



TECHNICAL INFORMATION SHEET

STAY SILV® WHITE BRAZING FLUX

DESCRIPTION:

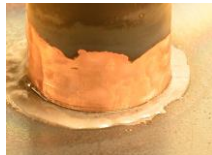
Stay Silv white paste flux is a homogenous brazing flux ideally suited for use with a variety of base metals. A mixture of boric acid and fluoride compounds, it is formulated to provide smooth flux application, even coverage, and excellent protection during braze heating cycles.

Stay Silv white flux is recommended for brazing copper and copper alloys, (except aluminum bronze), steel, stainless steel, nickel alloys and other ferrous base metals. It is used with many high silver brazing filler metals of the AWS A5.8 BAg classifications and ISO 17672 class Ag alloys.

It is also suitable for use with many phosphorus-copper-silver alloys, (AWS BCuP and ISO CuP), for brazing copper to brass.

Flux may be water thinned but care should be taken to avoid excess dilution.

Flux turns clear, (transparent), close to brazing application temperature. This is a useful indicator you are ready to apply braze wire or rod.



Flux condition near brazing temperature

ACTIVITY RANGE:

1050 – 1600°F (565 - 870°C)

FLUX REMOVAL:

Post braze flux residue should be removed to avoid potential corrosion. A hot water wash and brushing with a rag or non-woven abrasive pad, (e.g. Scotch-Brite™), is often sufficient. Additional measures include mechanical cleaning with a wire brush, steam jet, or abrasive blasting media such as grit, soda, or dry ice.

Production post-braze cleaning can also be accomplished with proprietary chemical formulas such as Bernite® 45 available from Harris Products Group. This approach is suitable where parts lend themselves to a water bath/tank immersion.

AVAILABLE CONTAINERS:

6.5 oz bottle with brush cap, ¼ lb. jars, ½ lb. jars, 1 lb. jars, 5 lb. jars, 25 lb. pail, 60 lb. pail.

SPECIFICATION COMPLIANCE:

AWS A5.31 Classification FB3 A
AMS 3410
Federal Specification O-F-499, Type B
EN 1045 Type FH10

SAFETY INFORMATION:

WARNING: CONTAINS FLUORIDES.
PROTECT YOURSELF AND OTHERS. Read and understand this information.

BURNS EYS AND SKIN. CAN BE FATAL IF SWALLOWED.

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.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

Additional information available at our web site: www.harrisproductsgroup.com