



## TECHNICAL INFORMATION SHEET

### PASTEWELD PASTE SOLDER

#### NOMINAL CHEMICAL COMPOSITION%:

Lead 49%-51%  
Tin 49%-51%

#### TYPICAL PHYSICAL PROPERTIES:

Solidus 361°F (182°C)  
Liquidus 421°F (216°C)

#### SOLDERING PROPERTIES:

Pasteweld leaded solder is a formulated mixture of tin, lead, and a zinc chloride flux mixture used for torch, iron or furnace soldering. It provides a convenient one-step method of solder application. When heated the binder burns away, the flux becomes active, and when soldering temperature is reached; the metal solder powder melts and completes the solder connection. Pasteweld is not for potable water systems and is not recommended for process that involves products for human consumption. It's generally unsuitable for electrical or electronic, the flux consists of zinc chloride and the flux residue should be removed after soldering.

#### AVAILABLE FORMS

Pasteweld solder is sold in 4 lbs. containers only

#### RECOMMENDED FLUX:

No flux is required, when additional flux is needed Stay Clean flux can be used.

#### SPECIFICATION COMPLIANCE:

Internal Harris specification only

#### 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 flame or hot metal can injure eyes.**

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- 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 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.

#### THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY

4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)