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**TECHNICAL SPECIFICATION SHEET**

**Harris L-Ag20 BRAZING FILLER METAL**

**NOMINAL CHEMICAL COMPOSITION:**

Ag %	Cu %	Zn %	Si %	Others %
19,0 – 21,0	43,0 – 45,0	34,0 – 38,5	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)
430	8,7	810	690 – 810	0,05 – 0,13

**BRAZING PROPERTIES:**

L-Ag20 filler metal is an economical alloy with large melting range. The wetting and flow characteristics make L-Ag20 an appropriate choice to join similar and dissimilar base metals (excluding aluminium) on a medium responsibility structural applications. 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	-
DIN EN1044	Ag- 206
DIN8513	L-Ag20
AWS A5.8	-
NFA 81-362	20A1
BS 1845	-

**RECOMMENDED FLUX:**

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

**APPLICATIONS:**

L-Ag20 is especially used on the HVAC industry on dissimilar base metals low responsibility structural joints and on 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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