



TECHNICAL INFORMATION SHEET

STAY CLEAN® ALUMINUM SOLDERING FLUX

FLUX DESCRIPTION & USE

Stay Clean aluminum soldering flux is an active flux formulation designed for soldering aluminum and joining aluminum to other metals. The flux is formulated with amines and complex inorganic fluorides and was designed for use with Harris Products Group Alsolder® 500.

It is also a good choice for use with other tin based solders that have a suitable melting temperature.

HEATING

During initial heating avoid directing the flame on the flux. Heat adjacent to the flux and allow heat to be conducted through the base metal. Fluxing action decreases near 600°F (315°C) so avoid overheating.

TYPICAL PHYSICAL PROPERTIES

Working temperature	350°F - 550°F (177°C - 288°C)
Specific gravity	1.30 @ 68°F
PH	7 - 9

FLUX REMOVAL

The flux is slightly corrosive so post soldering residue should be removed with hot water or other suitable cleaner.

AVAILABLE SIZES

Stay Clean aluminum flux is available in 4 oz containers and is included in Alsolder 500 kits, (flux and solder in one package).

SPECIFICATION COMPLIANCE

Harris Products Group internal standard.

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.
- Avoid eye and skin contact.
- Do not take internally.
- Keep your head out of the 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