



**T H E H A R R I S P R O D U C T S G R O U P**  
**A L I N C O L N E L E C T R I C C O M P A N Y**  
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**TECHNICAL SPECIFICATION SHEET**

**STAY CLEAN® ALUMINUM SOLDERING FLUX**

**STATEMENT OF LIABILITY- DISCLAIMER**

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

**DESCRIPTION/DIRECTIONS:** Stay Clean® Aluminum soldering flux is a chloride free flux for soldering aluminum alloys and dissimilar metals using Tin/Zinc, It has a working temperature range of 350F to 550F. Stay Clean Aluminum soldering flux is used with the Harris Products Group Alsolder 500. The Flux can be removed with warm water 120-150F and mild soap, and a little scrubbing action.

**MINIMAL COMPOSITION**

Aminoethylethanolamine	Tin
Ammonium Fluoborate	Zinc
H <sub>2</sub> O	

**Physical Properties:**

Color	Thick Amber Liquid	Specific Gravity ( H <sub>2</sub> O=1)	1.245
Flash Point	275°F	Solubility in Water	100%
Boiling Point	273°F		

**SOLDERING PROPERTIES:**

Stay Clean® Aluminum soldering flux is a chloride free flux for soldering aluminum alloys and dissimilar metals using Tin/Zinc, Tin /Silver and other soft solders.

Optimal temperature range of this viscous amber flux would be 350° - 550°F which has an ammonia odor.

**AVAILABLE FORMS:**

4 oz. With 24 to a case or Alsolder 500 Kits 1-oz of each solder & flux

**SPECIFICATION COMPLIANCE:**

Harris Internal

**WARNING: PROTECT yourself and others. Read and understand this information.**

**FUMES AND GASES can be hazardous to your health.**

**HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.**

- Before use, read and understand the manufacturer’s instructions, Material Safety Data Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

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Additional information available at our web site: [www.harrisproductsgroup.com](http://www.harrisproductsgroup.com)