



TECHNICAL INFORMATION SHEET

OHP BRAZING FILLER METAL

CHEMICAL COMPOSITION %:

Phosphorus	7.0-7.4
Copper	Remainder
Others, (total)	0.15 maximum

PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1450°F (788°C)
Specific Gravity	8.21

BRAZING PROPERTIES:

An economical brazing filler metal (very fluid medium temperature brazing alloy) for joining copper, brass, and bronze. Will withstand moderate vibration. Recommended joint clearance is .002"-.005". Stay Silv OHP, (and other phosphorus containing filler metals), should not be used to braze ferrous or nickel alloy base metals.

FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass use Stay-Silv® white flux. Harris ECO SMART® boric acid free flux, (powder or paste), is an excellent choice to promote sound brazed assemblies and comply with European REACH requirements

CORROSION RESISTANCE:

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv OHP, should not be used if the braze is exposed to sulfur or sulfur compounds in service

AVAILABLE FORMS:

Standard wire diameters, coils, rods and preform rings.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCuP-2, ASME SFA5.8 BCuP-2

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

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, Safety Data Sheets (SDS), 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 correctly 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.

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