



THE HARRIS PRODUCTS GROUP
A LINCOLN ELECTRIC COMPANY
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TECHNICAL SPECIFICATION SHEET

Harris L-Ag30Sn BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Ag %	Cu %	Zn %	Sn %
30,0	36,0	32,0	2,0

PHYSICAL AND MECHANICAL PROPERTIES:

Tensile strength (N/mm ²)	Specific Weight (gr/cm ³)	Working Temperature (°C)	Melting range (°C)	Joint clearance (MM)
480	8,8	750	665 – 755	0,05 – 0,13

BRAZING PROPERTIES:

L-Ag30Sn filler metal is a medium range alloy. The wetting and flow characteristics are appropriate to make medium / large responsibility joints. The melted filler metal has a flat surface, giving to the operator a security perception. L-Ag30Sn melting range offers a large window that allows to the operator fill in large gaps. Colour Silver - Yellow.

AVAILABLE FORMS:

Standard wire diameters (rods, coils and spools), preformed on different length and sizes.

SPECIFICATION COMPLIANCE:

ISO 17672	Ag- 130
DIN EN1044	Ag- 107
DIN8513	L-Ag30Sn
AWS A5.8	-
NFA 81-362	-
BS 1845	Ag- 21

RECOMMENDED FLUX:

Always is necessary use Stay Silv White / Eco smart Flux Green (without overheating) or Stay Silv Black Flux / Eco smart Flux High Heat.

APPLICATIONS:

L-Ag30Sn is mainly used on the HVAC industry on ferrous / copper – ferrous based pipe - fitting connections.

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

- Before use, read and understand the material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.

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