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

TECHNICAL SPECIFICATION SHEET

SILICON BRAZING ALLOY BLOCKADE® PATENT PENDING

ISO 9001
Cert. No. 31598

ALLOY PROPERTIES – BLOCKADE®

BLOCKADE® is the first of a new family of silicon/tin alloyed brazing filler metals. BLOCKADE® is engineered to join copper, brass or bronze. BLOCKADE's innovative composition provides the following brazing features:

- The ability to form a large shoulder, or cap, at the braze connection.
- Excellent for the air-conditioning and refrigeration industry
- A highly visible silver-gray cap, (fillet). This allows quick, accurate, and visual confirmation of a leak-free seal.
- Improved ductility over BCuP-2, (non-silver bearing), alloys
- Significant reduction in brazing temperature over other BCuP braze alloys.

NOMINAL CHEMICAL COMPOSITION:

Silicon	0.01-0.4 %	Copper	Balance
Phosphorus	6.0-7.0 %	Others (total)	0.15 %
Tin	6.0-7.0 %		

PHYSICAL PROPERTIES:

Solidus	1178°F (637°C)	Braze Color	Silver-Gray
Liquidus	1247°F (674°C)		

AVAILABLE FORMS:

Bare rod in standard wire diameters.
Flux coated rod.

SPECIFICATION COMPLIANCE:

ANSI/AWS A5.8, Class BCuP-9

RECOMMENDED FLUX:

No flux required on copper
For brass or bronze, use Stay-Silv® white or black brazing flux or flux-coated Blockade rod.

Additional information available at our web site: www.harrisproductsgroup.com

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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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