCuP-6	2	91.0					7.0P	1190	643	1450	788	4	Broadens melting range of 0. For copper or brass. Clearance range .002-.005".
STAY-SILV® 5			BCuP-3	5	89.0					6.0P	1190	643	1500	816	3	For copper or brass. Used to bridge gaps where close fit-up can't be maintained.
STAY-SILV® 6				6	87.5					6.5P	1190	643	1425	774	5	For copper or brass. Medium range alloy for applications with clearances or .002-.005".
STAY-SILV® 15	BCuP-5		BCuP-5	15	80.0					5.0P	1190	643	1480	804	3	For copper or brass. Useful for wide clearance. .002-.006". Good ductility.
LOW FUMING BRONZE			RBCuZn-C		58	40		1	1 Fe		1590	866	1630	888		For steel and cast iron. Braze welding type alloy with flux coating.
SAFETY-SILV® 25				25	43	30		2			1270	688	1435	779	5	For steel to copper alloys. Moderate ductility. For dissimilar metals joint should be in compression on cooling.
SAFETY-SILV® 30	BAG-20		BAG-20	30	38	32					1250	677	1410	766	6	Use with ferrous and non-ferrous base metals. Flow suitable for bridging gaps.
SAFETY-SILV® 35			BAG-35	35	32	33					1250	677	1350	732	5	Ferrous and non-ferrous base metals. Moderate temperature and good ductility.
SAFETY-SILV® 38T			BAG-34	38	32	28		2			1220	660	1325	718	7	Low-temperature, free-flowing alloy with exceptional fillet-forming quality. For ferrous and non-ferrous metals.
SAFETY-SILV® 40				40	30.5	29.5					1250	660	1350	732	5	For steel, nickel, and copper alloys. Suitable for wider clearance yet provides good ductility.
SAFETY-SILV® 40T			BAG-28	40	30	28		2			1220	660	1310	710	6.5	Good flow properties. Suitable for ferrous and non-ferrous base metals.
SAFETY-SILV® 45	BAG-5		BAG-5	45	30	25					1225	663	1370	743	6.5	General purpose filler for steel and copper alloys. Melting range useful for wide clearances.
SAFETY-SILV® 45T			BAG-36	45	27	25		3			1195	646	1265	685	7	Good flow properties. Suitable for ferrous and non-ferrous base metals.
SAFETY-SILV® 50			BAG-6	50	34	16					1270	688	1425	774	5.5	Often used to braze galvanized steel but suitable for bridging gaps in other ferrous and non-ferrous metals.
SAFETY-SILV® 50N		4788	BAG-24	50	20	28		2			1220	660	1305	707	7	For stainless steel applications to prevent crevice corrosion.
SAFETY-SILV® 56	BAG-7	4763	BAG-7	56	22	17		5			1145	618	1205	652	8	For ferrous and non-ferrous alloys. Often used to braze stainless steel for food service. NSF 51 listed.
AL-BRAZE™ 1070			BAISI4								1070	577	1080	582		For brazing aluminum base metals.
AL-BRAZE™ 4043											1065	574	1170	632		Aluminum repair, brazing of splits/holes. Wider melting range than Al-Braze™ 1070.
ALCOR®											824	440	824	440		For the repair of heat exchangers, air conditioners, aluminum alloy condensers and other applications.
ALSOLDER™ 500						15		85			391	199	482	250		A low temperature solder for aluminum and copper.
NICK®											438	225	729	387		Fit small tight fitting connections and to bridge gaps in large, loose fitting, or non-concentric pipe.
SPEEDY®											450	232	555	290		Faster melting range. Allows operator to fit small, tight fitting pipe connections quickly.
STAY-BRITE®				4				96			430	221	430	221	10	Low-temperature solder for all metals except aluminum. Used in refrigeration joints. NSF 51 listed.
STAY-BRITE® 8				6				94			430	221	535	279	8	Similar to Stay-Brite®. Plastic range useful in bridging wider gaps. Certified to NSF 51 listed.
BRIDGIT®											460	238	630	332	6	Lead-free, nickel & silver-bearing solder of exceptional strength & capping ability. NSF 61 listed.

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

WARNING Protect yourself and others. Read and understand this information. BRAZING AND SOLDERING ALLOYS AND FLUXES MAY PRODUCE FUMES AND GASES HAZARDOUS TO YOUR HEALTH. • 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 the fumes. • Use enough ventilation, exhaust at the flame or both, to keep fumes and gases from your breathing zone and the general area. • For maximum safety, be certified for and wear a respirator at all times when welding or brazing. • 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, 500 N.W. LeJeune Road, Miami Florida 33126; OSHA Safety and Health Standards, 29 CFR 1910, Available from the U.S. Government printing office, Washington, D.C. 20402. • MSDS are available for all Harris products. MSDS contain detailed safety and health information about possible hazards associated with use of these products. MSDS are available from your employer or by contacting the Harris Products Group, Mason, OH 45040.