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TECHNICAL SPECIFICATION SHEET

Harris L-Ag12 BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION:

Ag %	Cu %	Zn %	Si %	Others %
11,0 – 13,0	47,0 – 49,0	38,0 – 42,0	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)
410	8,5	830	800 – 830	0,05 – 0,13

BRAZING PROPERTIES:

L-Ag12 filler metal is an economical alloy with not large melting range. The wetting and flow characteristics make L-Ag12 an appropriate choice to join brass and iron / stainless steel connections. Colour Brass.

AVAILABLE FORMS:

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

SPECIFICATION COMPLIANCE:

ISO 17672	Ag- 212
DIN EN1044	Ag- 207
DIN8513	L-Ag12
AWS A5.8	-
NFA 81-362	-
BS 1845	-

RECOMMENDED FLUX:

Always is necessary use 600 bronze brazing flux, Stay Silv white (without overheating) or Stay Silv Black flux.

APPLICATIONS:

L-Ag12 is especially used on copper / stainless steel boilers (Heat industry).

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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