



SUPERIOR No. 1280



ALUMINUM SOLDERING FLUX

- A high activity flux designed for high temperature soldering of Aluminum and Aluminum alloys.
- Effective on joining Aluminum to most ferrous and non-ferrous alloys.

DESCRIPTION

Superior No. 1280 is a high activity, viscous 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. This flux also performs well in hot dip coating of Aluminum cable connectors to provide a low-electrical resistance contact surface.

Superior No. 1280 can also be utilized in joining Aluminum to difficult-to-solder metals like stainless steel, kovar, or nickel. The preferred solder is a Zinc/Aluminum (98Zn/2Al, 95Zn/5Al) alloy combination.

DIRECTIONS

Superior No. 1280 can be used with all conventional soldering techniques, including soldering iron, torch, furnace, and dip soldering. The soldering temperature must be monitored due to overheating causing the flux action to degrade.

The post-solder residues of **Superior No. 1280** are water-soluble. 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	Viscous Liquid
Specific Gravity of Finished Flux	1.320 +/-0.05 @ 20-25°C/68-77°F
Density	11.01 lbs./Gallon @ 20-25°C/68-77°F
Appearance of Finished Flux	White, semi-separated liquid/powder
Flashpoint	15.6°C/60°F
pH	10.80 +/-0.50 @ 20-25°C/68-77°F
Recommended Soldering Range	650-800°F
This Product is RoHS Compliant	

SAFETY PRECAUTIONS

Superior No. 1280 is mildly corrosive to steel and should be stored in sealed glass or plastic containers. Keep away from sparks, open flames, and heat sources. Avoid skin contact and/or breathing vapors. Use with adequate ventilation. Refer to material safety data sheet (MSDS) for additional information.

The certified shelf-life of this product is one (1) year if stored at room temperature.

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax:
440-349-3003 www.superiorflux.com • e-mail: info@superiorflux.com