



WELDCOTE GENERAL PURPOSE LIQUID SOLDERING FLUX



General Purpose Liquid Soldering Flux

Formulated for soldering Stainless Steel and High-Chrome Alloys.

Excellent across a broad range of base metals, solders, and temperatures.

Exhibits excellent capillary action.

DESCRIPTION

Weldcote Liquid Soldering Flux is a water-based, general purpose, inorganic-acid flux formulated for soldering stainless steel and other industrial metals. The flux contains Zinc Chloride, Ammonium Chloride, and Hydrochloric Acid, that make this flux active at room temperature where it begins to clean metals and remove oxides. The flux exerts a strong scavenging action to remove oxide coatings and other impurities from the metal surface to produce strong joints. Pre-cleaning is not necessary under most conditions.

APPLICATIONS

Weldcote Liquid Soldering Flux is excellent for use on Stainless Steel, Monel, High-Chrome Alloys, Inconel, Nickel, Copper, Brass, Ferrous Alloys and many more metals. It is not recommended for Aluminum and Magnesium.

DIRECTIONS

Weldcote Liquid Soldering Flux may be applied with a brush, swab or by dipping. The flux exhibits the best activity between 93°C/200°F and 315°C/600°F. Post-solder residues are water-soluble and hot water rinses (140°F or higher) may be adequate for most applications.

The following steps are recommended for optimum soldering results:

- Remove any oil, grease, or other contaminants from the surface to be soldered.
- Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.
- Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.
- Apply solder; dip part, place torch or iron to area being soldered.
- To insure complete removal of flux residues, first use water containing 2% HCl followed by as many hot water rinses as necessary.

PHYSICAL PROPERTIES

Form	Colorless liquid
Specific Gravity	1.326 ± 0.01 @ 20°C
pH	0.1
Flash Point	None
Freezing Effects	None
Residues	Completely water-soluble
Spread Factor	80 Minimum
Recommended Soldering Range	93°C/200°F - 315°C/600°F

SAFETY AND PRECAUTIONS

Weldcote Liquid Soldering Flux is a corrosive product and should be handled with care and the normal precautions taken when working with chemical products.

When soldering with Weldcote Liquid Soldering Flux, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

Due to the presence of zinc, a heavy metal, disposal of post-solder residues and wash-water must be carried out in accordance with local, state, and/or federal environmental guidelines.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.