



# Superior No. 6JB (BIFLUORIDE-FREE)



## SILVER BRAZING PASTE FLUX

- Formulated as a safe, general-purpose, brazing flux.
- Covers a broad temperature range.
- Brazes Copper, Brass, Nickel, ferrous metals, precious metals and carbides.
- Suitable for use with all BAg alloys, as well as high temperature filler metals.
- Residues are water-soluble.

### DESCRIPTION

**Superior No. 6JB** is a creamy, brown, brazing paste flux that is active and protective to 980°C/1800°F. It is recommended for use with copper, copper-based alloys, ferrous metals, nickel, carbides, gold, silver, and platinum. **Superior No. 6JB** contains no Potassium Bifluoride and will not irritate the skin.

### APPLICATIONS

**Superior No. 6JB** is a general purpose brazing flux used in a wide variety of joining applications for many different finished products including; appliances, automotive, heat exchangers, jewelry, musical instruments, refrigeration, ship repair, welding equipment and carbide tools.

### PHYSICAL PROPERTIES

Form	Paste
Color	Brown
Specific Gravity	1.5
Water Content	Less than 35%
pH	9.2 ± 0.4
Flash Point	None
Freezing Effects	None
Active Temperature Range	485-980°C/900-1800°F

**THIS PRODUCT IS RoHS COMPLIANT**

### SPECIFICATIONS

- AMS 3410
- AWS A5.3I-91, TYPE FB3A
- Federal specification 0-F-499, Type B

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## APPROPRIATE FILLER METALS

- BAg
- RBCuZn
- BCuP

## DIRECTIONS

**Superior No. 6JB** may be used in concentrated form or diluted with water to a thinner consistency. Heating the flux to 60-82°C/140-180°F makes it less viscous and more reactive. Heat the flux slowly to reduce spattering or excessive bubbling. The raw flux and residues are soluble in hot water (at least 60°C/140°F). Chipping or grinding is not necessary.

- ❶ Remove any oil, grease, or other contaminants from the surface to be brazed.
- ❷ Apply flux to joint by dipping, swabbing or brushing area being brazed. The flux may be used as supplied or diluted.
- ❸ Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux.
- ❹ Feed the braze alloy into the joint, unless a brazing preform is already in place.
- ❺ Clean flux residues from brazed joint using hot water (60°C±5°C /140°F±10°F) for best results. If unavailable, room temperature water may also be used.

## SAFETY PRECAUTIONS

**Superior No. 6JB** contains Potassium Fluoborate (CAS No. 14075-53-7) and should be handled with care.

Avoid contact with skin, eyes or clothing, using safety goggles and rubber gloves. As an added precaution, wash hands thoroughly after use. Brazing should be done with adequate ventilation.

Disposal of raw flux and flux residues must be carried out in accordance with local and federal environmental guidelines.

**Superior No. 6JB** 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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