THE SOLDER CONNECTION

Technical Bulletin

Issue 1 - 27/07/2014

Fryolux T1333 Solder Paint

Alloys: Leaded / Pure Tin

DESCRIPTION

Fryolux Solder Paint T1333 is an uniform mixture of finely powdered solder and zinc chloride activated flux, having a creamy consistency, for pre-tinning and solder coating. It has been especially formulated to keep the heavy solder powder in suspension and to reduce the settlement of the metal powder and therefore making it easier to restir and an aid to prolong its shelf life.
If the metal powder does settle to the bottom of the container, then this is easily reconstituted with light stirring.

BENEFITS

- High activity flux
- Improved shelf life
- Ease of application
- Paint easily restirred

APPLICATION METHODS

For tinning the article is brushed or sprayed with Fryolux and heated until the solder melts to form an adherent coating.
For soldering, the joint members should be coated before assembly, thus correctly locating the solder in the joint. To complete the joint, heat is applied until sweating occurs.
The solder paint should be applied to the metal surfaces to be tinned or sweat soldered in the cold state. As with other zinc chloride based fluxes, the residues can be corrosive and in most applications it is appropriate to wash the tinned area to remove these residues.

TECHNICAL SPECIFICATION

Metal loading is 70% by weight. A choice of five alloy grades are available.

Grade	Melting or Solidus / Liquidus Temp °C	Uses
S-Sn40Pb60	183 - 235	All general sweating and tinning work
S-Sn97Cu3 Pure Tin	230 - 250 232	Hand tinning Sweat soldering where a lead free solder is essential

MATERIAL CHARACTERISTICS

Characteristic	Data
Appearance	Grey, slurry, creamy
Odour	Faint
Density @ 20C (g/ml)	4
PH	Acidic

PACKAGING

Fryolux Solder Paint T1333 is available in various container sizes: 125g, 500g and 2.5Kg .

SOLDER CONNECTION
EXPERTS IN SOLDER TECHNOLOGY

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TECHNICAL SUPPORT

Please refer to your local Sales Office.

HEALTH AND SAFETY

Materials containing Lead are subject to the Control of Lead at Work Regulation.
Eye and skin protection must be used when handling or working with fluxes. Always wear safety goggles and suitable rubber gloves.
Avoid breathing fumes evolved during soldering process by providing fume extraction or good ventilation. In case of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes. Obtain medical attention.
Refer to Health and Safety Data Sheet for more detailed information.

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