



Quality Management System  
in accordance with  
**ISO 9001:2000**  
Cert # 05-R0925

# SUPERFLOW<sup>®</sup> BLACK BRAZING FLUX

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



## ALLOY DESCRIPTION AND APPLICATION:

*SUPERFLOW<sup>®</sup> Black Brazing Paste Flux* is known as a hi-test brazing flux used with Silver brazing alloys and Phos-copper alloys such as *SUPERFLOW<sup>®</sup> 45* and *SUPERFLOW<sup>®</sup> 15*. It is formulated to work at higher temperatures and longer brazing cycles. This creamy black flux is commonly used to join any combinations of stainless steels, carbides, nickels, steels and may also be used on copper, brass and bronze. It is formulated not to harden or crystallize retaining its smooth creamy texture for a minimum of one year. *SUPERFLOW<sup>®</sup> Black Brazing Paste Flux* may be used in its current form or if needed water may be added to make a thinner consistency. For best results heat the flux indirectly - bring the base metal up to the needed temperature then after the braze cools clean the flux residues using a hot water at about 140° F

## PHYSICAL DATA:

Active Temperature Range	1050-1700°F (565-925°C)
Form & Color	Black Creamy Paste
Water Content	Less than 35%
pH	8.0-8.5
Specific Gravity	1.6
Flash point	None
Effects of Freezing	None
Residues	Water -Soluble

## AVAILABLE SIZES:

TAF SBPW =6oz brush cap, 1/2# jars , 1# jars

## SPECIFICATIONS:

**AWS** A5.31  
**AMS**  
**FED** O-F-499

**FB3-C**  
**3411**  
**Type B**



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