

## Handy Flux® B-1 Dry

### ***GENERAL DESCRIPTION***

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Handy Flux B-1 Dry is an active fluoride/borate-type flux in powder form, which has been specially formulated to provide excellent protection of parts up to 1700°F (927°C). It is recommended to use this product with braze filler metals that flow between 1100°F (593°C) - 1700°C (927°C).

### ***PRODUCT APPLICATION***

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Handy Flux B-1 Dry is primarily used as a general purpose brazing flux in brazing applications involving brazing of high chromium stainless steels, steel, copper and copper alloys, nickel and nickel alloys, tungsten, tungsten carbides, chromium carbides and molybdenum alloys. It is not recommended to use in aluminum bronze or other aluminum alloy brazing applications. Handy Flux B-1 Dry is suitable for use with most heating methods including torch, induction or furnace. The product exhibits excellent shelf life if stored in a dry place between 65°F (18°C) - 75°F (24°C).

### ***POST CLEANING***

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This product is corrosive and a post braze cleaning or rinsing operation is required. The flux residue is easily dissolved in hot water at temperatures of 120°F (49°C) or higher.

### ***WARRANTY & STORAGE***

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Lucas-Milhaupt, Inc. warrants their Dry Fluxes for twelve months from the date of shipment if stored in the original, unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry with a relative humidity of 50% or lower. It is not uncommon for the dry flux constituents to aggregate overtime. This has, however, not shown to affect the performance of the dry flux products.

Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application.

### ***AVAILABLE PACKAGING***

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Handy Flux B-1 Dry is available in a variety of packaging options including 1/2 lb, 1 lb, 5 lb, 25 lb and 50 lb containers.

### ***SPECIFICATIONS***

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Handy Flux B-1 Dry conforms to the following specifications: N/A

### ***APPLICABLE PRODUCT CODE(S)***

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-024.

### ***SAFETY INFORMATION***

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The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for Handy Flux B-1 Dry.

## ***WARRANTY CLAUSE***

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