



SUPERIOR No. 5



HIGH TEMPERATURE BRAZING POWDER FLUX

DESCRIPTION

Superio No. 5 is a brazing powder flux that is active in the temperature range 760 - 1205°C/1400-2200°F. It is used for brazing brass, bronze, copper, steel, stainless steel, malleable iron and heat-resistant alloys. Anti-Borax flux promotes deep penetration of the filler metal in the joints, resulting in high bond-strength. It dissolves and removes oxides rapidly and thoroughly with a minimum of bubbling, keeping impurities and porosity out of the joints.

APPLICATIONS

Superior No. 5 is used in the following industrial applications: appliances, farm machinery, heat exchangers, maintenance, ship repair, steel furniture and welding equipment.

PHYSICAL PROPERTIES

Form	Powder
Color	White
Specific Gravity	1.3 (Average)
Flammability	None
Volatile Content	0 %
Freezing Effects	None
Active Temperature Range	760-1205°C / 1400-2200°F
This Product is RoHS Compliant	

RECOMMENDED FILLER METALS

- | | |
|----------|-------|
| ➤ BAg | ➤ BCu |
| ➤ BNi | ➤ BAu |
| ➤ RBCuZn | |

Superior manufactures quality fluxes. Our business is solving problems.



DIRECTIONS

Thoroughly clean the work piece; breaks should be enlarged to a V-notch. Heat the end of the metal rod with a torch and dip into the flux or sprinkle the flux on the work piece. At the right temperature, flux will turn into a liquid that rapidly flows into all cracks and crevices, removing oxides and other impurities. Continue to melt the filler rod until the break or joint is filled, avoiding overheating. It is well to remember that, in brazing, only the filler metal is melted, not the base metal. **Superior No. 5** may also be used as a paste by adding water and mixing well. Brush the paste on the work piece and also on the brazing rod, allow the paste to dry, and apply heat. Flux residues wash off completely using hot water.

SAFETY PRECAUTIONS

Superior No. 5 contains no fluorides and is reasonably safe to use. Respiratory protection should be worn in heavy dust concentrations. The flux is not absorbed through healthy, intact skin, but is absorbed through burned or wounded skin areas, or if ingested. Absorption or ingestion may cause pathological disturbance. Brazing should be carried out only in well-ventilated areas.

Superior No. 5 has a two (2) year shelf life when stored properly.

Refer to MSDS for additional safety information.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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