

Tenacity™ No 14 Flux Powder



Tenacity™ No. 14 Flux Powder

Tenacity™ No. 14 Flux Powder is a brazing flux suitable for use with silver brazing filler metals. It is principally designed for use on brass where red staining, due to oxidation of zinc during heating, is a problem. It is active at about 450°C and spreads rapidly giving good cover early in the heating cycle. It is recommended for use with silver brazing alloys that melt below 700°C. JM special purpose fluxes are required when brazing aluminium bronze or where protracted heating is involved.

Conforms to: EN1045:FH10
Working range: 550-750°C

Directions for Use

Tenacity™ No. 14 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 of this product, left after completion of the brazing operation, are corrosive and should be removed. Generally they can be readily removed by soaking in hot water at a temperature >40°C for between 15 and 30 minutes. However in some cases better results may be achieved by immersing in a warm 10% solution of sulphuric acid. Any remaining residues can then be brushed off in running water.

Product Availability

0.5kg Plastic Pots
 5kg Plastic Pots

Tenacity™ is a Johnson Matthey trademark and is registered to JM in the EU and certain other countries.

Johnson Matthey Plc cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products will be used. This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is given in good faith, being based on the latest information available to Johnson Matthey Plc and is, to the best of Johnson Matthey Plc's knowledge and belief, accurate and reliable at the time of preparation. However, no representation, warranty or guarantee is made as to the accuracy or completeness of the information and Johnson Matthey Plc assumes no responsibility therefore and disclaims any liability for any loss, damage or injury howsoever arising (including in respect of any claim brought by any third party) incurred using this information. The product is supplied on the condition that the user accepts responsibility to satisfy himself as to the suitability and completeness of such information for his own particular use. Freedom from patent or any other proprietary rights of any third party must not be assumed. The text and images on this document are Copyright and property of Johnson Matthey. This datasheet may only be reproduced as information, for use with or for resale of Johnson Matthey products. The JM logo®, Johnson Matthey name® and product names referred to in this document are trademarks of Johnson Matthey. Easy-flo® and Silver-flo® are registered to JM in the EU. Sil-fos™ is registered to JM in the UK and certain other countries but is marketed as Mattiphos™ in Germany and the USA.



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