THE HARRIS PRODUCTS GROUP
A LINCOLN ELECTRIC COMPANY
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TECHNICAL SPECIFICATION SHEET

HARRIS 15 BRAZING FILLER METAL (LOW FUMING BRONZE)

ISO 9001
Cert. No. 31598

CHEMICAL COMPOSITION RANGE (%)

Copper	56-60	Zinc	Balance
Tin	0.80-1.10	Manganese	0.01-0.50 max.
Iron	0.25-1.20 max	Silicon	0.30 max.

PHYSICAL PROPERTIES:

Melting Point	1680° F (882° C)
Working Temperature	1600-1720° F(871-938° C)
Tensile Strength	60,000-65,000 psi
Brinell Hardness	80-90
Machinability	Excellent

BRAZING PROPERTIES:

Designed for repair and fabrication applications on steel, copper, copper alloys nickel and nickel alloys

RECOMMENDED PROCEDURE:

Clean all areas to be joined or built-up thoroughly apply the Harris 600 bronze brazing flux then using a neutral flame, heat the part until the flux liquefies. The flux can also be applied directly to the rod, by heating the rod and dipping the rod into the powder flux. Add a drop of the alloy and flow it out using the torch flame. There is no need to remove the flux between passes. The torch should be held at a low angle to prevent excessive heat build-up in the part. When working on cast iron, bonding qualities can be improved by first searing the surface with a strong oxidizing flame.

AVAILABLE FORMS:

Standard wire diameters, performed rings, Flux coated rods.

SPECIFICATIONS COMPLIANCE:

AWS A5.8 RBCuZn-C

RECOMMENEDED FLUX:

Harris 600

STATEMENT OF LIABILITY- DISCLAIMER

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 arc, 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.