



# SUPERIOR No. 16



## TITANIUM BRAZING FLUX

### DESCRIPTION

**Superior No. 16** is a powder flux designed for torch brazing Titanium and Titanium-based alloys, with an active temperature range of 1,200 - 1,830°F / 650 – 1,000°C. It promotes strong braze joints in Titanium parts without subjecting them to extreme temperatures. This flux can be used without the removal of the alpha-layer involving acid or caustic pre-treatment.

### APPLICATIONS

**Superior No. 16** can be used to braze Titanium, Ti6AL4V, and many of its common alloys with gas-oxygen torches. This flux can also work in induction and furnace brazing applications using controlled atmospheres. Used in aerospace and a wide variety of industrial applications, including eyeglass frames.

### PHYSICAL PROPERTIES

Form	Powder
Color	White
Bulk Density	1.3
Flash Point	None
Volatile Content	Less than 0.5%
Freezing Effect	None
Humidity Effect	Slightly hygroscopic
Active Temperature Range	650 – 1,000°C/1,200 - 1,830°F

**THIS PRODUCT IS RoHS COMPLIANT**

### RECOMMENDED FILLER METALS

- Brazing Alloy BAg-8 (1,435 – 1,650° / 780 - 900°C)
- Aluminum

### DIRECTIONS

Clean Titanium with acetone to remove oils, grease and other impurities. **Superior No. 16** can either be used as supplied, or mixed with enough water to meet a specific viscosity range.

### SAFETY PRECAUTIONS

**Superior No. 16** contains inorganic chlorides and fluorides and should only be used in well ventilated areas. Avoid contact with skin and eyes and avoid breathing fumes produced in brazing. Keep away from heat, moisture and water as they reduce the shelf life.

**Superior No. 16** has a two (2) year shelf life when stored properly. Refer to the Material Data Safety Sheet (MSDS) for additional information.

*Superior manufactures quality fluxes. Our business is solving problems.*



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