Tenacity™ No. 6 Flux Powder

Tenacity™ No. 6 Flux Powder is a specialized boron-modified flux for use on heat resistant stainless steel, tungsten carbide and the refractory metals. It is often recommended for use on tungsten carbide components where it helps to provide improved wetting of the brazing alloy.
Being dark brown it is not always easy to observe the flow of the brazing alloy. It has a working range of 550-800˚C. Tenacity™ No. 6 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.

Conforms to: EN 1045: FH12
Working range: 550-800˚C

Directions for Use

Tenacity™ No. 6 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. 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 Tenacity No.6 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

0.5kg Plastic Pots
4kg Plastic Pots

Tenacity™ is a Johnson Matthey Metal Joining trademark.

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