SUPERIOR No. 79D

INORGANIC ACID SOLDERING FLUX

- Formulated for soldering Stainless Steel and High Chrome Alloys.
- Non-Fuming and water-soluble.
- Exhibits excellent capillary action.

DESCRIPTION

Superior No. 79D is a non-acid, water-soluble flux formulated for soldering stainless steel and other industrial metals. The flux contains no acids which helps make this flux a non-fuming, self-cleaning soldering flux. The flux exerts a strong scavenging action to remove oxide coatings and other impurities from the metal surface to produce strong joints. Pre-cleaning is not necessary under most conditions.

APPLICATIONS

Superior No. 79D is excellent for use on Stainless Steel, Monel, High Chrome Alloys, Inconel, Nickel, Copper, Brass, Ferrous Alloys and many more metals. It is not recommended for Aluminum and Magnesium**.**

DIRECTIONS

Superior No. 79D may be applied with a brush, swab or by dipping. The flux exhibits the best activity between 95-315°C/200-600°F. Post-solder residues are water-soluble and hot water rinses (140°F or higher) may be adequate for most applications. To insure complete removal of flux residues, first use water containing 2% HCl followed by as many hot water rinses as necessary. ***Superior No. 79D*** should be shaken or stirred prior to use, as some settling of solids may occur.

The following steps are recommended for optimum soldering results:

❶ Remove any oil, grease, or other contaminants from the surface to be soldered.

❷ Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.

❸ Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.

❹ Apply solder, dip part, place torch or iron to area being soldered.

❺ Clean flux residues from soldered area using de-ionized, distilled, RO, and in some cases tap water heated to a temperature of 60°C±5°C /140°F±10°F for best results. Room temperature water may also be used.

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PHYSICAL PROPERTIES

Form	Transparent, colorless liquid
Specific Gravity	1.500 ± 0.050 @ 20°C
Flash Point	None
Freezing Point	-9°C /15°F
Freezing Effects	None
Boiling Point	105°C/221°F Minimum
Spread Factor	80 Minimum
Recommended Soldering Range	95-315°C/200-600°F

THIS PRODUCT IS RoHS COMPLIANT

SAFETY AND PRECAUTIONS

Superior No. 79D is a corrosive product and should be handled with care and the normal precautions taken when working with chemical products.

When soldering with ***Superior No. 79D***, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

Due to the presence of Zinc, a heavy metal, disposal of post-solder residues and wash-water must be carried out in accordance with local, state, and/or federal environmental guidelines.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

Superior No. 79D has a two (2) year shelf life.

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