



TECHNICAL INFORMATION SHEET

HARRIS 0HHP BRAZING FILLER METAL

NOMINAL CHEMICAL COMPOSITION%:

Copper	Remainder
Phosphorus	7.50
Other (Total)	0.15

TYPICAL PHYSICAL PROPERTIES:

Solidus	1310°F (710°C)
Liquidus	1431°F (769°C)
Electrical Conductivity	9.9 (%IACS)
Electrical Resistivity	19.2

BRAZING PROPERTIES:

Harris 0HHP is a higher phosphorus content version of Harris 0 and 0HP. This alloy offers one of the lowest melting temperatures for a copper phosphorus brazing alloys. This low temperature coupled with its narrow melting range is ideally suited for copper connections with controlled narrow clearance, preferably close to 0.003". It is sometimes used for manual brazing but is more frequently supplied in ring form for automated brazing of copper return bends in HVACR evaporator and condenser coils. Harris 0HHP is also a suitable choice for brazing brass. In this application operators should take care to avoid over heating the brass and use Harris Stay Silv® white or ECO Smart® brazing flux. Harris 0HHP is not recommended for brazing steel or other ferrous base metals. The phosphorus content will form a low ductility intermetallic with the base metal.

CORROSION RESISTANCE

Generally similar to the copper base metal, but phosphorus containing alloys, including Stay Silv 0HHP, should not be used if the braze is exposed to sulfur or sulfur compounds in service

AVAILABLE FORMS

Standard wire diameters, rods and preformed rings

RECOMMENDED 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

SPECIFICATION COMPLIANCE:

Harris internal specification

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.

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