



TECHNICAL INFORMATION SHEET

GENERAL METALWORKS ACID CORE SOLDER

NOMINAL CHEMICAL COMPOSITION %:

Copper	3.5 – 4.5
Silver	0.03 - 0.2
Tin	Remainder

TYPICAL PHYSICAL PROPERTIES:

Melting Temperature – solidus 430°F (221°C)
liquidus 660F (349°C)

DESCRIPTION:

General Metal Works lead free acid core silver bearing solder. Absolutely great solder for working on gutters, tinning on car panels, also works with stainless steel. The solders acid core eliminates the need for additional flux. Not intended for plumbing applications. Flux residue easy to remove. Complies with the EU REACH regulation & RoHS directive.

APPLICATION:

Prior to soldering, clean parts or connection with a brush or Scotch Brite® to remove surface oxide. An air-fuel hand torch, such as a Harris propane or MappPro® torch, is typically used. When additional heat is required, a Harris Inferno® torch with a swirl combustion tip provides rapid and controlled heat input. The Inferno uses air/acetylene, (or other fuel gases) to provide increased heating capability.

Apply heat to part and then apply solder. Avoid melting the solder with just the heating tip or flame.

RECOMMENDED FLUX:

Flux is contained in the solder core. Clean part after soldering to remove flux residue.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.


HEAT RAYS, (infrared radiation) from flames or hot metal can injure eyes.

- Before using it, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Flux may be harmful or fatal if inhaled or swallowed.
- Flux may cause skin and eye irritation.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for a particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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