

**Tenacity™ No 2****Modified  
Flux Powder**


---

## Tenacity™ No. 2 Modified Flux Powder

---

Tenacity™ No.2 Modified is a brazing flux specifically formulated for use as the flux element of flux coated rods. The product has also been specially milled to produce powder of suitable size for flux coating machinery. It is supplied in bulk to manufacturers of flux coated silver brazing rods and is used on all Johnson Matthey flux coated rods.

The flux itself is 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 brazing situations where the flux has a short period of time in which to begin to be effective.

**Conforms to:** EN 1045: FH10  
**Working range:** 550-800°C

---

### Directions for Use

---

Tenacity™ No.2 Modified is designed for use as the outer flux on flux coated rods. When used in this way it 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.

---

### 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

---

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

Tenacity™ is a Johnson Matthey trademark.

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](mailto:mj@matthey.com)

[www: jm-metaljoining.com](http://www.jm-metaljoining.com)