



SUPERIOR No. 4



SILVER BRAZING POWDER FLUX

- Formulated as a safe general-purpose, silver brazing flux.
- Brazes copper, copper-based alloys, nickel, steel, and precious metals.
- Residues are soluble in hot water.

DESCRIPTION

Superior No. 4 is a white, silver brazing powder that is active and protective to 815°C/1,500°F. It was designed for the majority of silver brazing applications, and is recommended for use with copper and copper-based alloys, steel, nickel and precious metals. **Superior No. 4** flux is highly active in dissolving refractory oxides and is, therefore, especially effective on stainless steels, carbides and heat-resistant alloys.

APPLICATIONS

Superior No. 4 is a general purpose powder brazing flux used in a wide variety of joining applications for many different finished products, including; appliances, automotive, carbide tools, heat exchangers, refrigeration and air conditioning, plumbing fixtures, jewelry and maintenance.

DIRECTIONS

Superior No. 4 may be used in powder form as supplied or diluted with water to a thinner consistency. Heating the flux to 60°C/140°F – 82°C/180°F makes it less viscous and more reactive. Heat the flux slowly to reduce spattering or excessive bubbling. The raw flux and residues are soluble in hot water (Recommended temperature of 60°C/140°F). Chipping or grinding is not necessary.

- ❶ Remove any oil, grease, or other contaminants from the surface to be brazed.
- ❷ Heat the end of the filler metal rod and dip into the flux, or sprinkle the flux on the work-piece.
- ❸ When the proper temperature is reached, the flux will liquefy and rapidly flow into the joints, removing all surface oxides and tarnish. Continue heating until the filler metal fills the joints, producing shiny fillets.
- ❹ The flux may be used in powder form or mixed with water to make a paste.
- ❺ Clean flux residues from brazed joint using hot water (60±5°C/140±10°F) for best results. If unavailable, room temperature water may also be used.

APPROPRIATE FILLER METALS

- 35, 45, 50 and 56% silver alloys, with or without cadmium.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

Form	Powder
Color	White
Bulk Density	1.2
Water Content	Less than 1%
Flash Point	None
Freezing Effects	None
Humidity Effect	Slight Moisture Pickup
Active Temperature Range	485°C/900°F – 815°C/1,500°F

SAFETY PRECAUTIONS

Superior No. 4 contains inorganic fluorides and should be used only in well-ventilated areas.

Avoid contact with skin, eyes or clothing. It is recommended that NIOSH approved safety goggles, rubber gloves, and rubber apron be worn when brazing. As an added precaution, wash hands thoroughly after use. Brazing should be done with adequate ventilation. In case of eye contact, flush with water and contact a physician.

Disposal of raw flux and flux residues must be carried out in accordance with local and federal environmental guidelines.

Superior No. 4 has a two (2) year shelf life when stored properly. Keep away from heat, moisture and water. Return flux to sealed container to prevent caking.

Refer to MSDS for additional safety information.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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