

ISO-Flux® Electronic flux

Flux for wave soldering processes in component manufacturing

FELDER ISO-Flux® electronic flux For the manufacture of highly sophisticated electronics. For mixed-assembly circuits (THT/SMT). Can be used in both lead-free and lead-based soldering processes.

Packaging form Pack size

Bottle	1.000 l
Canister	5.000 l, 10.000 l, 25.000 l

Other container sizes are available on request.



Product	DIN EN ISO 9454-1	IPC-J-STD-004	Solid content	Use and application
ClearWave	2131	ORLO	2.0 %	Wave/selective soldering, spray fluxing, drop jetting
ClearWave S	2231	ORLO	2.2 %	Wave/selective soldering, spray fluxing, foam fluxing
ClearWave R	1131	ROLO	3.5 %	Wave/selective soldering, spray fluxing, foam fluxing
ELS 3320	2231	ORLO	2.7 %	Wave/selective soldering, lead-free, halogen-free and resin-free, no-clean
ELS 3320-22	2231	ORLO	2.2 %	same as ELS 3320, but with minimised solid content

Other types of flux for assembly production (water-washable / halide-containing / VOC-free) are also available.

Description

„ClearWave“	No-clean electronic flux with a solids content of 2.0% without resin content. The minimal flux residues have very high surface resistances and are non-corrosive.
“ClearWave S“	Electronics flux with a solid content of 2.2%. ClearWave S also contains a small amount of synthetic resin (0.2%). This serves to encapsulate residues that have not completely reacted in the selective soldering process.
“ClearWave R“	ROLO flux with a solids content of 3.5%. Contains colophony, low residue, IPC-J-STD-001 compliant.
“ELS“	Resin-free no-clean electronic flux based on organic activators.

ISO-Flux® Cable flux

Special flux for cable assembly and coil production

For dip tinning and dip and selective soldering of copper strands and enamelled copper wires

FELDER ISO-Flux® cable flux differs from conventional fluxes in that it partially tins the stripped cable ends.

Packaging form Pack size

Bottle	1.000 l
Canister	5.000 l, 25.000 l

Other container sizes are available on request.



Product DIN EN ISO 9454-1 IPC-J-STD-004 Solid content Halide content Scope of application

KF 23	2231	ORLO	5.0 %	< 0.01 %	Cable assembly, transformer construction, selective soldering
KF 32	1231	RELO	15.0 %	< 0.01 %	Cable assembly, selective soldering, resin-based
KF 070	2123	ORM1	1.3 %	< 1.5 %	Cable assembly, transformer construction, solid core
KF-L	2123	ORM1	3.4 %	< 0.5 %	Cable assembly, low VOC

 **Made in Germany**



ISO-Flux® SMD- and BGA repair flux

For rework and repair soldering following the reflow process

FELDER ISO-Flux® "Clear" and ISO-Flux® "Active-Clear" sind paste-like rework flux for soldering, desoldering and also for diluting FELDER SMD solder pastes ISO-Cream® "Clear" and "Active-Clear"

Packaging form	Pack size
Dispenser cartridges	5, 10 and 30 ccm
Cans	100 g
Other containers are available on request.	



Product	Viscosity	Flux
ISO-Flux® Clear	250 - 350 Pa s	Paste flux Type 1231 (DIN EN ISO 9454-1), RELO (DIN EN 61190-1-1 / J-STD-004)
ISO-Flux® Active-Clear	250 - 350 Pa s	Paste flux Type 1222 (DIN EN ISO 9454-1), REL1 (DIN EN 61190-1-1 / J-STD-004)

Description

ISO-Flux® "Clear" and ISO-Flux® "Active-Clear" have been adapted to the requirements of assembly and connection technology and thus optimised for Sn/Ag, Sn/Ag/Cu and Sn/Cu soldering systems. They are also ideally suited for hot air and iron soldering.

Further FELDER Repair-flux (for lead-containing soldering processes)

ISO-Flux® "EL 3201-B" and "EL 3202-A" are suitable for reworking solder joints containing lead.

ISO-Flux® Soldering oils and soldering pastes

For soft soldering in electronics and electrical appliance manufacturing

FELDER soft soldering flux ISO-Flux® "EL" and "E" are very well suited for hand and dip soldering as well as tinning work, especially at high soldering temperatures and long soldering times.

Type	Packaging form	Pack size
Solder paste	Can	20 g, 50 g, 100 g, 250 g
Solder oil	Bottle	100 ml, 1.000 l
Solder oil	Canister	5.000 l, 10.000 l, 25.000 l



Product DIN EN ISO 9454-1 IPC-J-STD-004 Halide content Scope of application

Solder oil / solder paste "EL" 1131	ROLO	< 0.01 %	General soldering work and in electronics
Solder oil / solder paste "E" 1123	ROM1	1 % / 0.5 %	Electrical engineering and electrical equipment manufacturing

Flux thinner

To adjust the concentration of FELDER ISO-Flux®-fluxes

FELDER Flussmittelverdünner "VF-1" and "VF-2" When used in foam fluxing equipment, the flux gradually becomes concentrated, which affects the soldering result. In dip fluxing stations, the solvent also evaporates through large, open surfaces. To determine the amount of thinner to be added, we recommend titrating the acid number of the flux (FELDER titration set accessory).

Product	To be used with the following FELDER fluxes:
Thinner "VF-1"	All ISO-Flux® -Ethanol-based types
Thinner "VF-2"	All ISO-Flux® "ClearWave"-Types, Solder oil "E" and "EL" as well as all FELDER cable flux agents

Packaging form	Package size
Flasche	1.000 l
Kanister	5.000 l, 25.000 l

Other container sizes are available on request.

