



TECHNICAL INFORMATION SHEET

HARRIS 600 BRAZING FLUX

DESCRIPTION:

600 brazing flux is an all-purpose powder flux for use with bronze alloys such as Welco 15. This highly active flux can be used dry by dipping the heated rods into the powder or mixing with water. Applications include steels, cast irons and also copper base alloys. Residues may be removed with a hot water rinse leaving a bright, clean, strong and porosity free brazed joint.

Nominal Composition

Boric Acid
Borax

APPLICATION:

The flux can be formed into a paste by mixing with approximately 20% water or until a thick paste consistency is achieved. Braze 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 brazing operation.

ACTIVITY RANGE:

1400° - 2200° (760° - 1204°)

FLUX REMOVAL:

Post braze flux residue should be removed to avoid potential corrosion. A hot water wash and brushing with a rag or non-woven abrasive pad, (e.g. Scotch-Brite™), is often sufficient. Additional measures include mechanical cleaning with a wire brush, steam jet, or abrasive blasting media such as grit, soda, or dry ice.

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 lbs. containers

SPECIFICATION COMPLIANCE:

AWS A5.31 CLASS FB3-J

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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