

# Technical Bulletin

## TSC S26 Flux

### DESCRIPTION

TSC S26 Flux is a phosphoric acid based flux designed primarily for the soft soldering of stainless steels. These metals are often difficult to solder due to the tough oxide layer present on the surface of the steel alloys. The effective fluxing action of S26 removes these oxides, producing a clean surface for the solder to wet.

### FEATURES & BENEFITS

- High activity flux – allowing soft soldering of stainless steel, zinc, galvanised metals, pewter, nickel, nickel-chrome and Monel metal (nickel-copper).
- Milder action than traditional zinc chloride fluxes – resulting in a cleaner joint. Post soldering flux residues easily removed by a water wash.
- Ideal for use with various solder alloy grades, S26 works particularly well with Sn60 Pb40 solder (ISO 9453, Alloy No.2). If the joint has to be lead free, then CEAMG's Sn99 Cu1 grade solder (ISO 9453 Alloy No.23) should be used.

### APPLICATION METHODS

The method of flux application can be adapted to suit the particular soldering operation. The most popular method is to use a brush to apply the flux to the joint area, being careful not to over-apply it. When heat is introduced, the flux will begin to work effectively so that when the solder is applied, the joint can be formed. Any remaining post-soldering flux residues can be easily removed by washing in water.

### TECHNICAL SPECIFICATIONS

	<b>Specifications</b>
Appearance	Clear, water white liquid
Density	1.69 gcm-3 @ 20°C
Odour	Odourless
Solubility	Easily soluble in cold, hot water

### STORAGE

TSC S26 Flux is supplied in 125ml, 250ml and 500ml containers. Liquid flux should be stored in dry, well-ventilated area, away from direct heat and flame. Shelf life is 36 Months from date of manufacture.

### HEALTH & SAFETY

Contains ingredients classified as hazardous. Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

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