Copper/Brass Radiator Soldering - Product Guide

Tube Mills

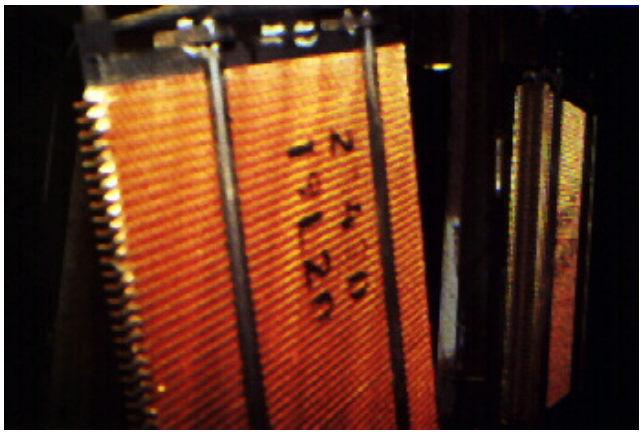
Radiator Tube Mill soldering requires high speed tinning with virtually no residues after soldering. In the case of a lockseam joint the connection must also from a strong capillary bond.

Superior No. 530 is a bromide-based, inorganic acid type flux, specifically designed for brass tube mill soldering. The unique mix of fluxing ingredients of this flux offers a high degree of fluxing activity and excellent oil absorption, both essential properties for brass tube mill soldering. This formulation leaves virtually no residue in lockseam tubes.

Core Baking

Radiator Core Baking requires strong soldering of reflowed solder from tubes to copper fins. The resulting soldered connection must have good thermal conductivity from the brass tube to the copper fins.

Superior No. 520B is a zinc-free, bromide-based, amine salt type flux, specifically designed for copper-brass radiator assembly soldering. It has been designed as a high concentration flux that allows for a great amount of dilution resulting in huge savings for the production operation. It leaves very little residue and will not turn the brass green after soldering.



Superior No. 580T is a zinc-free, bromide-based, inorganic salt type flux for radiator core baking specifically designed to be the cleanest possible formulation while still allowing great savings via high dilution.

Superior Flux and Mfg. Co., Cleveland, Ohio 14439, Tel: (440) 349-3000 Fax: (440) 349-3003, info@superiorflux.com
Or contact Bill Avery, Metal Joining Specialist, Phone: (716) 665-2656, william.f.avery@gmail.com

Superior Flux & Mfg. Co.

Copper/Brass Radiator Soldering - Product Guide

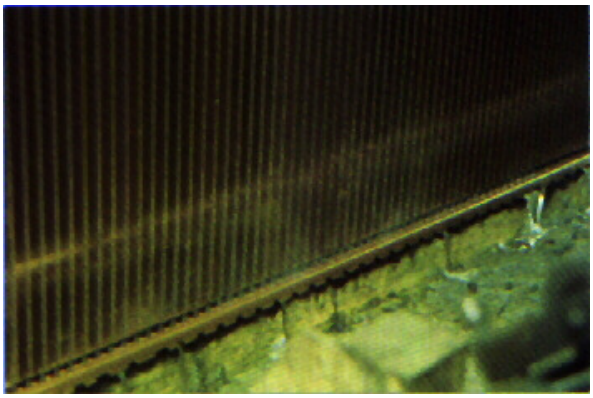
Header Dipping

Radiator Header Dipping requires strong capillary action to form the tube to brass header soldered connection. The soldered connection must have a strong bond due to the high internal shear stresses of this connection.

Superior No. 520B is a zinc-free, bromide-based, amine salt type flux with excellent capillary flow to tube to header connections.

Superior No. 590 is a strong zinc-based, bromide-based, inorganic salt type flux, which will not turn green after soldering.

Superior No. 153SFM is a strong zinc-based, bromide/chloride-based, inorganic salt type flux, with a unique hybrid chemistry which limits brass turning green after soldering.



Tank Soldering and Part Assembly

Tank Soldering and other Brass Part Soldering is typically done by high temperature torch soldering. The soldered connections must have strength since they have the highest pressure containing and external stresses of the unit.

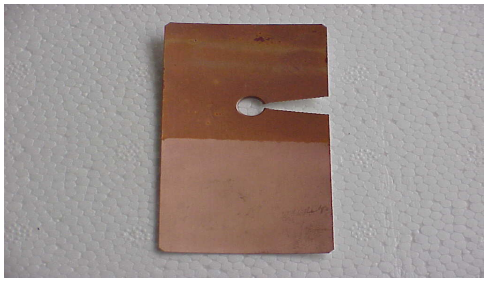
Superior No. 590 is a strong zinc-based, bromide-based, inorganic salt type flux, specifically designed for high temperature copper-brass radiator assembly soldering.

Superior No. 153SFM is a strong zinc-based, bromide/chloride-based, inorganic salt type flux, specifically designed for a wide range of torch soldering copper-brass radiator assembly operations.

Brass Cleaning and Radiator Washing

Brass parts should be cleaned before soldering. To assure that the completed radiator will not suffer from long term corrosion a chemical cleaning will completely remove any residual flux.

Superior No. 5700SFM is an effective halide-free copper and brass cleaner that was designed to have no effect on the water treatment system of radiator plants. This product works as a brass part cleaner and as a completed radiator cleaning solution to remove oxides and flux residues.



Superior Flux and Mfg. Co., Cleveland, Ohio 14439, Tel: (440) 349-3000 Fax: (440) 349-3003, info@superiorflux.com
Or contact Bill Avery, Metal Joining Specialist, Phone: (716) 665-2656, william.f.avery@gmail.com