



Product Information

Coachwork tinning paste, S-Pb74Sn25Sb1

For tinning and pre-tinning in coachwork industry

Metal powder content according to DIN EN ISO 9453, S-Pb74Sn25Sb1

Flux according to DIN EN 29454-1, 3.1.1.C

Item no.: 21256070

All information about our products is the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

Description

Ready to use soft solder metal paste for soldering, tinning and pre-tinning. Flux based on zinc chloride and ammonium chloride in organic preparation with metal powder.

The tinning paste S-Pb74Sn25Sb1 is ready to use. There is no sedimentation of the metal powder content.

Properties

Alloy according to DIN EN ISO 9453:2006	Melting range	Metal content	Condition
S-Pb74Sn25Sb1	185 - 263°C	60 - 70%	pasty

Processing Advices

After the area to be tinned has been widely grinded to a shiny extent, the paste will be thinly applied with a brush on the coachwork sheet and will be steadily heated up by a Bunsen burner or a solder lamp. As soon as the paste is melted the flux residues have to be washed off thoroughly with a wet clean cloth and fresh water. Subsequently you can continue to work with solder rod alloys Pb74Sn25Sb1. The sheet and the soft solder will be heated up with the burner until the solder rod reaches a doughy condition. During the whole application the solder should be kept in a ductile and pulpy condition. If sufficient solder was applied, it has to be smooth out. For this purpose you have to use a so called tin wood (beech wood) or an aluminium spoon. In order that the solder does not stick on the wood you have to spread it with beeswax or a commercial vegetable fat. Afterwards you can polish the excessive solder. The flux residues are corrosive and have to be removed thoroughly with water (if required maybe neutralisation, ultrasound).

Delivery Form

1,00 kg tin can

Other container sizes are deliverable on request.

Storage Advices

Store in tightly closed containers protected against humidity, insolation and heat exposure. FELDER Soft solder and tinning paste in unopened containers is durable for 24 months from production date (XXXXXX/month/year).