

Solder & Flux



Specifications

DESCRIPTION

Lead-free 95/5 tin-antimony solder combined with highly effective flux in a stable paste form for brush-on applications. Fluxes, tins and solders in one easy money saving operation, minimizing application and prep time.

Joins a wide assortment of metals including copper, brass, zinc, tin, lead, galvanized and black iron, steel, and some grades of stainless steel.

Makes 3 to 4 times as many joints as an equal weight of wire solder plus flux.

Eliminates wasted solder. When properly applied, **swif 95** does not drip. Shear strength is 40% higher than 50/50. Ideal for applications where temperature, pressure and vibration may be encountered. Flux meets Spec. CID. A-A51145 and is non-corroding after joint is properly made. Recommended for potable water and for food piping and processing lines. Conforms to ASTM B485.

Swif 95 is also a highly effective tinning flux.

SIZES AND PACKING

STOCK NO.	SIZE	PACKING	WEIGHT/CASE
10210*	1/2 lb.	12	6.6 lbs.
10215*	1 lb.	12	13.2 lbs.
10222*	3 lb.	6	20.0 lbs.

*Free brush

swif[®] 95

swif® 95

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SPEC SHEET #S00002

APPROVALS AND LISTINGS

Spec. CID. A-A51145
ASTM #B486
UPC listed

SPECIFIC USES

Used to flux, tin and solder in one operation. Also may be used as a highly effective tinning flux.

SPECIFIC APPLICATIONS*

Used on potable water lines, and is approved for food piping and processing lines.

PHYSICAL PROPERTIES

Specific Gravity: 4.03
Solubility in water: Slightly miscible with water
Boiling point: Tin 2260°C Antimony 1635°C
Appearance/color/odor: Gray, silvery paste. No odor.

WARNINGS OR CAUTIONS

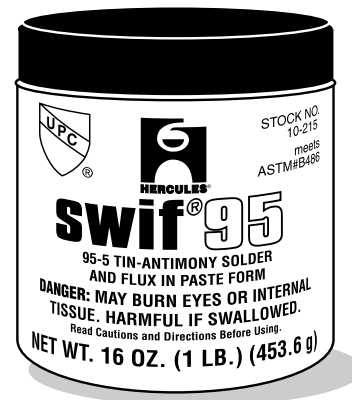
- Read all cautions and directions carefully before using this product.
- **Keep out of reach of children.**
- Contains zinc chloride.
- Harmful if swallowed.
- Avoid eye or skin contact. Eye contact can cause irritation, discomfort, and blurred vision. Prolonged skin contact can cause skin irritation with rash.
- Avoid inhaling fumes while soldering.
- Use brush; do not apply with fingers.
- Wash hands after use.

DIRECTIONS FOR USE

KEEP TIGHTLY CLOSED WHEN NOT IN USE. If left open and swif 95 thickens, add a few drops of water and stir well. ADDING TOO MUCH WATER WILL REDUCE PRODUCT EFFECTIVENESS.

For Sweat Soldering

- 1) Check dry fit of tubes and fitting. Square cut, no burrs, clean surfaces and proper fit will assure best results. A loose fit may cause problems which may require future tube or fitting replacement. Note: Avoid loose fitting joints. If space between tube and fitting is too large for proper capillary action, supplement **swif 95** with wire solder and fill in. Mechanical pre-cleaning is recommended for best results.
- 2) Stir **swif 95** well. Brush on both tube and fitting, liberally covering areas to be joined. Join tube and fitting. Small "collar" of solder should be evident when tube and fitting are joined-this will be drawn into joint when heat is applied. Apply heat to adjacent metal surfaces. Do not direct flame at **swif 95**. Warming tube can help speed job. When heated, **swif 95** turns from metal grey to black and starts bubbling.
- 3) When **swif 95** flows, draws into joint and slight residue stops bubbling around joint, remove torch flame. On 1 1/2 inch and larger sizes, add wire solder (same grade) to joint. Wipe clean with damp cloth or wet brush.



How to Tin:

- 1) Brush **swif 95** on area to be tinned.
- 2) Heat adjacent portion of metal.
(Do not apply flame directly to **swif 95**.)
- 3) When solder melts, wipe in usual manner.

MATERIAL SAFETY INFORMATION

FOR MORE INFORMATION ON THIS PRODUCT, REQUEST MATERIAL SAFETY DATA SHEET (MSDS) #02

For Delivery by Fax	Call 1-800-942-4636
Internet	See MSDS section of www.herchem.com
Mail	Contact Hercules at address below or any Hercules representative

HMIS Hazard Warning 2-0-1-C.

INGREDIENTS	CAS#
Tin	7440-31-5
Antimony	7440-36-0
Zinc Chloride	7646-85-7
Ammonium Chloride	12125-02-9

NJ-T.S.R. #31348300 5002P

* For special applications which may not be covered on this or other Hercules literature, please contact Hercules Technical Services Department by phone at 1-800-221-9330 or send a fax to 1-800-333-3456.



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