**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.