



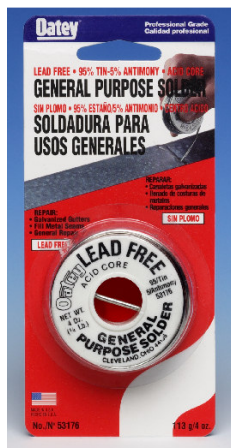
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TECHNICAL SPECIFICATION

ACID CORE SOLDER



TECHNICAL SPECIFICATION: Oatey Acid Core Solder is available in 3 different alloy compositions, 40/60 (40% Tin, 60% Lead), 50/50 (50% Tin, 50% Lead) and 95/5 (95% Tin, 5% Antimony). 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. **40/60 & 50/50 ACID CORE SOLDERS CONTAIN LEAD. IT IS ILLEGAL TO USE LEAD ALLOY SOLDERS IN POTABLE WATER SYSTEMS (DRINKING WATER).**



Tin/Lead solders are not recommended for applications involving high stress or vibration. It is illegal to use lead alloy solders in potable water systems (drinking water).

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.

PHYSICAL/CHEMICAL PROPERTIES

Wire composition	40/60 & 50/50	Tin, Lead & Acid
	95/5	Tin, Antimony & Acid
Appearance		Solid wire with acid flux core
Melting Range	40/60 alloy	361° F to 460° F
	50/50 alloy	361° F to 421° F
	95/5 alloy	450° F to 464° F

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.

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.

INGREDIENTS (CAS Number)

- Tin (7440-31-5)
- Lead (7439-92-1)
- Antimony (7440-36-0)
- Acid Flux (N/A)

APPROVALS AND LISTINGS

Meets Military Specification QQ-S-571E

PRODUCT NUMBER	DESCRIPTION	GAUGE	PACK	CARTON WEIGHT
29032	1 oz. 40/60 Acid Core Solder – Bulk	.081	20	2 lbs.
53183	1.5 oz. 40/60 Acid Core Solder – Carded	.081	12	2 lbs.
53011	1.5 oz. 40/60 Acid Core Solder – Display	.081	12	2 lbs.
53192	4 oz. 40/60 Acid Core Solder – Carded	.081	12	4 lbs.
53015	4 oz. 40/60 Acid Core Solder – Display	.081	12	4 lbs.
50193	8 oz. 40/60 Acid Core Solder – Bulk	.081	10	5 lbs.
53196	8 oz. 40/60 Acid Core Solder – Carded	.081	12	8 lbs.
50429	8 oz. 40/60 Acid Core Solder – Display	.081	12	8 lbs.
21115	1 lb. 40/60 Acid Core Solder – Bulk	.125	10	10 lbs.
20116	1 lb. 50/50 Acid Core Solder – Bulk	.125	10	10 lbs.
53174	1.5 oz. 95/5 Acid Core Solder – Display	.081	12	4 lbs.
53176	4 oz. 95/5 Acid Core Solder – Display	.081	12	4 lbs.
53170	8 oz. 95/5 Acid Core Solder – Bulk	.081	10	5 lbs.
53172	1 lb. 95/5 Acid Core Solder – Bulk	.120	10	10 lbs.