



Canfield Technologies, LLC

TECHNICAL DATA SHEET CANFIELD WATER-SOLUBLE FLUX Lead-Free



Canfield Water-Soluble Flux is formulated for use in plumbing applications where copper and copper alloy tubes are being soldered. It is also an excellent choice for copper pipes used in heating, air conditioning, mechanical and fire sprinkler systems. Formulated for use on tin/silver as well as all Canfield's lead-free alloys. Can also be used with tin/lead solders.

Canfield Water-Soluble flux meets ASTM Specification B-813 and complies with Copper Development Association requirements.

This is a water based flux that promotes excellent solderability and post solder removal with lead-free solders. Canfield Water-Soluble Flux is creamy white, water flushable paste that holds its shape and will not slump until being heated above 122° F (50°C).

Directions for use:

Apply with brush or swab. The flux exhibits the best activity between 200 - 600°F (93-315°C).

The following steps are recommended for optimum soldering results:

- (1) Remove any oil, grease, or other contaminants from the surface to be soldered.
- (2) Apply flux to joint by swabbing or brushing area being soldered.
- (3) Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.
- (4) Apply solder wire to area being soldered.
- (5) Clean flux residues from soldered area using a water rinse or by wiping off with a wet cloth.

Safety precautions:

Canfield Water-Soluble Flux contains no petrolatum, but contains a small amount of zinc chloride (CAS 7464-85-7) and should be handled with care.

Use adequate ventilation when working with solder and flux. Avoid contact with eyes, skin and mucous membranes. Always wear NOISH approved safety equipment when working with chemicals. Store away from heat.

Disposal of raw flux and flux residues must be carried out in accordance with local and federal environmental guidelines. Refer to SDS for additional safety information.

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