



PRODUCT DATA SHEET

Current: July 1998
Supersedes: July 1995

ASBURY FLUXMASTER

#770 General Purpose Flux

CHARACTERISTICS: ASBURY Flux #770 is a general purpose cleaning and drossing flux which is also used effectively as a cover flux. It promotes low metallic content in the dross and also helps keep furnace walls clean. It has good skimming properties for use in treating drosses. Flux #770 is designed for use in both crucible and reverberatory type furnaces when melt temperature is 1275-1350 °F.

APPLICATIONS:

For use as a **charge cover flux**, spread about 1/4" evenly on the molten heel at the beginning of the heat. Charge metal through this cover until the melt is ready for the dross to be skimmed. Then apply a further quantity of flux over the dross. Stir or rabble the flux into the dross. Wait a few minutes and skim the dross from the furnace. Allow the skimmer to rest on the furnace sill, or remove it with a perforated spoon allowing a few seconds for the metal contained in the skim to flow back into the melt.

For use as a **drossing flux**, turn off the burners and observe the dross. Break any large lumps with the skimmer, rake the dross until even, then sprinkle about 1 lb. of flux/square yard of surface area depending on the oxide depth. Stir or rabble the flux into the dross as evenly as possible. If any large metal beads remain, additional flux is required. Add the flux, close the furnace door, turn on the burners for several minutes, and again observe for metal beads. The combination of additional flux and firing should finish the job. Dross should appear light, powdery and free of excessive metal.

PACKAGING: Fiber drums.....125-lb. and 500-lb