



WALLCOLMONOY
HI TEMP BRAZING ALLOYS



The all-purpose flux for brazing filler metals. Promotes wetting action for better brazements.

WALLCOLMONOY LTD. (UK)
TECHNICAL DATA SHEET

Nicrobraz[®] Flux

For Brazing With Nickel,
Gold, Silver, or Copper
Filler Metals, Using Torch,
Induction or Furnace

Description:

This high-quality flux dissolves oxides and promotes the flow of Brazing Filler Metals in any type of stainless steel or high-temperature metal. The melting point of Nicrobraz Flux is below 1300°F (700°C), and it decomposes slowly and will not run off through its range of effectiveness, 1600 - 2200°F (870° - 1200°C).

Nicrobraz Flux is used in torch-brazing, induction-heating applications, and in atmosphere brazing furnaces, using a wide range of filler metals.

Form Available:

Nicrobraz Flux is a creamy paste that retains its smooth consistency even when thinned in water. It will not separate or crystallize. It is supplied in 0.5 -kg. jars.

It is also a constituent of Nicrobraz Flux-Powder Paste, a premixed combination of Nicrobraz nickel-based Brazing Filler Metal and Nicrobraz Flux.

Nicrobraz Flux has a minimum shelf life of 2 years. Thickening due to evaporation may always be corrected by adding water.

Recommended Application Procedures:

(1) Nicrobraz Flux should be liberally applied to all surfaces to be joined, and adjacent surfaces that are to be kept free of oxidation. Nicrobraz Flux may be thinned with water to suit whatever application method is desired: brushing, dipping or spraying.

(2) The flux should dry before brazing, either in air or by slow heating.

(3) When torch brazing stainless steel or superalloy components, first heat work to melt flux and then braze using a neutral flame. Refer to "Torch Brazing with Nicrobraz Paste and Rod".

(4) When furnace brazing stainless steel alloys in exothermic or other atmospheres, where the dew point is too high to prevent oxidation, Nicrobraz Flux can be used to good effect. For this use it should be very thin: start with a ratio of one part flux to six parts water. Nicrobraz Flux-Powder Paste or Nicrobraz 'S' Filler Metals can be used. If powdered filler metal is used with Nicrobraz Cement to hold it in place, flux should be applied over it (after cement is fully dry).

(5) After brazing, the flux residue may be removed with hot water, steam, or commercial flux remover. Choice of method depends upon speed of removal desired.

Safety:

Nicrobraz Flux contains inorganic fluorides and is moderately corrosive to both metals and skin. Avoid skin contact. Limit time between application and brazing as much as possible to avoid corrosion of sensitive base metals. When handling metal powder alloys, avoid inhalation or contact with the skin or eyes. Conduct application operations in a properly ventilated area. For more information, consult, OSHA Safety and Health Standards available from U. S. Government Printing Office, Superintendent of Documents, P. O. Box 371054, Pittsburgh, PA 15250, and the manufacturer's Material Safety Data Sheet (MSDS). Read and understand the manufacturer's material safety data sheet before use.

The information provided herein is given as a guideline to follow. It is the responsibility of the end user to establish the process information most suitable for their specific application(s). Wall Colmonoy Limited (UK) assumes no responsibility for failure due to misuse or improper application of this product, or for any incidental damages arising out of the use of this material.

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