



AMTEC SF110 LOW TEMPERATURE SILVER SOLDER

SOLDER ALLOY (SOLID, FLUX-CORED OR PASTE)

General Characteristics

Amtec SF110 is a high strength, silver bearing solder alloy that is free of cadmium, zinc, lead and other impurities. The deposit stays bright and shiny and has a close color match to stainless steel. This alloy is great for low temperature joining of ferrous and non-ferrous metals, except the white metals, and has excellent corrosion resistance.

Procedure

Clean the weld zone of all contaminants. Apply Amtec 110 flux (for the solid wire solder) to part and heat with a soft flame, being careful not to burn the flux. Apply solder and continue to heat until the alloy flows out completely. Remove the flame or heat source and cool slowly, then remove flux residue with warm water. If using the flux-cored or paste form of this product, additional flux may not be necessary as they both contain fluxing ingredients to aid in cleaning the surface to be soldered.

Application

Amtec SF110 Silver Bearing Solder is commonly used to join a wide variety of ferrous and non-ferrous metals when higher strengths are required than what can be produced with commonly used solders. It is ideal for use on stainless steel, brass, bronze, copper, nickel, nickel alloys and carbon steels. Typical applications would be dairy and food equipment, hospital equipment, instruments, oxygen lines, sanitary apparatus, electrical connections and general maintenance.

Tensile Strength	15,000 PSI
Working Temperature	430°F
Hardness	15 Brinell
Electrical Conductivity	very good
Corrosion Resistance	good

Diameter (Inch)	1/16	1/8
(mm)	1.5	3.2

Available in Kits containing 9 feet of solder, both solid wire with flux, or flux-cored, or in 1 lb. spools. The SF110 Paste comes in a 1 lb. plastic jar.

CONFIDENTIAL INFORMATION

Subject to change without notice