

**Tenacity™ No 2****Flux Powder**


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## Tenacity™ No. 2 Flux Powder

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Tenacity™ No.2 Flux Powder is a brazing flux suitable for use with silver brazing filler metals. It has a working range of 550-800°C and is recommended for use with filler metals melting below 750°C (such as the low melting point Silver-flo™ and Easy-flo™ alloys). It is highly active very early on in the brazing cycle, exhibits very little bubbling during heating and has a relatively low viscosity when molten. These facts make it suitable for induction brazing, very short heating, and Tenacity™ No.2 Modified Flux Powder is used for flux coated rods.

Tenacity™ No.2 Flux Powder is suitable for use on all the common engineering materials (copper, brass, mild steel and stainless steel), but not aluminium. It performs particularly well on copper and copper alloys. 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:** 550-800°C

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### Directions for Use

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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.

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### Flux Residue Removal

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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.

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### Product Availability

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0.5kg Plastic Pots  
 5kg Plastic Pots  
 25kg Plastic Sacks

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