

Handy Flux[®] SLSB

GENERAL DESCRIPTION

Handy Flux SLSB is a boron modified, smooth and creamy paste flux which has been specially formulated to give excellent adhesion when brushed on parts. This product has limited water separation during storage. Due to its excellent product consistency, Handy Flux SLSB has negligible crystal growth reducing product variation. When used with appropriate braze filler metal, Handy Flux SLSB will provide adequate fluxing action to join most ferrous and non-ferrous metals producing high strength and hermetically sealed joints. It is recommended to use with filler metals that flow between 1100°F (600°C) - 1700°F (926°C). The flux provides excellent protection of parts up to 1700°F (926°C).

PRODUCT APPLICATION

Handy Flux SLSB is primarily used as a general purpose brazing flux in brazing applications involving brazing of steel, high chromium stainless steel, tungsten, tungsten carbide, chromium carbide, copper, copper alloys, nickel, and nickel alloys and molybdenum. It is not recommended to use in aluminum bronze or other aluminum or titanium bearing alloy brazing applications.

Handy Flux SLSB is suitable for use with most heating methods including torch, induction or furnace. This product is not recommended for use in a vacuum or controlled atmosphere furnace brazing operations.

Handy Flux SLSB exhibits excellent adhesion, oxide removal capabilities and less spattering during brazing process. This product exhibits restrictive properties when molten and does not require drying prior to brazing and it will remain in place and not flake off or blow off assemblies during the brazing process.

Handy Flux SLSB should be stirred before each use. Handy Flux SLSB may be thinned with distilled or deionized water.

POST CLEANING

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 (50°C) or higher.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Water Based 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), cool and dry.

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. Flux beyond the warranty may be reconstituted to a working consistency by warming in a water bath and or by additions of distilled or de-ionized warm water.

Flux may require mixing, dilution or warming to regain its normal consistency prior to use. Flux, when placed on a U.S. standard 40 mesh (425 micron) sieve conforming to ASTM E11 and worked lightly with a brush shall pass completely through the sieve. If the flux has partially coagulated in the container, the flux may, before conducting the test, be warmed in a water bath until it has returned to its normal consistency.

AVAILABLE PACKAGING

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

SPECIFICATIONS

Handy Flux SLSB conforms to the following specifications:

- American Welding Society (AWS) A5.31 FB3C
- Society of Automotive Engineers (SAE) / AMS 3411

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-098; 73-230; 73-231.

SAFETY INFORMATION

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 SLSB.

WARRANTY CLAUSE

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.