



**T H E H A R R I S P R O D U C T S G R O U P**  
**A L I N C O L N E L E C T R I C C O M P A N Y**  
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## TECHNICAL DATA SHEET

### DYNAFLOW® BRAZING FILLER METAL

#### NOMINAL CHEMICAL COMPOSITION:

Silver	6.0 %	Copper	Balance
Phosphorus	6.1 %	Others (total)	0.15 % max

#### PHYSICAL PROPERTIES:

Solidus	1190°F (643°C)	Electrical Conductivity (%IACS)	8.80
Liquidus	1459-1471°F (787-794°C)	Electrical Resistivity	19.7
Brazing Temperature Range	1300-1500°F (704-816°C)	Tensile Strength-Brazed Copper tube	35,000 psi nominal, based on (242 mm <sup>2</sup> -tube alloy C122 annealed.)
		Elongation in 2"	25%

#### BRAZING PROPERTIES:

Designed for copper or brass applications, Dynaflo is self fluxing on copper but requires use of Stay-Silv® white or black brazing flux when joining brass. Dynaflo mirrors the brazing characteristics of Stay-Silv 15. The melting range is wide enough to alloy filling gaps, necessary to braze loose connections or "cap" a finished joint. When heated to its liquidus temperature the filler metal flows quickly to fill tight gaps or standard connections.

#### AVAILABLE FORMS:

Standard wire diameters in 20" or 36" lengths, on layer wound spools, formed rings

#### SPECIFICATION COMPLIANCE:

Harris Products Group internal specification.

#### RECOMMENDED FLUX:

No flux required on copper  
 Stay Silv white or black brazing flux with brass

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

**FUMES AND GASES can be hazardous to your health.**

**ARC RAYS can injure eyes and burn skin.**

**ELECTRIC SHOCK can KILL.**

- 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 arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)