SSF-6 Instructions

1. Prepare metal using sand paper, emory cloth, wire brush, Dremel tool, steel wool, a sander, or a wire wheel.
2. After cleaning metal, preheat generally to 350° F
   Heat the joint area to 800° F.
3. Melt off some flux and allow it to flow throughout the joint.
4. Add alloy while heating the deposit and the parent metal until the deposit has completely flattened and flowed out.

SSF-6 Tips

- Clean base metal before soldering.
- Never heat metal bright red, as this can impede the flow of SSF-6.
- The key to any brazing or soldering with a torch is a fair amount of preheating of the adjacent work area. Broadly preheating beforehand reduces the surrounding metal from pulling heat away from the targeted area. This will always ensure a better result.
- Allow the flux to work momentarily before adding the rod.
- Flow out each drop of rod before depositing more.
- If the rod balls up, the base metal is too cold-- back the brazing rod up and heat the base metal in a broad fashion.
- A flat braze will result in the best seal and bond.
- Almost any torch can be used, including: propane, MAPP gas, natural gas and air, straight acetylene, or oxy-acetylene. The cheap brass tips do net work well in most cases. On thin metal or small parts, propane or MAPP gas works fine. Use an oxy-acetylene with heavy gauge metals.
- To build up, use slightly less heat when depositing rod. The bridge small

gaps and holes, apply some rod around the hole or gap then use less heat to bridge the desired area. More heat will make the rod flow thinner and it can fall through.

- If the rod is in place and you want more flow, add more flux.
- After brazing, let the part air cool naturally to achieve the highest strength.
- Warm water and a wire brush will remove any remaining flux.

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