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TECHNICAL SPECIFICATION

**LEAD FREE 95/5
ACID CORE SOLDER**



TECHNICAL SPECIFICATION: Oatey Lead Free 95/5 Acid Core Solder is a general purpose solder for repairing galvanized gutters, filling metal seams and other general repair. Lead Free Acid Core Solder is made of 95% Tin and 5% Antimony. Acid Core Solder should not be used on electrical parts.



PHYSICAL/CHEMICAL PROPERTIES

Alloy composition	95%Tin 5% Antimony Acid Flux Core
Appearance	Solid wire with acid flux core
Melting Range	450° F to 464° F

DIRECTIONS FOR USE

Remove all corrosion, dirt and oil using Oatey Abrasive Cloth, Utility Brushes or Nylon Grit Pads. Clean all surfaces until they are bright. Acid Core Solder contains flux, however additional flux may be necessary to ensure proper flow of solder wire. Join parts together. Apply heat with a torch or solder gun. Apply solder while maintaining heat. When soldering process is complete, allow the joint to cool undisturbed. When joint is cool, remove any flux residual with a damp cloth.

PRECAUTIONS

Read all cautions and directions carefully before using this product. Wash hands thoroughly after use and before eating. Wear safety glasses with side shields and rubber gloves. EYE AND SKIN IRRITANT. HARMFUL IF SWALLOWED. VAPOR MAY BE HARMFUL. Use only in well ventilated area. Eye or skin contact may cause intense irritation and injury. In case of contact with eyes or skin, flush with water and seek medical attention immediately. If inhaled, get fresh air and seek medical attention if ill feelings persist. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information. For emergency first aid help, call 1-303-623-5716 COLLECT.

COMMON APPLICATIONS

Oatey Acid Core Solder is a general purpose solder for repairing galvanized gutters, filling metal seams and other general repair. Acid Core Solder should not be used on electrical parts.

Consult Oatey Technical Department for applications not specifically referenced above.

INGREDIENTS (CAS Number)

- Tin (7440-31-5)
- Antimony (7440-36-0)
- Acid Flux (N/A)

APPROVALS AND LISTINGS

Meets Military Specification QQ-S-571E