



SUPERIOR No. 606B



HIGH TEMPERATURE BRAZING PASTE FLUX

DESCRIPTION

No. 606B is a creamy black paste flux that is active and protective up to 1950°F. It is particularly suitable for brazing of ferrous metals and alloys, high-chromium alloys and tungsten carbide compositions. No. 606B works well with low-silver content brazing alloys and nickel silver (CDA773) and low-fuming bronze (CDA681) filler metals. The flux will not harden or crystallize in the container and retains its creamy texture for two years

APPLICATIONS

No. 606B is used for brazing of carbide tools or large steel parts or when long heating cycles are required.

PHYSICAL PROPERTIES

Form	Fine Creamy Paste
Color	Black
Specific Gravity	1.6 g/cc
Water Content	<20%
Flash Point	None
Freezing Effects	None
Brazing Temperature Range	537-982°C/1000-1800°F

THIS PRODUCT IS RoHS COMPLIANT

APPROPRIATE FILLER METALS

- BAg
- BCuP
- BAu
- BNi
- RBCuZn

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SPECIFICATIONS

- AMS 3410D
- AWS A5.3I-92, TYPE FB3-C
- Federal Specification 0-F-499C, Type B

DIRECTIONS

Superior No. 606B 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 140°F/60°C). 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. 606B contains potassium bifluoride (CAS #7789-29-9) and potassium fluoborate (CAS #14075-53-7) and should be handled with care.

Avoid contact with skin, eyes or clothing, using NIOSH approved safety goggles, rubber gloves and rubber apron. 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. 606B 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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