



SUPERIOR No. 55



LIQUID SOLDER FLUX

DESCRIPTION

Superior No. 55 is a highly concentrated flux that performs well on hard-to-solder metals. It is water-based and contains phosphoric acid and organic acid phosphate. No. 55 exerts powerful scavenging action on refractory and chemically-resistant oxides, removes scale and other impurities, and promotes formation of strong soldered joints.

APPLICATIONS

Superior No. 55 is excellent for use with hard-to-solder metals such as special stainless steels, high-Chromium and high-Nickel alloys, and specially treated ferrous alloys. Do not use on Aluminum or Magnesium.

PHYSICAL PROPERTIES

Form	Clear Viscous Liquid
Specific Gravity	1.150 ± 0.010 @ 20-25°C/68-77°F
PH	1.50 ± 0.50 @ 20-25°C/68-77°F
Conductivity	310 ± 50 @ 20-25°C/68-77°F
Flash Point	None
Freezing Effects	None
Recommended Temperature Range	220-550°F/105-290°C
Spread Factor	80 minimum

THIS PRODUCT IS RoHS COMPLIANT

DIRECTIONS

Superior No. 55 may be applied by brush, swab, spray, or dipping. The flux may be used as supplied, or can be diluted for use with less hard-to-solder metals. **Superior No. 55** reaches peak activity, and is recommended for use, between 105-290°C/220-550°F. If the process requires higher temperatures, the flux will still work. Residues are water-soluble, and should be removed after soldering. Use de-ionized or distilled water heated to at least 60°C/140°F. Addition of one gram of a non-ionic surfactant to four (4) liters of water is recommended to reduce the wash water surface tension and make it more effective as a cleaner.

SAFETY PRECAUTIONS

Superior No. 55 contains phosphoric acid and an organic acid phosphate. The flux is corrosive and can cause burns. Handle with caution. Avoid contact with flux in eyes, on skin or on clothing. Avoid breathing mist. Wash any items that contact flux thoroughly after handling. In case of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes, while removing contaminated clothing and shoes. Wash clothing before reuse. If swallowed, drink plenty of water and call a physician immediately. Keep out of reach of children.

Refer to the Material Data Safety Sheet for Further information.

Superior No. 55 has two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.

