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## **10 Steps to Super Alloy 1**

- 1. Pre-clean the parent metal or metals to be joined. Use emorycloth, wire-brush, bead-blasting, etc.**
- 2. Apply the non-corrosive, liquid flux to the repair area. An easy method of application is to dip the end of the rod into the flux. The flux will cling to the rod and is easily spread with the rod.**
- 3. Use a soft flame, heat gun, or soldering iron to heat the parent metal adjacent to the actual repair. A direct flame on the repair area is likely to overheat the solder and flux.**
- 4. Hold the torch tip four to six inches away from the parent metal. If it is necessary to apply the flame directly on the rod and flux pull the torch tip back even further from the work surface and keep the torch moving.**
- 5. The flux will begin to bubble and turn light brown. Besides preparing the parent metal for the solder, these changes indicate the proper working temperature. If the flux turns black, clean-up the area and start over.**
- 6. When the flux turns brown it is time to apply the rod. Drag the rod over the area to be soldered until it begins to flow and stop applying the heat. If additional layers are needed, continue dragging the rod over the area.**
- 7. Sometimes it is advisable to heat the tip of the rod with the flame to help the solder flow easier and quicker onto the repair area. Do not heat the rod to the melting point.**
- 8. Observe the deposit. The solder should bond smoothly, DO NOT OVERHEAT! The rod will melt if overheated, but it will just lay there and fail to bond properly.**
- 9. If you have stopped the soldering process too soon and want to flow the deposit out more, add more flux and reheat. The flux will help in the bonding process whether adding more rod or just flowing out the previous deposit. If you have stopped the welding process too soon and want to flow the deposit out some more, add more flux by repeating steps 1 and 2. The flux will help the bonding process whether you are adding more rod or just flowing out the previous deposit.**
- 10. Remove excess flux with warm water and a wire brush.**