

# Soft Solder Flux No.3S



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## Soft Solder Flux No. 3S™ Flux Paste

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Soft Solder Flux No.3S™ Flux Paste is a predominantly designed for industrial soldering applications. It is particularly suitable for use on carbon and stainless steel as well as being effective on copper and copper alloys such as brass. It is recommended for use on all common engineering materials except aluminium.

Soft Solder Flux No.3S™ Flux Paste has an active or working range which goes up to 350°C. It can therefore be used with tin-copper solders such as JM 99C or 97C™ and tin-silver solders such as P40™ or P5™. It is also suitable for use with specialised high temperature solders such as Comsol™, LM10A™, A25, and A5™.

Soft Solder Flux No.3S™ Flux Paste is a semi-fluid light grey coloured flux paste that can be readily applied by brushing onto components prior to heating.

**Conforms to:** Proprietary  
**Working range:** 180-350°C

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### Directions for Use

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It is good practice to mechanically clean and degrease the joint surface of the components before applying flux. Heat slowly and evenly to the soldering temperature, without localised overheating. During heating initially the flux will become more fluid and it will spread across the components. As heating progresses the water in the flux will boil off and the flux will give off a chemical odour. At ~180°C the flux will become active and will protect the components from oxidation during the soldering process. If the solder does not flow and the components are not heavily oxidised then heating should continue for before reapplying the solder. If blackening of the flux occurs this is often a sign of insufficient flux, overheating or flux exhaustion.

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### Flux Residue Removal

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The flux residues of this product, left after completion of the soldering operation, are corrosive and should be removed by washing and brushing the component in a stream or tank of hot water. If a cleaning tank is used the water in it should be changed regularly to avoid contamination of the components by the residues.

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### Product Availability

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1 kg Plastic Pots

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**Johnson Matthey**

Metal Joining York Way, Royston, Hertfordshire, SG8 5HJ, UK

Telephone: +44 (0) 1763 253200

Fax: +44 (0) 1763 253168

email: [mj@matthey.com](mailto:mj@matthey.com)

[www.jm-metaljoining.com](http://www.jm-metaljoining.com)