



TECHNICAL INFORMATION SHEET

STAY SILV® 15 BRAZING FILLER METAL

CHEMICAL COMPOSITION%:

Silver	14.5 - 15.5
Phosphorus	4.8 - 5.2
Copper	Remainder
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)
Liquidus	1475°F (802°C)
Density	0.305 (lb/cu.in)
Electrical conductivity	9.9 (% IACS)
Electrical resistivity	17.4 (microhm/cm)

BRAZING PROPERTIES:

Stay Silv 15 is a frequent choice for copper brazing. It has a wide melting range that allows operators to fill loose connections and “cap”, or build up, around the finished joint. When heated above its liquidus, however, it will penetrate tight connections.

Stay Silv 15 is also a suitable choice to braze brass. In these applications operators should take care to avoid over heating the brass, and use Stay Silv white brazing flux.

Stay Silv 15 has historically been a popular brazing filler metal for HVAC and refrigeration connections. Its low phosphorus content provides brazed assemblies with good strength and ductility. Users should also consider Harris Dynaflo® as a lower cost option.

Stay Silv 15 is not recommended for brazing steel or other ferrous base metals. The phosphorus content promotes formation of a low ductility intermetallic with the ferrous base metal. It is sometimes used to braze selected low nickel content copper-nickel base metals, (90/10), but service suitability should be first established.

CORROSION RESISTANCE:

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv 15 should not be used if the braze is exposed to sulfur or sulfur compounds in service.

AVAILABLE FORMS:

Standard wire diameters in coils, rods, spools, and rings, strip, and shims.

RECOMMENDED FLUX:

No flux is required for copper brazing. For brazing brass or copper to brass use Stay-Silv® white flux.

SPECIFICATION COMPLIANCE:

AWS A5.8 BCuP-5, ASME Section IIC SFA 5.8 BCuP-5, QQ-B-654A BCuP-5, ISO17672 CuP 284

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, Material Safety Data Sheets (MSDS), 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 correct 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.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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