



# TECHNICAL DATA SHEET

CATEGORY: **WATER SOLUBLE LIQUID FLUX**  
PRODUCT: **ST-501A**

## FEATURES

- WATER SOLUBLE
- ENHANCED ACTIVITY LEVEL FOR STAINLESS STEEL
- EXCELLENT WETTING
- WIDE PROCESS WINDOW

## DESCRIPTION

**ST-501A** is a water-based, inorganically activated liquid flux designed to solder almost all grades of stainless steel. Though designed for application via a foam fluxer, ST-501A also may be applied by dipping or brushing. Since ST-501A is highly corrosive, all residues must be rinsed with water after soldering.

## PHYSICAL PROPERTIES\*

<b>SOLIDS CONTENT</b> 50%	<b>FLUX DENSITY</b> 1.25	<b>ACID VALUE</b> 340MG +/- 10% KOH/GRAM
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## HANDLING

- ST-501A has a sealed shelf life of one year. Do not freeze this product.
- ST-501A is shipped ready-to-use; no mixing is necessary.
- Do not mix used and unused chemical in the same container. Reseal any opened containers.

\*Please be aware that these fluxes are toxic and cannot be shipped via UPS or FedEx under any circumstances in any quantity. These can only be shipped via truck freight and cannot be expedited.

## FLUX APPLICATION

ST-501A can be used in dipping, spraying, brushing, swabbing, and many other fluxing operations. Flux pots should be plastic or titanium.

## CLEANING

The residues and raw flux are completely water soluble and should be washed in an aqueous cleaning system using de-ionized or distilled water heated to a recommended temperature of 100-150°C.

## SAFETY

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **Material Safety Data Sheet** for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

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