



## WELDCOTE BLACK PASTE FLUX

- ▶ Formulated as a general-purpose, silver brazing flux.
- ▶ Brazes copper, brass, nickel, carbon steel, stainless steel, and precious metals.
- ▶ Residues are water-soluble.

### DESCRIPTION

**Weldcote Black Paste Flux** is a creamy, black silver brazing paste flux that is active and protective to 980°C/1,800°F. It was formulated for the majority of brazing operations, and is recommended for use with copper and copper-based alloys, steel, stainless steel, nickel, carbides, precious metals and heat-resistant alloys. **Weldcote Black Paste Flux** is available in dispensable form suitable for spraying or other automatic application methods. The flux will not harden or crystallize, retaining its creamy texture up to two (2) years.

### APPLICATIONS

**Weldcote Black Paste Flux** is a general purpose brazing flux used in a wide variety of joining applications for many different finished products including; appliances, automotive, carbide tools, dental tools, orthodontia, farm machinery, heat exchanges, heat equipment, maintenance, mining tools, musical instruments, plumbing fixtures, refrigeration and air conditioning, ship repair, steel furniture and welding equipment.

### PHYSICAL PROPERTIES

Form	Creamy Paste
Color	Black
Specific Gravity	1.6
Water Content	Less than 35%
pH	8.3 ± 0.2
Flash Point	None
Freezing Effects	None
Active Temperature Range	540°C/1,000°F – 980°C/1,800°F

### APPROPRIATE FILLER METALS

- ▶ BAg
- ▶ BCuP

## SPECIFICATIONS

- ▷ AMS 3411
- ▷ AWS A5.31-92, TYPE FB3C
- ▷ Federal Specification 0-F-499, Type B

## DIRECTIONS

**Weldcote Black Paste 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.

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

**Weldcote Black Paste Flux** 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.

**Weldcote Black Paste Flux** has a two (2) year shelf life when stored properly.

Refer to MSDS for additional safety information.

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.