



SUPERIOR No. 25



SILVER BRAZING LIQUID FLUX

- VOC-Free Flux
- Excellent choice for jewelry, musical instruments and other applications.
- Boosts productivity, efficiency, and output for SS409 Tube Welding

DESCRIPTION

Superior No. 25 is a VOC-Free, liquid brazing flux, containing borates and fluorides. It performs well on ferrous and non-ferrous alloys, as well as precious metals. The flux exhibits excellent capillary action, drawing the silver solder into narrow joints. Furthermore, it exerts powerful scavenging action on most metal oxides, removing tarnish, scale, and other impurities yielding strong brazed joints.

APPLICATIONS

Superior No. 25 is used for brazing in furnaces with poor atmospheres for joining jewelry parts and musical instruments, and for any brazing job that requires a liquid flux. Another application is in Tube Welding where the flux reduces electrical requirements in induction process, removes oxide levels on surface to yield a better, stronger joint.

DIRECTIONS

Superior No. 25 may be applied manually by brush, spraying, dipping or with automatic dispensing equipment. Recommended heat sources are torch, induction, or furnace brazing methods. The flux is active between 590 – 870°C/1094 - 1598°F which makes it an ideal candidate for use with a variety of silver brazing alloys.

- ❶ Remove any oil, grease, or other contaminants from the surface to be brazed.
- ❷ Apply flux to joint by dipping, swabbing, spraying 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.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

Form	Clear Liquid
Specific Gravity	1.110 @ 20-25°C/68-77°F
pH	7.7 @ 20-25°C/68-77°F
Flash Point	None
Freezing Point	-6°C/-42.8°F
Boiling Point	106°C/223°F
Freezing Effects	None
Active Temperature Range	590-870°C/1094-1598°F
Residues	Water-Soluble

THIS PRODUCT IS RoHS COMPLIANT

SAFETY PRECAUTIONS

Superior No. 25 contains borates and fluorides and should be handled with care.

Avoid contact with skin, eyes or clothing. Wear NIOSH approved safety goggles, rubber gloves and rubber apron when handling and brazing. As an added precaution, wash hands thoroughly after use. Brazing should be done in an area of adequate ventilation.

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

Superior No. 25 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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