

## SMF G50 Paste

## Brass Brazing

## Fluxes

### Classifications:

Standard : EN 1045 FH 21  
Identification : Name Printed

### Characteristics:

Senor SMF G50 is a paste type flux for braze welding /brazing of copper alloys, carbides, carbon & galvanized steels. This is useful for torch, induction or furnace heat brazing. Also used when brazing with low fuming bronze, nickel bronze and brass brazing alloy. Residues can be easily removed. This gives high fluxing activity with good wetting and spread and gives nice visibility while brazing. (no sodium glare).



### Applications:

- 1) Automobile Industries
- 2) Cycle manufacturing
- 3) Home Appliances
- 4) Furniture Industries,
- 5) Tools manufacturing

### Properties:

Activity range : 750°C - 1150°C  
Activity : Good  
Fluidity : Good  
Flux residues : Non corrosive  
Capillary : Medium  
Life : High

### Flux Removal :

To obtain best results wire brush with hot water (60°c) or dip in hot diluted caustic soda.

Packaging (kg) : 1.0

## General Instruction

Remove oil, grease or other contaminants from the surface to be brazed / weld. Keep away from heat, moisture and water. These fluxes are hygroscopic in nature. Return flux to sealed container to prevent Caking. These fluxes are mild chemicals, ensure proper hygiene care.

## Note On Usage:

1. The Flux may be used in Powder form or mixed with water to make paste. In case of paste form the flux may be used as supplied or diluted.
2. Heat the end of the filler metal rod and dip into the flux, or sprinkle the flux on the work piece. In case of paste apply flux to the joint and filler metal by brushing or dipping.
3. Apply heat, by torch, induction or other means to activate the flux.
4. When proper temperature is reached, the flux will liquefy and rapidly flow into the joints. Feed the filler alloy into the joint, continue heating until the filler metal fills the joints, producing shiny fillets.
5. After brazing / welding clean flux residues from brazed / weld joint using hot water (60oC) for best result. If unavailable, room temperature water may also be used.

**Above are basic guidelines and will vary depending on joint design, number of passes and other factors.**

## **⚠WARNING Ⓣ**

Protect yourself and others.

Fumes and Gases can be dangerous to your health. Burns Eyes and skin on contact. Can be fatal if swallowed.

- Before use, read, understand, and follow manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the work, or both, to keep fumes and gases from your breathing zone and the general area.
- Avoid contact of flux with eyes and skin.
- Do not take internally.
- Keep out of the reach of children.

## See:

1. American National Standard Z49.1, Safety in Welding and Cutting published by the American Welding Society,
2. OSHA Safety and Health Standards, 29CFR 1910.

## First Aid:

If flux contacts eyes, flush immediately with clean water for at least 15 minutes. If swallowed, induce vomiting. Never give anything by mouth to an unconscious person. Call a physician.