



A LINCOLN ELECTRIC COMPANY

TECHNICAL INFORMATION SHEET

Water Soluble Plumbing Flux

DESCRIPTION:

Water-soluble flux is designed for soldering copper water tube. It is formulated so flux residue inside the tube is removed by hot or cold-water flow. This eliminates the potential of long term pitting corrosion sometimes caused by non-dissolved post soldering flux residue.

PHYSICAL DATA:

Soldering temperature range 200°F - 700°F, (93°C - 371°C)

PROPERTIES & USE:

Water-soluble plumbing flux is formulated to stay active through the temperature range required by most lead-free solders. The flux is unexcelled for use in soldering copper, brass, bronze, galvanized and other plumbing fittings. This flux works well with many lead-free solders including Sterling[®], Select, Premium Silver, Solder Safe[™] Lead-Free, 95/5, and 97/3 solders.

Use the brush cap, (or separate brush), to apply flux sparingly on copper tube.

FLUX RESIDUE REMOVAL:

It is good practice to clean the joint after soldering to remove residue. Thoroughly wipe the joint with a hot water soaked wet rag. A second wipe with a wet clean rag is recommended. The goal is to remove the petrolatum residue remaining after soldering.

SPECIFICATION COMPLIANCE:



ASTM B813



Product is certified to NSF/ANSI 61 and conforms to the lead content requirements for "lead free" plumbing as defined by California, Vermont, Maryland, and Louisiana state laws and U.S. Safe Drinking Water Act.

SAFETY INFORMATION:



WARNING: PROTECT yourself and others. Read and understand this information. Wear correct eye, ear, and body protection.

FUMES AND GASES and **VAPORS** can be hazardous to your health.
FLUX IS CORROSIVE: may be harmful or fatal if inhaled or swallowed.
FLUX CAUSES SKIN AND EYE BURNS.
KEEP OUT OF THE REACH OF CHILDREN.
HEAT RAYS, (infrared radiation) from flame or metal can injure eyes.

Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices. Keep your head out of fumes. Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area. See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from U.S. Government Office, Washington, DC 20402 .

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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