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## **10 Steps to Super Alloy 5**

- 1. With your torch, heat the tip of your rod and dip it in the jar of flux. The flux will adhere to the rod and allow you to transfer it to the weld area.**
- 2. Melt the flux of the rod onto the weld area and remove the rod without removing the flame from the work surface.**
- 3. Constantly move the flame across the repair area. This will help to eliminate hot spots. Remember, you are trying to heat the parent metal to attract the rod, do not try melting the rod into place.**
- 4. Use a carburizing flame. This is a flame with less oxygen or compressed air. This softens the flame and allows the work area to reach proper temperature with less risk of damage.**
- 5. Hold the torch tip four to six inches away from the weld surface. Keep the flame perpendicular to that surface if possible. Move the flame back and forth, not in circles.**
- 6. Continue moving the flame as described until the flux becomes a watery consistency. Thorough heating prior to adding the rod will result in better bonding and rod flow.**
- 7. WITHOUT pulling the flame away, apply the rod softly onto the repair area. Do not press the rod down. If the rod "balls up" on the end, pull the rod away again without removing the flame. Heat the area a little longer and reapply the rod as before.**
- 8. Watch for the rod to flow out. When it begins flowing, pull flame away.**
- 9. 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 in 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.**