SUPERIOR NO. 3350SFM

ZINC-BASED SOLDERING FLUX

- Torch Soldering Flux for Copper, Brass, Nickel, Steel and Stainless steel
- Excellent Rapid Oxide Removal Properties
- Excellent General Purpose Flux for All Heavy Duty Soldering Operations
- Completely Water-based Formulation, No Solvents and No Alcohols

DESCRIPTION

Superior No. 3350SFM is a zinc-based, inorganic acid type flux. The flux exerts a strong scavenging action to remove oxide coatings and other impurities from the metal surface to produce strong joints. The fluxing ingredients of ***Superior No. 3350SFM*** flux offers a high degree of fluxing activity in the soldering and tinning temperature ranges for torch soldering copper, brass, nickel, steel and stainless steel and for all general purpose heavy-duty soldering. Pre-cleaning is not necessary under most conditions.

APPLICATIONS

Superior No. 3350SFM is excellent for use on Stainless Steel, Steel, Nickel, Copper, Brass, other Ferrous Alloys and many more metals. The flux contains Zinc Chloride, Ammonium Chloride, and Hydrochloric Acid that make this flux active at room temperature where it begins to clean metals and remove oxides. It is not recommended for Aluminum and Magnesium**.**

DIRECTIONS

1. ***Superior No. 3350SFM*** can be diluted up to five parts water to one part flux by volume.
2. ***Superior No. 3350SFM*** is normally applied by brush or part immersion at room temperature.
3. Torch or soldering iron soldering can be used because of the ability of this flux to withstand high torch soldering temperatures.
4. Post-tinning residues are water-soluble and can normally be removed, if necessary, in a hot water wash of 60-80°C (140-176°F) followed by drying.

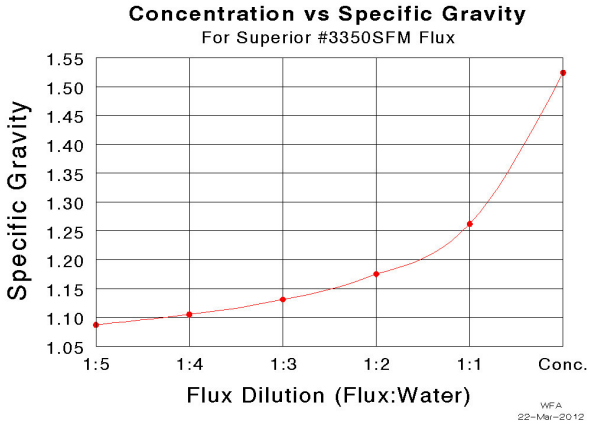
Superior Flux & Mfg. Co. 6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax: 440-349-3003 www.superiorflux.com • e-mail: info@superiorflux.com

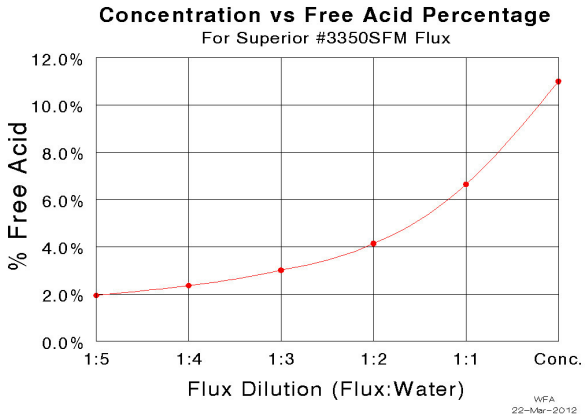
PHYSICAL PROPERTIES

Appearance	Clear, Colorless to Yellow
Specific Gravity @ 20°C (68°F)	1.524 ± 0.015
Density @ 20°C (68°F)	12.8 Lbs./Gallon
Free Acid	11.0 ± 2.0% HCl
Surface Tension	32 dynes/cm minimum
Recommended Soldering Range	500-800°F (260-427°C)
Odor	Mild
Flash Point	None
Freezing Point	None

PREPARATION and HANDLING

Superior No. 3350SFM is shipped as a concentrate to be diluted of up to five parts water to one part flux by volume. For greater strength, lower dilution ratios should be used. Mix well when diluting and check specific gravity with a hydrometer before use. The solution will not separate on standing.





SAFETY PRECAUTIONS

Since ***Superior No. 3350SFM*** attacks many metals to some extent, it is recommended that polyethylene, PVC or fiberglass reinforced polyester containers be used. Any machinery or construction materials, which might be exposed to direct contact with the flux, should also be able to withstand acids.

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

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