



# SUPERIOR NO. 530



## BROMIDE-BASED TUBE MILL FLUX

- Continuous Brass Tinning Flux for Radiator Brass Tube Mill
- Extremely Fast Tinning Properties
- Draws Strong Internal Joint for Lockseam Tube Mill
- Leaves No Residue After Tinning
- Has Excellent Oil Absorption Properties
- 100% Bromide, No Clean Formulation Uses No Corrosive Chloride

### DESCRIPTION

**Superior No. 530** is a bromide-based, inorganic acid type flux, specifically designed for brass tube mill soldering. The unique mix of fluxing ingredients of **Superior No. 530** flux offers a high degree of fluxing activity and excellent oil absorption, both essential properties for brass tube mill soldering. **Superior No. 530** leaves virtually no residue in lockseam tubes.

### APPLICATIONS

**Superior No. 530** was formulated specifically for continuous soldering in a radiator tube mill, either welded or lockseam type. The **Superior No. 530** formulation has been designed to completely remove the excessive water-oil mix used for brass tube mill material lubrication. Normal flux application is total immersion of the brass tube.

### DIRECTIONS

- ➊ **Superior No. 530** is normally applied at room temperature using an overflowing flux immersion technique.
- ➋ **Superior No. 530** is used at one part flux to two part water for lockseam tube mills. **Superior No. 530** can be diluted up to six parts water to one part flux by volume for welded tube mill applications.
- ➌ There are virtually no post-soldering residues using **Superior No. 530**, therefore no cleaning need to be done.

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

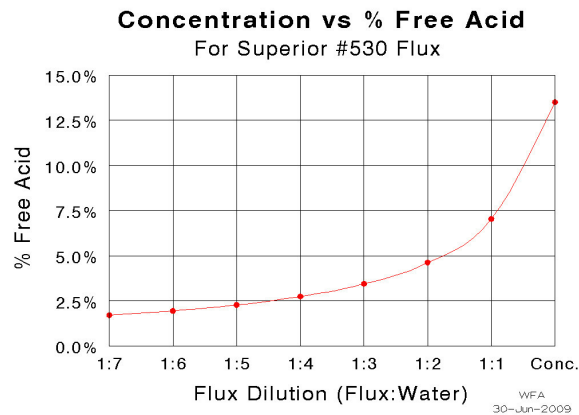
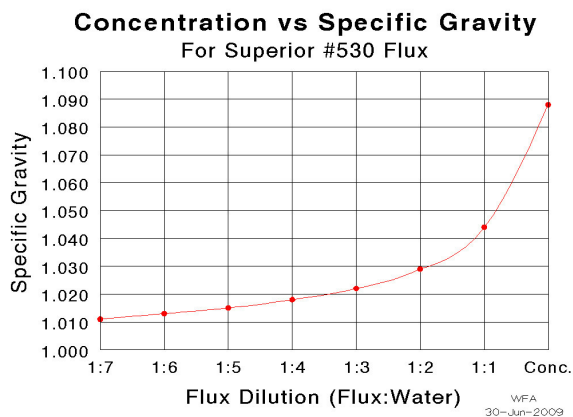


## PHYSICAL PROPERTIES

|                                       |                                   |
|---------------------------------------|-----------------------------------|
| Appearance                            | Clear, Red                        |
| Specific Gravity                      | 1.088 ± 0.010 @ 20-25°C/68-77°F   |
| Density                               | 9.1 Lbs./Gallon @ 20-25°C/68-77°F |
| Free Acid                             | 13.2 ± 2.0% HBr                   |
| Surface Tension                       | 32 dynes/cm minimum               |
| Recommended Soldering Range           | 260-427°C/500-800°F               |
| Odor                                  | Mild                              |
| Flash Point                           | None                              |
| Freezing Point                        | None                              |
| <b>This Product is RoHS Compliant</b> |                                   |

## PREPARATION and HANDLING

**Superior No. 530** is shipped as a concentrate to be diluted of up to two parts water to one part flux by volume for lockseam tube mills and one part flux to six parts water for welded tube mills. For greater strength, lower dilution ratios should be used. Mix well when diluting and check specific gravity with a hydrometer before use. The solution will not separate on standing.



## SAFETY PRECAUTIONS

Since **Superior No. 530** attacks many metals to some extent, it is recommended that polyethylene, PVC or fiberglass reinforced polyester containers be used. Any machinery or construction materials, which might be exposed to direct contact with the flux, should also be able to withstand acids.

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

**Superior No. 530** has a two (2) year shelf life.

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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