



SUPERIOR No. 715-SFM



GENERAL PURPOSE SOFT-SOLDERING FLUX

- Formulated for soldering Copper, Brass, Zinc, Steel, Stainless Steel and High-Chrome Alloys.
- Excellent across a broad range of base metals, solders, and temperatures.
- Exhibits excellent capillary action.

DESCRIPTION

Superior No. 715-SFM is a water-based, general purpose, inorganic-acid flux formulated for soldering stainless steel and other industrial metals. The flux contains Zinc Chloride, Ammonium Chloride, and Hydrochloric Acid that make this flux active at room temperature where it begins to clean metals and remove oxides. The flux exerts a strong scavenging action to remove oxide coatings and other impurities from the metal surface to produce strong joints. Pre-cleaning is not necessary under most conditions.

APPLICATIONS

Superior No. 715-SFM is excellent for use on Stainless Steel, Monel, High-Chrome Alloys, Inconel, Nickel, Copper, Brass, Ferrous Alloys and many more metals. It is not recommended for Aluminum and Magnesium.

DIRECTIONS

Superior No. 715-SFM may be applied with a brush, swab or by dipping. The flux exhibits the best soldering activity between 260-427°C/500-800°F. Post-solder residues are water-soluble and hot water rinses (140°F or higher) may be adequate for most applications. The following steps are recommended for optimum soldering results:

- ➊ Remove any oil, grease, or other contaminants from the surface to be soldered.
- ➋ Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.
- ➌ 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.
- ➍ Apply solder, dip part, place torch or iron to area being soldered.
- ➎ Rinse with hot water to remove residual flux material.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

Form	Appearance Clear, Colorless to Yellow
Specific Gravity	1.512 ± 0.015 @ 20-25°C/68-77°F
Density	12.6 Lbs. /Gallon @ 20-25°C/68-77°F
Free Acid	0.3 ± 0.1% HCl
Flash Point	None
Freezing Effects	None
Odor	Mild
Surface Tension	32 dynes/cm minimum
Spread Factor	80 Minimum
Recommended Soldering Range	260-427°C/500-800°F

THIS PRODUCT IS RoHS COMPLIANT

PREPARATION AND HANDLING

Superior No. 715-SFM is shipped ready to use. Dilution is not generally recommended for this flux because of the low acid content, however, if it is diluted, mix well before using. The solution will not separate on standing.

SAFETY AND PRECAUTIONS

Since **Superior No. 715-SFM** attacks many metals to some extent, it is recommended that polyethylene, PVC or fiberglass reinforced polyester containers be used. Any machinery or construction materials, which might be exposed to direct contact with the flux, should also be able to withstand acids.

This product, during handling or use, may be hazardous to health or the environment.

Read the Material Safety Data Sheet and warning label before using this product.

Superior No. 715-SFM has a two (2) year shelf life.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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**Superior Flux
& Mfg. Co.**

6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax:
440-349-3003 www.superiorflux.com • e-mail: info@superiorflux.com