

## Technical data

### Brazing Flux

#### Silver-flo™ Flux powder

#### Product description

Silver-flo™ Flux Powder is a basic lower cost brazing flux suitable for use with silver brazing filler metals. As such it does not exhibit all the activity and characteristics of other brazing fluxes such as Easy-flo™ Flux Powder. It is however, suitable for use on all of the common engineering materials (copper, brass, mild steel and stainless steel), but not aluminium.

JM special purpose fluxes are required when brazing aluminium bronze, certain grades of stainless steel, tungsten, molybdenum and tungsten carbide or where protracted heating is involved.

**Conforms to:** EN 1045: FH10

**Working range:** 450-775 °C

#### Directions for use

Flux powder should be mixed with water and a few drops of liquid detergent to form a thick paste. Paste should then be brushed onto the joint surfaces before assembly. Further flux should then be applied externally either side of the joint mouth.

Hot Rodding is where a warm brazing rod is dipped into flux powder and the flux adhering to the rod is transferred to the joint area. This is an effective fluxing method but difficult to achieve good penetration of capillary joints. It can be used to supplement a pre-fluxed area during heating.

It is good practice to mechanically clean and degrease the joint surface before applying flux. Heat slowly and evenly to the brazing temperature, without local overheating. Use the flux as a temperature guide - it will become clear or opaque as brazing temperature is approached. If blackening of the flux occurs this is often a sign of insufficient flux, overheating or flux exhaustion.

#### Flux residue removal

The flux residues left after completion of the brazing operation are corrosive and should be removed. The residues for

Silver-flo™ Flux Powder can easily be removed by soaking in hot water > 40°C for between 15 and 30 minutes. Any remaining residues can then be brushed off in running water.

#### Product availability

0.25kg Plastic Pots

0.5kg Plastic Pots

5kg Plastic Pots

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