



QUALITEK®

813 Flux Water-Soluble, Halide Free

DESCRIPTION

813 is a halogen free, water-soluble organic flux. 813 provides a stable head of tight bubbles in foaming applications. The flux residues are removed easily in warm water.

BENEFITS

- Halide-Free
- Excellent wetting on virtually all types of substrates
- Excellent for lead tinning
- Remains active at high temperatures

APPLICATION METHODS

813 lends itself particularly well to foaming applications, and may also be applied by dip, spray, or brush methods. 813 provides a rapid break-up of bubbles that evenly coat the board surface. Should the flux become concentrated due to solvent loss, add Qualitek 800 thinner to maintain the proper specific gravity and performance.

PHYSICAL & CHEMICAL CHARACTERISTICS

Color and Appearance	Light Amber Liquid
Solids Content, % (By Wt.)	17.0 – 18.0
Specific Gravity	0.870 +/- 0.006
Flash Point	53°F
pH (as is)	2.6 – 3.0
Flux Classification per J-STD-004	ORM0
Shelf life (un-opened)	2 years

RESIDUE REMOVAL

As with all water-soluble fluxes, post cleaning is required. Residues can be easily removed with both hot and cold water, thus; no neutralizer is needed. De-ionized water should be used in the final rinse for cleanliness results beyond MIL-28809A.

PACKAGING & STORAGE

813 flux is available in 1, 5 and 55 gallon containers. It should be stored in cool, dry place away from ignition sources.

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Consult MSDS for health and safety information