

Tenacity™ No 4A Flux Powder



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Tenacity™ No.4A Flux Powder is a medium temperature brazing flux suitable for use with silver brazing filler metals. It has a working range of 600-850°C and is suitable for use with silver brazing filler metals that melt below 800°C.

It is useful for brazing larger assemblies in steel or copper wherever prolonged heating may cause general-purpose fluxes to become exhausted. It also finds applications in silversmithing.

Conforms to: EN 1045: FH10
Working range: 600-850°C

Directions for Use

Tenacity™ No. 4A 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.

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 are corrosive and should be removed after brazing. They are only partially soluble in water. Immersion in a warm (>40°C) 10% sodium hydroxide solution for 30 minutes followed by brushing in a stream of water is recommended for removing them. The residues are hard and will also respond well to mechanical removal methods such as grit blasting.

Product Availability

0.5kg Plastic Pots
 5kg Plastic Pots

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