



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 SPECIFICATION SHEET

ISO 9002
Cert. No. 31598

HARRIS SPEEDY® LEAD FREE SOLDER

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.

NOMINAL SOLDER COMPOSITION:

Copper 2.5 – 3.5%
Tin Balance

PHYSICAL PROPERTIES: Mechanical properties of bulk solder

Solidus	450°F (232°C)	Density	7.52 g/cm ³
Liquidus	555°F (290°C)	Brinell Hardness	11 HV
Color	Bright Silver		

SOLDERING PROPERTIES:

Speedy has a faster melting range, which allows operators to fill small, tight-fitting pipe connections speedily. Speedy's low temperature, free flowing nature increases cycle time while reducing setup time. Speedy can be used with Stay-Clean paste or liquid flux, as well as Bridgit paste flux. Speedy is a lead-free, low temperature alloy formulated for joining copper pipe in potable water systems. This tin-based alloy conforms to the 1986 Federal Safe Drinking Water Act Amendment.

AVAILABLE FORMS:

Speedy is available in 1/8" diameter wire on one pound spools.
Master cartons hold 50 pounds.

SPECIFICATION COMPLIANCE:

Harris Internal

RECOMMENDED FLUX:

Stay Clean soldering fluxes are recommended except on electrical or electronic applications, which require the use of a rosin core solder or 505 neutral flux.

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

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