



A LINCOLN ELECTRIC COMPANY

TECHNICAL INFORMATION SHEET

HARRIS HIGH ACTIVITY STAINLESS STEEL FLUX

DESCRIPTION:

High Activity, Stainless Steel Flux is a water-based, inorganic-acid flux formulated for soldering stainless steel and other industrial metals. The flux contains Zinc Chloride, Ammonium Chloride, bi-fluoride, and Hydrochloric Acid. The flux exerts a strong scavenging action to remove oxide coatings and other impurities from the metal surface.

PHYSICAL DATA:

Soldering temperature range
203°F - 797°F, (95°C - 425°C)

PROPERTIES & USE:

High Activity, Stainless Steel Flux is excellent for use on Stainless Steel, Monel, High-Chrome Alloys, Inconel, Nickel, Copper, Brass, and Ferrous Metals. It is not recommended for Aluminum and Magnesium.

DIRECTIONS

Pour flux into a glass or plastic container. Using a plumbers brush or acid brush. Dip brush into liquid flux apply thoroughly as to coat the area solder will be applied.

FLUX RESIDUE REMOVAL:

This is a three-step process to remove flux residue. Apply liquid hand soap to the flux area in conjunction with hot tap water scrub the area with a rag; rinse thoroughly. Then apply soda ash or baking soda and again using hot tap water scrub the flux area and rinse with hot tap water. A final rinse maybe needed with just hot tap water. Repeat as needed.

SPECIFICATION COMPLIANCE:

RoHS compliant
A-A-51145, Type 2, Form B.
(A-A-51145 replaced O-F-506C)
ANSI-J-STD-004, Type INH1.
ASTM B32, Flux Type IS.

SAFETY INFORMATION:



WARNING: PROTECT yourself and others. Read and understand this information. Wear correct eye, ear, and body protection.

FUMES AND GASES and VAPORS can be hazardous to your health.

FLUX IS CORROSIVE: may be harmful or fatal if inhaled or swallowed.

FLUX CAUSES SKIN AND EYE BURNS.

KEEP OUT OF THE REACH OF CHILDREN.

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

Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), 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. See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from 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.

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Additional information available at our web site: www.harrisproductsgroup.com