



# Product information

## Lead free roofer crafts soft solder alloy SnZn-801

Lead free soft solder bar Sn91Zn9 for soldering zinc roofs and gutters, according to DIN EN ISO 9453

Article-No.: 13740120

All information about our products are the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

## Description

For lead free soldering of zinc roof sheets, gutters and drain pipes. It´s also applicable for all available bright and coated zinc alloys on the market. **FELDER SnZn-801** is characterized by very good flow and wetting properties. A soldering seam expertly executed with this solder is permanently watertight and has a high fatigue strength, which corresponds almost to the base material. With its low melting point, it is perfectly matched to the material zinc and offers a large process window.

## Properties

Metallic composition	:	91 % Sn, 9 % Zn
Melting range/point	:	199 °C
Specific weight	:	7,3 g/cm <sup>3</sup>
Working temperature	:	> 200 °C
Recommended iron tip weight	:	minimum 350 g

## Application

First, the parts to be joined must be cleaned. Depending on the type of sheet, the corresponding special flux (see table) is applied. After a short exposure time, solder is first applied punctiform to fix the sheets. Thereafter, the solder is melted on the soldering iron and slowly and uniformly introduced into the soldering seam. Due to the capillary effect, the soldering gap is completely filled with solder. Directly after soldering, the solder joint has to be thoroughly cleaned with water.

FELDER Flux	Material	Application advice
„ZD“	bright rolled zinc	for new and slightly oxidized zinc sheet
„ZD-Spezial“	bright rolled zinc	especially for old weathered zinc sheet
„ZD-pro“	RHEINZINK® prePATINA, sheets NedZink NOVA	Apply soldering fluxwater, leave for approx. 1 minute, then solder as usual.
„ZD-Quartz“	VMZinc Quartz-Zinc and Anthra-Zinc	use as „ZD-pro“
„PowerSurface“	RHEINZINK® GRANUM-sheets	suitable for all bare and coated zinc surfaces! Solvent and flux in one product. Let it take effect briefly and then solder.
„Lösemittel-pro“	RHEINZINK® prePATINA, blue-grey and graphite-grey	Apply solvent, allow to act for 30 seconds, then apply soldering flux and solder as usual.

## delivery form

Extruded flat bar, ca. 230 g, 400 mm long, ca. 20, - kg- cardboard boxes.  
Other rod dimensions and blocks are deliverable on request.

## Advices

**FELDER lead-free soft solder alloys contains no materials, for which exists restrictions in the rules of 2011/65/EU ("RoHS II"), above 0,1 mass-% (0,01 mass-% for cadmium) obtained on the respectively homogeneous material.**

Other alloys are included in our standard delivery programme.