



**THE HARRIS PRODUCTS GROUP**  
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**TECHNICAL SPECIFICATION SHEET**

**Harris L-Ag60 BRAZING FILLER METAL**

**NOMINAL CHEMICAL COMPOSITION:**

Ag %	Cu %	Zn %	Si %	Others %
59,0 – 61,0	25,0 – 27,0	12,0 – 16,0	0,05 – 0,25	0,15

**PHYSICAL AND MECHANICAL PROPERTIES:**

Tensile strength (N/mm <sup>2</sup> )	Specific Weight (gr/cm <sup>3</sup> )	Working Temperature (°C)	Melting range (°C)	Joint clearance (MM)
450	9,5	720	695 – 730	0,05 – 0,15

**BRAZING PROPERTIES:**

L-AG60 filler metals are highly appropriate on stainless steel and steels with large % of alloying elements applications. These filler metals provide excellent mechanical, physics and chemical characteristics, becoming a good solution on high responsibility joints on corrosive environments. The large (solidus – liquidus) window allow to the operators control the melting process, being recommended on vacuum, furnace or automatic brazing processes. Colour Silver.

**AVAILABLE FORMS:**

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

**SPECIFICATION COMPLIANCE:**

ISO 17672	-
DIN EN1044	Ag- 202
DIN8513	L-Ag60
AWS A5.8	-
NFA 81-362	-
BS 1845	-

**RECOMMENDED FLUX:**

Use Stay Silv White or Stay Silv Black Flux. Flux is not necessary on vacuum applications.

**APPLICATIONS:**

L-AG60 is mainly used on vacuum or protective atmosphere applications

**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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