SUPERIOR 1265

ALUMINUM PASTE FLUX

- A high activity flux designed for low temperature soldering of Aluminum and Aluminum alloys.
- Paste form ideal for precision dispensing.
- Effective on joining Aluminum to most ferrous and non-ferrous alloys.
- Organic-based, chloride-free.

DESCRIPTION

Superior 1265 is a high activity, organic-based, chloride-free, paste Aluminum soldering flux. Applications in which this flux should be used include: Aluminum-to-Aluminum, Aluminum-to-Copper, Aluminum-to-Brass, and Aluminum-to-plated terminals. Its unique paste form makes this flux ideal for applications requiring dispensing or firm adherence of flux to a particular locale.

Superior 1265 can also be utilized in joining Aluminum to difficult-to-solder metals like stainless steel, kovar, or nickel. Works effectively with 91Sn/9Zn (Eutectic 199°C/390°F) and other tin/zinc plastic phase alloys; also proven to work effectively with other tin-based solder alloys, such as SN100C and 99.3Sn/0.7Cu.

DIRECTIONS

Superior 1265 can be used with all conventional soldering techniques, including soldering iron, torch, furnace, and dip soldering. The soldering temperature must be monitored because the flux chars at 315°C/600°F, which will result in loss of fluxing action. Overheating should be avoided.

The post-solder residues of ***Superior 1265*** are conductive and mildly corrosive. Residues are water-soluble, and an aqueous cleaning process using hot water (60°C/140°F) is recommended as the primary cleaning method. In applications where water cannot be used, methyl or isopropyl alcohols can be used to remove post-solder residues.

PHYSICAL PROPERTIES

Form	Amber Paste
Flashpoint	180°C/355°F Tag Closed Cup Method
pH/10.6% Solution	9.5 +/-0.5 @ 20-25°C/68-77°F
Viscosity	300,000-500,000 cps @ 20-25°C/68-77°F
Recommended Soldering Range	177-288°C/350-550°F

THIS PRODUCT IS RoHS COMPLIANT

SAFETY PRECAUTIONS

Superior 1265 is a corrosive material that emits noxious fumes. Always avoid skin contact and/or breathing vapors. Use with proper ventilation and employing necessary Personal Protective Equipment (PPE) as indicated on material safety data sheet (MSDS). This flux is mildly corrosive to steel and should be stored in sealed glass or plastic containers. Keep away from sparks, open flames, and heat sources. Refer to (MSDS) for additional information. This product has a two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.

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