



SUPERIOR No. 608



SILVER BRAZING POWDER FLUX

- Formulated as a safe general-purpose, Silver brazing flux.
- Brazes copper, Brass, Nickel, ferrous metals, and precious metals.
- Residues are water-soluble.

DESCRIPTION

SUPERIOR No. 608 is a powder, Silver brazing flux that is active and protective to 870°C/1,600°F. It is recommended for use with Copper, Copper-based alloys, ferrous metals, Nickel, carbides, Gold, Silver, and Platinum. **SUPERIOR No. 608** contains no Potassium Bifluoride, making this a less irritating flux when handling or brazing.

APPLICATIONS

SUPERIOR No. 608 is a general purpose powder 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, and welding equipment.

DIRECTIONS

SUPERIOR No. 608 may be used in powder form as supplied 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 (Recommended temperature of 60°C/140°F). Chipping or grinding is not necessary.

- ➊ Remove any oil, grease, or other contaminants from the surface to be brazed.
- ➋ Apply flux to joint by dipping, sprinkling, or brushing area being brazed. The flux may be used as supplied or diluted.
- ➌ Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux. Flux will liquefy and flow into joints when proper temperature is reached.
- ➍ Feed the braze alloy into the joint, unless a brazing preform is already in place.
- ➎ Clean flux residues from brazed joint using hot water (60±5°C/140±10°F) for best results. If unavailable, room temperature water may also be used.

APPROPRIATE FILLER METALS

- BAg
- BCuP

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PHYSICAL PROPERTIES

Form	Powder
Color	White
Bulk Density	1.1
Humidity Effect	Minimal
Flash Point	None
Freezing Effects	None
Active Temperature Range	470-870°C/900-1,600°F
This Product is RoHS Compliant	

SPECIFICATIONS

- AMS 3410
- AWS A5.3I-92, Type FB3F
- Federal Specification O-F-499, Type B

SAFETY PRECAUTIONS

SUPERIOR No. 608 contains potassium fluoborate (CAS No. 14075-53-7) and should be handled with care.

Avoid contact with skin, eyes or clothing. It is recommended that NIOSH approved safety goggles, rubber gloves, and rubber apron are worn when brazing. 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. 608 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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