



TECHNICAL INFORMATION SHEET

40/60 TIN LEAD SOLDER

NOMINAL CHEMICAL COMPOSITION%:

Lead	Remainder
Tin	39.5-41.5
Antimony	0.20 – 0.50

TYPICAL PHYSICAL PROPERTIES:

Solidus	361°F (183°C)
Liquidus	448°F (231°C)

BRAZING PROPERTIES:

With some exceptions, the tin-lead solder can be used to solder copper and most copper alloys, lead, high nickel alloys, and steel. 40/60 is often used for radiator soldering or other applications where a wider melting range solder is useful. Tin-lead solders are not recommended in high stress or vibration joints in the cooling industry due to lack of sufficient elongation properties. Heat sources include soldering guns, irons, and air-fuel torches. ***Lead bearing solders are not to be used in potable water systems.**

AVAILABLE FORMS

Standard wire diameters

RECOMMENDED FLUX:

Stay Clean® soldering flux is recommended for most base metals. Stay Clean is available in liquid and paste form. Remove flux residue after soldering.

Stay Clean is not recommended for electrical or electronic applications which require the use of a rosin flux.

SPECIFICATION COMPLIANCE:

ASTM B32 Alloy Grade Sn 40A,
J-STD-006 Sn40Pb60Sb0.4

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, 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.
- 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.

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