



TECHNICAL INFORMATION SHEET

STAY SILV® 2 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Silver	1.8-2.2 %
Copper	Remainder
Phosphorus	6.9-7.1%
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1450°F (788°C)
Brazing Range	1300°F- 1500°F (704°C -816°C)
Density	0.290 (lbs./cu.in.)
Electrical conductivity	5.50 (% IACS)

BRAZING PROPERTIES:

Stay Silv 2 brazing filler metal is a medium temperature range alloy for brazing copper, and copper to brass. The addition of silver provides an 1190°F solidus which widens the melting range compared to Harris 0. Stay Silv 2 is useful for applications with clearances of 0.002" – 0.005" (0.05 mm - 0.13 mm).

CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv 2, should not be used if the braze is exposed to sulfur or sulfur compounds in service

AVAILABLE FORMS

Standard wire diameters rods, spools, and preform rings,

RECOMMENDED FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass, use Stay-Silv® white flux. Harris ECO SMART® boric acid free flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCuP-6, ASME Section II C SFA 5.8 BCuP-6,
ISO 17672 CuP 280

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, 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.

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