



## TECHNICAL INFORMATION SHEET

### SOLAR FLUX TYPE B

#### DESCRIPTION:

Solar flux type B is a powder that can be mixed with alcohol (methanol preferred) Shelf life is infinite in its dry powder state. This flux is unaffected by freezing, it has no flash point and is non-explosive. Two ounces of Solar Flux type B properly mixed and applied covers 80 linear feet of joints. You can use Solar Flux Type B on stainless steel and high chromium alloys.

#### Nominal Composition

Proprietary Information

#### APPLICATION:

Solar flux type B can be used as a back purge flux to eliminate purging on small jobs. Type B Solar flux is used for welding stainless-steel except for 309 and 310, precipitation hardening steels, chrome-moly steels, and other steels with nickel content below 25%. Some piping systems require absolute purity from flux residue. Such piping systems such as food processing, beverage lines, medical oxygen lines where the flux residue can't be removed. It is best then to not use Solar flux and use a nitrogen purge to stop oxidation.

#### ACTIVITY RANGE:

Welding active range 2000F°- 2900F° (1093C°-1593C°)

#### FLUX REMOVAL:

Recommended flux removal process is sand blasting or chipping. Flux on stainless steels and nickel-based alloys may be removed in a hot pickling bath (160F-170F) in six to seven minutes. Recommended bath composition is 3%-4% hydrofluoric acid and 10%-20% nitric acid by volume with a balance of water. This pickling bath is not to be used on mild steel or alloys containing less than 16% chrome and 8% nickel.

#### AVAILABLE CONTAINERS:

1lbs containers

#### SPECIFICATION COMPLIANCE:

Military Specification MIL-F-7516B, classes 2 and 4  
Meets the Buy American Act

#### 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 a 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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