

# SOLDER CONNECTION

## Technical Bulletin



## Blackband

### DESCRIPTION

Black Band is a water based flux containing zinc chloride and other salts, which provide an extremely effective fluxing reaction at soldering temperatures. Black Band is commonly used for soldering copper and its alloys, mild steel and iron in a wide variety of industrial soldering applications (including copper-brass heat exchanger manufacture).

### FEATURES AND BENEFITS

- High activity flux – effective soft soldering of copper, brass, mild steel and iron.
- Water soluble flux residues – easy post soldering cleaning.
- Ideal for use with various solder alloy grades, including a wide variety of tin-lead and lead free soft solders.

### APPLICATION

For most applications, the flux can be applied by brushing, this being the most convenient method of controlling where the flux is placed. Alternatively, Black Band can be sprayed on, or the work-piece can be fully or partially immersed in the flux prior to soldering. When heat is introduced the flux will begin to work effectively so that when the solder is applied, the joint can be formed.

Zinc chloride containing fluxes are corrosive and the post soldering flux residues should normally be removed as soon as possible after cooling of the joint assembly. This can usually be achieved by washing with water, preferably warm. For the most through flux residue removal, initial cleaning should be in dilute hydrochloric acid (2-5%) or citric acid, followed by a final wash in clean water.

### AVAILABILITY

200, 10, 5 and 1 litre containers.

### PHYSICAL/CHEMICAL PROPERTIES

|                      |  |
|----------------------|--|
| Appearance:          | Clear colourless to pale yellow liquid |
| Flash Point:         | Not applicable                         |
| Solubility in water: | Easily soluble in hot and cold water   |
| Odour:               | Characteristic acidic                  |
| Specific Gravity:    | 1.28 @ 20°C                            |

### HEALTH AND SAFETY

Observe standard precautions for handling and use of corrosive liquids. Eye and skin protection must be provided. Avoid breathing fumes evolved during soldering. Adequate fume extraction should always be provided. For detailed information refer to the relevant Health and Safety Data Sheet (MSDS) available on request.

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