

# Product Information

## Fitting Solder Paste "Cu-Rofix®3-Spezial"

Ready-made soft solder metal paste for pre-tinning and soft soldering in the copper pipe installation awarded the RAL mark of quality of Gütegemeinschaft Kupferrohr e.V. DVGW mark of conformity DV-0101 AT 2247 (FI058)

Item No.: 2297605..1

FELDER lead-free fitting solder pastes „Cu-Rofix®3/3-Spezial“ and „Cu-Rofix®4/4-Spezial“ contain no substances for which exist restrictions in the directive 2011/65/EU “RoHS II” (lead, cadmium, mercury, hexavalent chromium, PBB resp. PBDE).

All information about our products are 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-made soft solder metal paste for pre-tinning and soft soldering in the copper pipe installation in combination with our Fitting Solder "Cu-Rotin®3". On the basis of zinc chloride and ammonium chloride in organic composition.

## Properties

Flux according to ISO 9454-1	:	3214 (3.1.1.C)
Alloy according to ISO 9453	:	Sn97Cu3
Metal powder content	:	≥ 60%
Melting range	:	227 - 310° C
Condition	:	pasty
DVGW-mark of conformity	:	DV-0101 AT 2247 (FI058)

## Application

Due to the good spreadability of "Cu-Rofix®3-Spezial" this fitting solder paste can be applied economically. It is sufficient to coat half a fitting insertion depth of the pipe surface. The solder powder content does not settle so that the solder paste does not need to be stirred. The excellent crevice filling contributes to the optimal shearing resistance. Due to the wide sphere of activity the overheating limit is quite high. Furthermore, the melting of the solder content indicates the reaching of the working temperature. Due to the special composition of the Fitting Solder Paste "Cu-Rofix®3-Spezial" and when used properly the paste does not run down although if you solder overhead. Even in inconvenient positions you are able to produce a perfect fillet weld. The solder paste does not spatter on warming up. The flux residues are corrosive and have to be removed through wiping from outside and rinsing from inside!

## Advices

Furthermore, we recommend you our quality tested fluxes for the copper pipe installation soft solder flux "Cu-Roplus®", "Cu-Roclean®" and "Cu-Roflux®39".

Keep dry and dust-free at room temperature. Minimum durability: 24 months.

## Delivery Forms

0,100 kg jars with brush holder

0,250 kg jars with brush holder

Other container sizes are deliverable on request