

Tradeflame®

SILVER BRAZING FLUX PRODUCT MANUAL

PART NO. 228478



CAUTION: For maximum protection, always wear safety goggles, gloves or other appropriate equipment

Tradeflame general purpose silver brazing flux paste is recommended for silver brazing of carbon steel, stainless steel and dissimilar metals. Used with silver brazing rods with low to medium silver content 2 to 40%. It is an excellent flux for medium to high temperature brazing. This general purpose flux when used in conjunction with the silver brazing alloys will produce excellent joints on carbon steel, stainless steel, nickel alloys, copper and brass.

SPECIFICATIONS

- **Melting point:** 620°C
- **Appearance:** White paste
- **Weight:** 250g

CONTENTS

- Potassium fluorhydroborate: 20 -40% (12228-71-6)
- Potassium tetraborate: 15-25% (1332-77-0)
- Boric acid: 30-45% (10043-35-3)
- Potassium fluoborate: 7-15% (14075-53-7)

INSTRUCTIONS FOR BRAZING

(Braze welding using flux)

1. Use appropriate protection when handling and using this product.
2. Clean and wash thoroughly any exposed skin after use.
3. Thoroughly clean all areas to be joined sand paper or wire brush.
4. Add the flux to the area to be brazed using a brush before applying heat. You can also add more flux to the tip of the brazing rod by dipping it directly into the flux after applying a little heat to the brazing rod.
5. A slight oxidising flame should be used to braze. Adjust your flame accordingly.
6. Heat the edges to be joined to a dull red color. Melt the end of the rod and at the same time heat both ends of the area being brazed to an equal amount. Ensure that the tinning has occurred on the area being brazed.
7. Melting of the area being brazed is not required in brazing and care should be taken not to overheat the base metal.
8. Continue adding the filler rod to the base metal until the required size and shape is attained.
9. Allow the joint to cool, remove any flux residue with a wire brush or acid solution followed by a water rinse.

ANGER

MAY DAMAGE FERTILITY OR THE UNBORN CHILD. TOXIC IF SWALLOWED. CAUSES SERIOUS EYE IRRITATION. READ INSTRUCTIONS BEFORE USE. DO NOT HANDLE UNTIL ALL SAFETY PRECAUTIONS HAVE BEEN READ AND UNDERSTOOD. AVOID BREATHING DUST/FUME/GAS/MIST/VAPOURS/SPRAY. WEAR PROTECTIVE GLOVES/PROTECTIVE CLOTHING/EYE PROTECTION/FACE PROTECTION. CAUSES SKIN IRRITATION AND MAY CAUSE RESPIRATORY IRRITATIONS. DISPOSE OF CONTENTS AND CONTAINER IN ACCORDANCE WITH LOCAL REGIONAL/NATIONAL INTERNATIONAL REGULATIONS. REFER TO THE SDS FOR FURTHER INFORMATION.

