SUPERIOR No. 625

ALUMINUM-BRONZE BRAZING PASTE FLUX

- Formulated for torch-brazing aluminum bronze metals.
- Wide active temperature range.
- Residues are water-soluble.

DESCRIPTION

_Superior No. 625_ is a white, brazing paste flux that is active and protective to a temperature of 1000°C/1,830°F. It is specifically formulated for brazing aluminum-bronze base metals, and other copper-based metals with an aluminum content of 2-10%. All flux residues are water-soluble and can be washed off of parts post-brazing.

DIRECTIONS

_Superior No. 625_ 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 60°C/140°F). Chipping or grinding is not necessary.

1. Remove any oil, grease, or other contaminants from the surface to be brazed.
2. Apply flux to joint by dipping, swabbing or brushing area being brazed. The flux may be used as supplied or diluted.
3. Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux.
4. Feed the braze alloy into the joint, unless a brazing preform is already in place.
5. 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.

SPECIFICATIONS

- AWS A5.31-92, TYPE FB4A
- Federal Specification 0-F-499, Type A

APPROPRIATE FILLER METALS

- BAg
**PHYSICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Form</td>
<td>Paste</td>
</tr>
<tr>
<td>Color</td>
<td>White</td>
</tr>
<tr>
<td>Water Content</td>
<td>Less than 12%</td>
</tr>
<tr>
<td>pH</td>
<td>5.35 ± 1.35</td>
</tr>
<tr>
<td>Halide Content</td>
<td>Less than 26%</td>
</tr>
<tr>
<td>Freezing Effects</td>
<td>None</td>
</tr>
<tr>
<td>Active Temperature Range</td>
<td>540-870°C/1000-1600°F</td>
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</tbody>
</table>

**THIS PRODUCT IS RoHS COMPLIANT**

**SAFETY PRECAUTIONS**

*Superior No. 625* contains different fluorides 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. 625* has a two (2) year shelf life when stored properly.

Refer to MSDS for additional safety information.