



# Product Information

## Lead free soldering and tinning paste

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For soldering, tinning and pre-tinning.

Metal powder content according to EN 610 resp. EN ISO 9453

Flux according to ISO 9454-1, 3214

Lead-free FELDER tinning pastes do not contain any substances for which there are restrictions in Directive 2011/65/EU ("RoHS").

Item-no.: 21.....

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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

Lead-free metal powder flux mixture for soldering, tinning and pre-tinning of copper, copper alloys and steel based on zinc chloride and ammonium chloride in organic preparation. **FELDER soft soldering and tinning paste** is ready to use and can be used undiluted. There is no sedimentation of the metal powder content.

## Properties

Metal powder type	Melting range	Item-no.
Sn99,9*	232 °C	2199....
Sn97Cu3**	230-310 °C	2197....
Sn97Ag3**	221-240 °C	2195....

\*EN 610, \*\*EN ISO 9453

Metal powder content : 60 – 70 %  
Condition : pasty  
Working temperature : depending on alloy and application between 250 and 350 °C

## Processing Advices

Apply paste thinly with a brush on the workpiece which has to be tinned and heat up constantly. Subsequently you might increase the alloy layer thickness with additional solder rods or wires. The flux residues are corrosive and have to be removed thoroughly with water (maybe supported by neutralization, ultrasonic).

## 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). '

## Delivery Form

0.10 kg, 0.25 kg, 0.50 kg jars  
1,00 kg tin cans  
Other container sizes are deliverable on request.