



SURCLEAN
Electronic Production Materials



TECHNICAL DATA SHEET

SSF-26 Flux - Soft Soldering Flux for Stainless Steels

PRODUCT APPLICATION

SSF-26 Flux is a soft soldering Flux based principally on Phosphoric Acid for effective solder joining of Stainless Steels. Stainless Steel retains its ability to resist corrosion by formation of a tough refractory surface oxide film which present difficulty when trying to solder by conventional methods. SSF-26 has the required fluxing activity levels and compatibility to allow good soft soldering joints to be made.

CHARACTERISTICS

High flux activity level - Capable of soft soldering of Stainless Steels, Zinc, Galvanized finish Steels, Nickel, Inconel (Nickel Chrome), and Monel (Nickel Copper) Alloys.

Lower activity than Zinc Chloride - Low residue clean joint areas. Residues can be rinsed away with warm water.

Can be used with a variety of soft solder alloys - SSF-26 works with most soft solders with high Tin content above 60 %. Lead free alloys such as 99C, and for maximum joint strength, SN100C, also work very well.

APPLICATION METHOD

SSF-26 Flux is typically applied by brush, but can be varied according to the work piece characteristics. Sufficient Flux should be applied to form a liquid film over the required wetting area and through parts requiring solder coverage. Excess application should be avoided in order to restrict the area of wetting. Once warmed, the Flux will immediately start to clean and de-oxidize the areas of application, and the solder Alloy should be applied as soon as possible once the solder melt temperature is achieved. The Flux residues should be removed as soon as possible after soldering is complete and the work is cool to avoid discolouration of the joint area. Cold water can be used, but warm water is preferable.

PACKAGING AVAILABILITY

Surclean SSF-26 is packed in screw top plastic containers. Standard pack sizes are 250ml, 500ml, 1 litre containers. Larger pack sizes can be supplied subject to availability.

PHYSICAL & CHEMICAL PROPERTIES

Appearance - Clear liquid.	PH - 1.5 (Acidic).	Odour - None.	Flashpoint - None.
Boiling point - 135 deg. C.	Relative density/Specific gravity - 1.58		

HEALTH & SAFETY

Surclean SSF-26 should be treated as a corrosive material. Eye and skin protection must be used. Read the application notes in this technical data sheet, and refer to the safety data sheet for the product.