



TECHNICAL INFORMATION SHEET

HARRIS 800 CAST IRON WELDING FLUX

DESCRIPTION:

800 welding flux is a red powder all-purpose cast iron oxy-fuel welding flux. This highly active flux can be used dry by dipping the heated rods into the powder or mixing with water to make a paste.

APPLICATION:

Pre-clean the casting to remove oil, grime then wire brush the surface. The flux can be formed into a paste by mixing with approximately 20% water or until a thick paste consistency is achieved. Welding rods may be heated and dipped into the dry powder flux. The flux will adhere to the heated rod to be applied to the base metal during the welding operation. Follow correct cast iron welding procedures that generally include preheat and slow cool.

ACTIVITY RANGE:

1400°F- 2200°F (760°C-1204°C)

FLUX REMOVAL:

Post braze weld flux residue should be removed to avoid potential corrosion. A hot water wash and brushing with hot water. Production post-braze cleaning can also be accomplished with proprietary chemical formulas such as Bernite® 45 available from Harris Products Group. This approach is suitable where parts lend themselves to a water bath/tank immersion.

AVAILABLE CONTAINERS:

1 lb. containers

SPECIFICATION COMPLIANCE:

Harris Internal Specification

SAFETY INFORMATION:

WARNING: CONTAINS FLUORIDES.

PROTECT YOURSELF AND OTHERS. Read and understand this information.

BURNS EYS AND SKIN. CAN BE FATAL IF SWALLOWED

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheet (SDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

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