SUPERIOR No. 604B/3411

BORON-MODIFIED SILVER BRAZING PASTE FLUX

- Boron-modified, high temperature silver brazing flux.
- Brazes Copper, Brass, Nickel, carbon steel, stainless steel, and carbide.
- Residues are water-soluble.

DESCRIPTION

Superior No. 604B/3411 is a creamy, Boron-modified brazing paste flux that is active and protective to 925ºC/1,700ºF. It is formulated for brazing operations where a higher temperature or longer flux-life is necessary.

It is recommended for use with copper and copper-based alloys, steel, stainless steel, nickel, carbides and heat-resistant alloys. ***Superior No. 604B/3411*** is available in dispensable form suitable for spraying or other automatic application methods.

APPLICATIONS

Superior No. 604B/3411 is a Boron-modified brazing flux used in a wide variety of joining applications for many different finished products including; carbide tools, stainless steel, large steel parts or processes requiring a long heating cycle.

PHYSICAL PROPERTIES

Form	Creamy Paste
Color	Dark Brown
Specific Gravity	1.6
Water Content	24%
Flash Point	None
Freezing Effects	None
Active Temperature Range	565-925ºC/1,050-1,700ºF

This Product is RoHS Compliant

SPECIFICATIONS

- AMS 3411
- AWS A5.3l-91, TYPE FB3C
- Federal Specification 0-F-499, Type B

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APPROPRIATE FILLER METALS

- BAg
- BCuP

DIRECTIONS

Superior No. 604B/3411 may be used in concentrated form or diluted with water to a thinner consistency. Heating the flux to 60-82ºC/140-180ºF 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.

1. Remove any oil, grease, or other contaminants from the surface to be brazed.
2. Apply flux to joint by dipping, swabbing or brushing area being brazed. The flux may be used as supplied or diluted.
3. Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux.
4. Feed the braze alloy into the joint, unless a brazing preform is already in place.
5. 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.

SAFETY PRECAUTIONS

Superior No. 604B/3411 contains potassium bifluoride (CAS #7789-29-9) and potassium fluoborate (CAS #14075-53-7) 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. 604B/3411 has a two (2) year shelf life when stored properly.

Refer to MSDS for additional safety information.

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