



# SUPERIOR No. 10



## WELDING BACK-UP FLUX

- Formulated for inert-gas, metallic-arc, and/or gas welding of stainless steel, high chromium ferrous alloys, and low Nickel alloys.
- Provides significant protection and improves weld quality.
- Post-weld residues partially “pop-off.”
- Most cost-effective alternative for backside protection in lieu of Nitrogen, Argon, or other gases.

### DESCRIPTION

**Superior No. 10** Welding Back-up Flux is formulated for Mig and Tig welding stainless steel and low Nickel (less than 20%) heat resistant alloys. The flux prevents oxide inclusion formation, protects the backside from oxidation, supports the molten metal, and reduces burn-through. It is a more cost-effective means of achieving backside protection than other alternatives, including back-up bars, inert gas purge, back-up tape, and even other back-up fluxes. Additionally, the flux can be placed in areas where back-up bars or back-up tapes are impractical; such as parts with irregular shapes or bends.

### DIRECTIONS

Best results can be obtained with **Superior No. 10** Welding Back-up Flux by following these guidelines:

1. Remove dirt, oil, grease and other impurities from metals to be welded.
2. Mix **Superior No. 10** Welding Back-up Flux with methanol or ethanol in 3 parts flux:2 parts alcohol weight ratio. Stir the flux to a thinned paste and let stand for 10-20 minutes to develop proper consistency.
3. Apply the flux with a brush to the area being welded, and allow sufficient time for the alcohol to evaporate and dry out the flux coating before welding
4. Coat bare surfaces near the seam with flux. (For tack welding, apply between joints for even, oxide-free joints.)
5. Though some of the flux may ‘pop-off’ post-welding, flux residues can be removed grinding, chipping, or sandblasting.

Keep away from heat, moisture and water, as they reduce shelf life. Return flux to sealed container to prevent caking and excessive water pickup.

*Superior manufactures quality fluxes. Our business is solving problems.*



## PHYSICAL PROPERTIES

Form	Fine Gray Powder
Specific Gravity	2.5 (Average)
Volatile Content	<0.1%
Flash Point	None
Lower Explosion Limit	None
Freezing Effects	None
Active Temperature Range	1090-1540°C/2000-2900°F

**THIS PRODUCT IS RoHS COMPLIANT**

## SAFETY PRECAUTIONS

**Superior No. 10** Welding Back-up Flux contains Silica and Fluoride. Adequate ventilation is necessary to remove flux fumes along with vapors and fumes during welding process. Avoid breathing vapors and contact with skin, eyes and mucous membranes. Wear NIOSH Approved safety gloves, goggles, and ventilation masks.

**Superior No. 10** has a two (2) year shelf life when stored properly. Keep away from heat, moisture and water.

Refer to Material Safety Data Sheet (MSDS) for additional 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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