



SUPERIOR No. 625



ALUMINUM-BRONZE BRAZING PASTE FLUX

- > Formulated for torch-brazing aluminum bronze metals.
- > Wide active temperature range.
- > Residues are water-soluble.

DESCRIPTION

Superior No. 625 is a white, brazing paste flux that is active and protective to a temperature of 1000°C/1,830°F. It is specifically formulated for brazing aluminum-bronze base metals, and other copper-based metals with an aluminum content of 2-10%. All flux residues are water-soluble and can be washed off of parts post-brazing. **Superior No. 625** will not harden or crystallize, retaining its texture up to two (2) years.

DIRECTIONS

Superior No. 625 may be used in concentrated form 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 (at least 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 Apply flux to joint by dipping, swabbing or brushing area being brazed. The flux may be used as supplied or diluted.
- ❸ Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux.
- ❹ Feed the braze alloy into the joint, unless a brazing preform is already in place.
- ❺ Clean flux residues from brazed joint using hot water (60°C ± 5°C /140°F ± 10°F) for best results. If unavailable, room temperature water may also be used.

SPECIFICATIONS

- > AWS A5.3I-92, TYPE FB4A
- > Federal Specification 0-F-499, Type A

APPROPRIATE FILLER METALS

- > BAg

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PHYSICAL PROPERTIES

Form	Paste
Color	White
Water Content	Less than 12%
pH	6.0 ± 0.7
Halide Content	Less than 26%
Freezing Effects	None
Active Temperature Range	600-1000°C/1111-1830°F

SAFETY PRECAUTIONS

Superior No. 625 contains different fluorides and should be handled with care.

Avoid contact with skin, eyes or clothing, using NIOSH approved safety goggles, rubber gloves and rubber apron. As an added precaution, wash hands thoroughly after use. Brazing should be done with adequate ventilation.

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

Superior No. 625 has a two (2) year shelf life when stored properly.

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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