

Tenacity™ No 20 Flux Powder



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Tenacity™ No. 20 Flux Powder is a high temperature brazing flux suitable for use with copper based brazing filler metals. Typically it would be used for brazing or bronze/braze welding of mild steel and copper components with brass type brazing filler metals such as Argentel™.

It is effective on copper and copper based alloys, mild and low alloy steels and tungsten carbide with alloys melting between 750-950°C.

Conforms to: EN 1045: FH21
Working range: 750-1000°C

Directions for Use

Tenacity™ No. 20 Flux Powder should be mixed with water and a few drops of liquid detergent to form a thick paste. This paste should then 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. Use the flux as a temperature guide. 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 are very hard and insoluble in water and must be removed by mechanical methods such as grit blasting or grinding.

Product Availability

0.5kg Plastic Pots
 5kg Plastic Pots

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