

Mattiflux™ 3A**Flux Paste**

Tenacity™ No. 3A Flux Paste

Tenacity™ No. 3A Flux Paste is a flux that is suitable for use with silver brazing filler metals. It is especially designed for use on heat resistant stainless steels, tungsten carbide and the refractory metals. It has a working range of 600-875°C and is suitable for use with silver brazing filler metals melting below 825°C (such as several of the Silver-flo™, Easy-flo™ and Argo-braze™ range of alloys). Tenacity™ No. 3A Flux Paste formerly sold as Mattiflux™ 3A Paste.

This flux contains elemental boron making it dark brown in colour. It is therefore not always easy to observe the flow of the molten brazing alloy. It is often recommended for use on tungsten carbide components where it helps to provide improved wetting of the brazing alloy. The flux also offers good overheat resistance.

Tenacity™ No. 3A Flux Paste 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. 6 Flux Paste has replaced Tenacity™ No. 3A Flux Paste as a stock product.

Conforms to: EN 1045: FH12, AMS 3411
Working range: 600-875°C

Directions for Use

Flux paste should 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, left after completion of the brazing operation, are corrosive and should be removed. They can be readily removed by soaking in hot water at a temperature >40°C for between 15 and 30 minutes. Any remaining residues can then be brushed off in running water.

Product Availability

Special order only

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