

# SOLDERING CONCENTRATES

fluxes on basis of zinc chloride

## DESCRIPTION

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Stannol Soldering Concentrates are fluxes on basis of zinc chloride to solder sheet metal constructions and steel, for dip tinning as well as for soldering of poorly wettable surfaces. Stannol Soldering Concentrates are aqueous solutions of zinc chloride and further additives in highest concentration.

**Soldering Concentrate 5030:** Flux for soldering and tinning of steel, iron, zinc and zinc coated sheet with persistent oxide coatings. Stannol Soldering Concentrate 5030 can be applied unthinned or if necessary be diluted with water or with a mixture Spirit/Water (50/50 Vol.) up to a ratio of 1:10. These solutions are sufficient for normally solderable metal parts. The concentrate and its dilutions correspond to DIN EN 29454-1, type 3.1.1.

**Soldering Concentrate 104:** Flux concentrate for soft soldering of copper constructions and for the copper tube installation. It is water dilutable up to a mixture ratio of 1:10 (Vol.). The degree of dilution depends on the solderability of the surfaces. Stannol Soldering Concentrate 104 contains no ammonium chloride and conforms to DIN EN 29454-1, type 3.1.2

**Soldering Concentrate 5050S-Nirosta:** Stannol Flux Concentrate 5050S-Nirosta is activated with mineral acids. By means of this additional activation stainless steel, which is not solderable with common fluxes, can be tinned and soldered. This flux conforms to DIN EN 29454-1, flux type 3.2.2 (formerly F-SW 11).

## APPLICATION

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Stannol Soldering Concentrates can be applied with an acid-resistant brush or by dipping. The surfaces treated with soldering concentrate can be heated up with a soldering iron, a blow torch (propane/butane) or other procedures. Since zinc chloride evaporates only at extremely high temperatures, it remains active up to more than 500°C. All usual solder alloys are suitable; the most common are S-Sn60Pb40 with a small melting range of 183 - 190°C or S-Pb70Sn30 with a wide melting range of 183 - 250°C. Also lead free alloys e.g. S-Sn97Cu3 are applicable, particularly for soldering of drinking water pipelines or articles, which come into contact with food.

The flux residues are highly corrosive and must be removed with water after soldering. The flux residues are water soluble. Increased temperatures and the additive of detergents improve the cleaning result. These fluxes are not suitable for applications in electro-technical and electronics manufacturing. **Disposal: Dispose only into hazardous waste, not into the domestic refuse.**

## SHELF LIFE

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2 years after date of delivery (provided proper storage in originally sealed container).

## HEALTH AND SAFETY

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Before using please read the material safety data sheet carefully and observe the safety precautions described.

## **NOTICE**

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The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.