



# SUPERIOR

## No. 609B/3417FP



# HIGH TEMPERATURE BRAZING FLUX

## DESCRIPTION

**Superior No. 609B/3417FP** is a Boron-modified powder flux that is active and protective up to 2200°F / 1205°C. It is suitable for brazing of ferrous metals and alloys, high-Chromium alloys and Tungsten Carbide compositions. **Superior No. 609B/3417FP** works well with low-Silver content brazing alloy, Nickel-Silver (CDA 773) and low-fuming Bronze (CDA 681) filler metals.

## APPLICATIONS

**Superior No. 609B/3417FP** is used for the brazing of carbide tools, large steel parts or when heating cycles are required. The flux is designed for furnace brazing operations and where moisture levels must be minimized.

## PHYSICAL PROPERTIES

Form	Fine Powder
Color	Brown
Specific Gravity	2.0g/cc
Water Content	None
Flash Point	None
Freezing Effects	None
Active Temperature Range	760°-1205°C/1400°-2200°F
<b>This Product is RoHS Compliant</b>	

## APPROPRIATE FILLER METALS

- |          |       |
|----------|-------|
| ➤ BAg    | ➤ BCu |
| ➤ BNi    | ➤ BAu |
| ➤ RBCuZn |       |

## SPECIFICATIONS

- AMS 3417
- AWS A5.3I-92, TYPE FB3J

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



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## DIRECTIONS

**Superior No. 609B/3417FP** can be used as supplied or mixed with water to make a paste. The raw flux and flux residues are completely soluble in water. Use hot water (at least 140°F / 60°C) to remove residues; chipping or grinding is not necessary.

## SAFETY PRECAUTIONS

**Superior No. 609B/3417FP** contains no Potassium Bifluoride and has a low overall Fluorine content. Nevertheless, avoid contact with skin, eyes or clothing; use of rubber gloves is recommended. Brazing should only be carried out with adequate ventilation, as inhalation of fumes can be dangerous. Make sure disposal of raw flux or residues is in accordance with local and federal environmental guidelines.

Refer to the Material Data Safety Sheet for further information.

**Superior No. 609B/3417FP** 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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