



**THE HARRIS PRODUCTS GROUP**  
A LINCOLN ELECTRIC COMPANY  
4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015  
C/Arq Ricard Giralt s/n • Figueres, E-17600 SPAIN  
Tel: +34-972-678-826 Fax: +34 972 505 143  
**TECHNICAL SPECIFICATION SHEET**

**Harris L-Ag44 BRAZING FILLER METAL**

**NOMINAL CHEMICAL COMPOSITION:**

Ag %	Cu %	Zn %	Others %
43,0 – 45,0	29,0 – 31,0	24,0 – 28,0	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)
550	9,1	740	675 – 735	0,05 – 0,15

**BRAZING PROPERTIES:**

L-AG44 filler metals are suitable in dissimilar base materials. These are mainly used where high mechanical characteristics are required. L-Ag44 filler metals are able to fill in medium sized gaps. The melted filler metal has a flat surface, giving to the operator a security perception Colour Silver.

**AVAILABLE FORMS:**

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

**SPECIFICATION COMPLIANCE:**

ISO 17672	Ag- 244
DIN EN1044	Ag- 203
DIN8513	L-Ag44
AWS A5.8	-
NFA 81-362	44 A1
BS 1845	-

**RECOMMENDED FLUX:**

Always is necessary use Stay Silv White (without overheating) or Stay Silv Black Flux on non protective atmospheres.

**APPLICATIONS:**

L-Ag44 is used on applications where high mechanical strength is required. These are recommended by manual / automatic / induction and furnace brazing 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.

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied. Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com) ISO 9001.