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TECHNICAL SPECIFICATION SHEET

Harris L-Ag34Sn BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Ag %	Cu %	Zn %	Sn %	Others %
33,0 – 35,0	35,0 – 37,0	25,5 – 29,5	2,0 – 3,0	0,15

PHYSICAL AND MECHANICAL PROPERTIES:

Tensile strength (N/mm ²)	Specific Weight (gr/cm ³)	Working Temperature (°C)	Melting range (°C)	Joint clearance (MM)
480	9	710	630 – 730	0,05 – 0,13

BRAZING PROPERTIES:

L-Ag34Sn filler metals are a frequent choice on the HVAC/R industry. This combines a low temperature melting range with a medium working window. It allows to the operator to fill in small and large gaps without overheating. Wetting and flow characteristics are appropriate to make responsibility joints on dissimilar metals. The melted filler metal has a flat surface, giving to the operator a security perception. Colour Silver - Yellow.

AVAILABLE FORMS:

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

SPECIFICATION COMPLIANCE:

ISO 17672	Ag- 134
DIN EN1044	Ag- 106
DIN8513	L-Ag34Sn
AWS A5.8	-
NFA 81-362	-
BS 1845	-

RECOMMENDED FLUX:

Always is necessary use Stay Silv White (without overheating) or Stay Silv Black Flux.

APPLICATIONS:

L-Ag34Sn is mainly used on the HVAC industry on ferrous / copper – ferrous based pipe - fitting connections. This is the frequent choice because combines a low silver amount with good mechanical and flow characteristics.

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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