



# MAGENTA FLUX

## Typical Properties:

|                          |                            |
|--------------------------|----------------------------|
| Form:                    | Paste                      |
| Color:                   | White                      |
| Specific Gravity:        | 1.5                        |
| Water Content:           | Less than 3.5%             |
| pH:                      | 9.5+/-0.2                  |
| Flash Point:             | none                       |
| Freezing Effects:        | none                       |
| Active Temperature Range | 485°C/900°F - 870°C/1600°F |

## Brazing Techniques:

FLUX 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 140°F/60°C). Chipping or grinding is not necessary.

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