Tenacity™ No. 5A Flux Powder

Tenacity™ No. 5A Flux Powder is a brazing flux suitable for use with silver brazing filler metals. It has a working range of 600-900˚C.
Tenacity™ No. 5A Flux Powder is a modified version of Tenacity™ No. 5 Flux Powder, with an addition of elemental boron. This improves the fluxing action on tungsten carbide and the refractory metals.
Tenacity™ No. 5A Flux Powder shows good overheat resistance when compared to other silver brazing fluxes. This characteristic is potentially useful when brazing stainless steel components for example, where because of its poor thermal conductivity there is a risk of overheating causing the flux to become exhausted and ineffective. However, Tenacity™ No. 5A Flux Powder should not be used on low nickel or nickel-free stainless steels if interfacial corrosion is likely to be a hazard in service.
Tenacity™ No. 5A Flux Powder also shows an extended life at brazing temperature (time / temperature stability). This feature is important when brazing large assemblies in steel or copper for example, or wherever prolonged heating is necessary.
Please note: Because Tenacity™ 5A is dark brown in colour it is not always easy to observe the flow of the brazing alloy.

Conforms to: EN 1045: FH12
Working range: 600-900˚C

Directions for Use

Tenacity™ No. 5A 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.
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. If blackening of the flux occurs this is often a sign of insufficient flux, overheating or flux exhaustion.

Flux Residue Removal

The flux residues of this product are virtually insoluble in water. Immersion in a warm (>40˚C) 10% sodium hydroxide solution for 30 minutes followed by brushing in a stream of water is recommended. The residues are hard and will also respond well to mechanical removal methods such as grit blasting.

Product Availability

0.5kg Plastic Pots

Tenacity™ is a Johnson Matthey Metal Joining trademark.

JM
Johnson Matthey
Metal Joining York Way, Royston, Hertfordshire, SG8 5HJ, UK
Telephone: +44 (0) 1763 253200 Fax: +44 (0) 1763 253168 email: mj@matthey.com www: jm-metaljoining.com