

Tenacity™ No 5 Flux Powder



Tenacity™ No. 5 Flux Powder

Tenacity™ No.5 Flux Powder is a brazing flux suitable for use with silver brazing filler metals. It is active at 600°C and is effective with alloys that melt below 850°C.

Tenacity™ No.5 shows good overheat resistance when compared to other silver brazing fluxes. This characteristic is useful when brazing stainless steel components for example, where because of its poor thermal conductivity there is a risk of overheating causing the flux to become exhausted and ineffective.

Tenacity™ No.5 also shows an extended life at brazing temperature (time / temperature stability). This feature is important when brazing large assemblies in steel or copper for example, or wherever prolonged heating is necessary.

Conforms to: EN 1045: FH10
Working range: 600-900°C

Directions for Use

Tenacity™ No. 5 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 virtually insoluble 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. The residues are hard and will also respond well to mechanical removal methods such as grit blasting.

Product Availability

0.25kg plastic pots
 0.5kg plastic pots
 5kg plastic pots

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