



TECHNICAL INFORMATION SHEET

DYNAFLOW® BRAZING FLUX

DESCRIPTION:

Dynaflow flux is a white paste silver brazing flux designed for brazing copper, brass, bronze, steel, and other ferrous base metals. The flux is formulated to provide a smooth consistency that makes it an ideal choice for automated or semi-automated dispensing. Dynaflow flux is a proprietary mixture of boric acid and fluoride compounds designed for optimum temperature activity and metal protection.

ACTIVITY RANGE:

1050° – 1600° F (566° – 871° C)

FILLER METALS:

Dynaflow flux is an excellent choice for use with silver braze alloys – Most AWS A5.8 BAg classifications and ISO 17672 class Ag compositions. The flux is also suitable for use with many phosphorus-copper-silver alloys, (AWS BCuP and ISO CuP), for brazing copper to brass.

FLUX REMOVAL:

Flux residues should be removed after brazing to prevent potential long term corrosion. Flux residue can usually be removed by washing with hot water. If flux has absorbed a large amount of oxides chemical or mechanical cleaning may be required. Proprietary cleaning compounds are available such as Bernite®45, (available from Harris Products Group). Other methods such as steam jet, wire brushing, or mechanical grinding may be necessary for heavily oxidized surfaces.

AVAILABLE CONTAINER WEIGHTS:

420 gram brush cap, 5 lb.(2.27 kg) Jar, 25 lb. (11.34 Kg), pail, 50 lb. (22.68 Kg),Pail

SPECIFICATION COMPLIANCE:

AWS A5.31 Class FB3A
AMS 3410
Federal Specification O-F-499, Type B
EN 1045 Type FH10

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, Material Safety Data Sheets (MSDS), 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

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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