



SUPERIOR NO. 11



CAST IRON WELDING FLUX

DESCRIPTION

Superior No. 11 is a welding powder flux that is active in the temperature range of 815°-1090°C/1500°-2000°F. This flux is used to weld cast or malleable iron with low fuming bronze. **Superior No. 11** promotes deep penetration of the joints, resulting in high bond strength. The formulation is fluoride-free.

APPLICATIONS

Superior No. 11 is used in the following applications: farm machinery repair, engine repair, and maintenance.

DIRECTIONS

The base metal should be cleaned thoroughly to remove dirt, grease and other contaminants. **Superior No. 11** may be used in a powder form or mixed with water to make a paste. Brush flux onto the work area, preheat filler metal rod and dip into the flux, then weld as usual. Flux residues are soluble in hot water at 60°C/140°F or hotter.

PHYSICAL PROPERTIES

Form	Powder
Color	White
Specific Gravity	1.5 (Average)
Volatile Content	<0.1%
Flash Point (TCC)	None
Lower Explosion Limit	None
Humidity Effect	Slight
Active Temperature Range	815°-1090°C/1500°-2000°F

This Product is RoHS Compliant

FILLER METAL

► Low Fuming Bronze

► Nickel-Silver

SPECIFICATIONS

Superior No. 11 meets all the requirements of Mil-F-16136B, Type C.

SAFETY PRECAUTIONS

Superior No. 11 contains Boric Acid and should only be used in well ventilated areas. Avoid breathing dust and fumes produced during welding. Avoid contact with skin, eyes and mucous membranes. In case of eye contact, flush freely with water and call a physician. Keep away from heat, moisture and water, as they reduce shelf life. Return flux to sealed container to prevent caking. Refer to Safety Data Sheet (SDS) for additional safety information.

Superior No. 11 has a two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

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