

Soft solder and tinning paste, S-Pb74Sn25Sb1

For tinning and pre-tinning in coachwork industry

Soft solder and tinning paste, S-Pb74Sn25Sb1
Flux according to DIN EN 29454-1, 3.1.1.C.

Article no.: 21256070

Description

Ready to use soft solder metal paste for soldering, tinning and pre-tinning. Flux based on zinc chloride and ammonium chloride in organic preparation with metal powder. Beware, this material is only for using on vintage cars!

Properties

Metal content : 60-70%
Condition : paste-like

The soft solder and tinning paste is ready to use. There is no sedimentation of the metal powder content.

Alloy	Melting range	Processing materials
S-Pb74Sn25Sb1	185-263°C	steel, copper, copper alloys

Processing advices

After the tin plated area has been widely grinded to a shiny extent, the paste will be thinly applied with a brush on the coachwork sheet and will be steadily heated up by a Bunsen burner or a solder lamp. Subsequently you can continue to work with the soft solder Sn92Cu8. The sheet and the soft solder will be heated up with the burner until the solder rods reaches a doughy condition. During the whole application the solder should be kept in a ductile and papescent condition. If sufficient solder is applied it has to be smooth out. For this purpose you have to use a so called tin wood (beech wood) or an aluminium spoon. In order that the solder does not stick on the wood you have to spread it with beeswax or a commercial vegetable fat. The flux residues are corrosive and have to be removed thoroughly with a clean cloth. Afterwards you can polish the excessive solder.

Delivery form:

1,00 kg tin can

Storage advices

Store in closed containers, protect against humidity, insolation and heat exposure.

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

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