



# SUPERIOR No. 75 Paste



## SOFT SOLDERING FLUX

- Water-based, high-activity flux.
- Formulated for copper, brass, and stainless steel for tin/lead and lead-free solder alloys.

### DESCRIPTION

**Superior No. 75-Paste** flux is a creamy, white, water flushable paste that holds its shape and will not slump until being heated above 50°C/122°F. It is a water-based flux that promotes excellent solderability and post-solder removal with tin/lead and lead-free solders.

### APPLICATIONS

**Superior No. 75-Paste** is formulated specifically for use in 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. Also promotes excellent solderability on other base metals where high flux activity is required.

### DIRECTIONS

**Superior No. 75-Paste** should be applied with a brush or a swab. The flux exhibits the best activity between 93-315°C/200-600°F. Post-solder residues are water-flushable. To insure complete removal of flux residues, first use water containing 2% HCl followed by as many hot water rinses as necessary.

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 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 or feed solder wire to area being soldered.
- ➎ Clean flux residues from soldered area using a water rinse or by wiping off with a wet cloth.

*Superior manufactures quality fluxes. Our business is solving problems.*



## PHYSICAL PROPERTIES

Form	Paste
Color	White
pH	< 0 – 2
Viscosity	50,000 – 500,000 cps (TD)
Specific Gravity	0.9055 ± 0.0015 @ 20-25°C/68-77°F
Soldering Temperature Range	93-315°C/200-600°F
Residues	Water Flushable

**THIS PRODUCT IS RoHS COMPLIANT**

## FILLER METALS

**Superior No. 75-Paste** is formulated for Tin/Silver and Lead-Free solders. It may also be used with Tin/Lead solders.

## SAFETY PRECAUTIONS

**Superior No. 75-Paste** contains no petrolatum, but contains small amounts of Zinc Chloride (CAS 7646-85-7) and should be handled with care.

When soldering with **Superior No. 75-Paste**, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

Disposal of raw flux and flux residues must be carried out in accordance with local and federal environmental guidelines.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

**Superior No. 75-Paste** 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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