



SUPERIOR No. 14



ALUMINUM WELDING FLUX

DESCRIPTION

Superior No. 14 is a powder flux for welding aluminum and aluminum based alloys, with a useful temperature range of 570° - 700°C/1050° – 1300°F. It was especially designed for welding 52-S, and the pure 2-S aluminum sheet employed in aircraft. The flux is an excellent solvent for aluminum oxide, promoting strong weld joints free of oxide inclusions.

APPLICATIONS

Superior No. 14 is used for the welding of aluminum metal and most common alloys in sheet, extruded and cast form. It works best with oxy-acetylene gas torches using 1100 series aluminum filler rod. It works well in selected induction and furnace applications.

DIRECTIONS

The base metal should be cleaned thoroughly to remove dirt, grease and other impurities. **Superior No. 14** may be used in a powder form or mixed with water to make a paste. Brush flux onto the work area, preheat filler metal rod and dip into the flux, then weld as usual. Flux residues are completely soluble in hot water at 60°C/140°F or hotter.

PHYSICAL PROPERTIES

Form	Powder
Color	White
Specific Gravity	2.4 (Average)
Volatile Content	0.3%
Humidity Effect	Hygroscopic
Active Temperature Range	570-1050°C – 700-1300°F
This Product is RoHS Compliant	

SPECIFICATIONS

AMS 3414

SAFETY PRECAUTIONS

Superior No. 14 contains inorganic alkali chlorides and a fluoride and should only be used in well ventilated areas. Avoid breathing dust and fumes produced during welding. Avoid contact with skin, eyes and mucous membranes. In case of eye contact, flush freely with water and call a physician immediately. Keep away from heat, moisture and water, as they reduce shelf life. Return flux to sealed container to prevent caking.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

Superior No. 14 has a two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

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