

Body solder, lead-free

According to DIN EN ISO 9453

Delivery form	Dimension	PU
Pressed rod	approx. 8 x 10 x 400 mm	20.0 kg



Art.-no.	Alloy	Melting range	Description and application
13761000	Sn90Zn7Cu3	200 - 280 °C	The solder has a very large melting range and is therefore also ideally suited for soldering on installed body parts. It is characterized by its optimum gap filling, good wetting on steel, minimum formation of blowholes in the brazing process as well as good grindability and high strength. The zinc content in this lead-free body solder ensures a paste-like consistency when applied and spread and prevents the solder from dripping off at vertical soldering points. The processing temperature should be in the melting range of the alloy to achieve the optimum consistency. The shape as pressed flat bar has an additional, positive influence on the workability during application.
12911000	Sn92Cu8	230 - ca. 400 °C	The solder has a very large melting range and is therefore also ideally suited for soldering on installed body parts. It is characterized by its optimum gap filling, good wetting on steel, minimum formation of blowholes in the brazing process as well as good grindability and high strength.

Body solder, leaded (Restriction of use: for professional users only)

Art.-no.	Alloy	Melting range	Description and application
12250122	Pb74Sn25Sb1	185 - 263 °C	Triangular rods approx. 10 x 10 x 400 mm, body tin
12251000	Pb74Sn25Sb1	185 - 263 °C	Pressed rods, body tin

Note on the use of soft solders containing lead

Please note that lead is classified as toxic under the current REACH regulation and is on the proposed list of substances of concern. It is to be expected that in the foreseeable future a classification in the corresponding substance list will be made and thus a ban on use will be imminent. Even today, special safety measures must be observed when using lead.

Soft solder and tinning paste

For the tinning of car body sheets

Alloys according to DIN EN ISO 9453,
flux according to DIN EN 29454.1, 3.1.1.C (F-SW 21), metal content 60 - 70%
ready-to-use metal paste

PU	Delivery form	Content
50 pc	Bottle	0.100 kg
25 pc	Bottle	0.250 kg
25 pc	Bottle	0.500 kg
15 pc	Bottle	1.000 kg
10 pc	Tin can with brush insert	1.000 kg



Alloy	Melting range	Remarks
Pb74Sn25Sb1*	186 - 260 °C	Only available in 1.000 kg bottle
Pb60Sn40	183 - 215 °C	
Sn97Cu3	230 - 250 °C	„Lead-free“ - RoHS-compliant
Sn99.9%	232 °C	„Lead-free“ - RoHS-compliant

Note on the use of soft soldering and tinning pastes containing lead

Please note that lead is classified as toxic under the current REACH regulation. Pastes containing lead are subject to the Chemicals Prohibition Ordinance and may only be used by competent persons. The special safety measures for use of lead must be observed.



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Soldering fluid

Flux for general soldering work on all metallic surfaces with the exception of aluminium and stainless steel

DIN EN 29454.1, 3.1.1.A (F-SW 12)



Art.-No.	Delivery form	PU	Remarks
24220036	Bottle	100 pc	50 ml bottle with brush insert
24220051	Bottle	50 pc	100 ml bottle
24220056	Bottle	20 pc	250 ml bottle
24220061	Bottle	30 pc	500 ml bottle
24220071	Bottle	15 pc	1000 ml bottle
24220086	Canister	1 pc	25.000 l canister

Soldering fluid brush

with metal shaft and natural bristles



Art.-No.	PU	Description
27130000	100 pc	Soldering fluid brush with metal shaft and natural bristles, approx. 10 mm wide

Sal ammoniacal bricks

for cleaning soldering tips

Art.-No.	Size	PU	Description
27100001	Brick No. 1	300 pc	65 x 45 x 20 mm
27100002	Brick No. 2	150 pc	65 x 45 x 40 mm
27100004	Brick No. 4	100 pc	100 x 50 x 25 mm in plastic can



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