

# SOLDER CONNECTION

## Technical Bulletin



## S26 Flux

### DESCRIPTION

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 AND 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

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.

### AVAILABILITY

500ml plastic containers.

### PHYSICAL/CHEMICAL PROPERTIES

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

### HEALTH AND SAFETY

Observe standard precautions for handling and use of corrosive liquids. Eye and skin protection must be provided. Avoid breathing fumes evolved during soldering. Adequate fume extraction should always be provided. For detailed information refer to the relevant Health and Safety Data Sheet (MSDS) available on request.

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