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TECHNICAL SPECIFICATION SHEET

Harris L-Ag25 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Ag %	Cu %	Zn %	Si %	Others %
24,0 – 26,0	39,0 – 41,0	33,0 – 37,0	0,05 – 0,25	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)
430	8,8	780	700 – 790	0,05 – 0,13

BRAZING PROPERTIES:

L-Ag25 filler metal is an economical alloy with large melting range. The wetting and flow characteristics make L-Ag25 an appropriate choice to join similar and dissimilar base metals (excluding aluminium) on a medium responsibility structural applications. It can be used on flame, induction and furnace procedures. Colour Brass - Yellow.

AVAILABLE FORMS:

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

SPECIFICATION COMPLIANCE:

ISO 17672	Ag- 225
DIN EN1044	Ag- 205
DIN8513	L-Ag25
AWS A5.8	-
NFA 81-362	25A1
BS 1845	-

RECOMMENDED FLUX:

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

APPLICATIONS:

L-Ag25 is mainly used on the HVAC industry on dissimilar base metals low responsibility structural joints and on ferrous 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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