

742 Soldering Flux

Inorganic Acid Liquid Flux

Product Description

Kester 742 Soldering Flux, an inorganic acid flux, is a solution of inorganic salts and other additives designed for general tinning applications. 742 is not meant for electronics soldering. Rapid soldering can be accomplished in most metals with this concentrated flux. 742 is particularly suitable for difficult-to-solder metal surfaces such as: copper, nickel, nickel-iron, iron-alloy and tin plate surfaces. 742 possesses high activity, stability and heat resistance. The inorganic nature of the activator system provides good fluxing ability over a wide soldering temperature range.

Performance Characteristics:

- Ease of cleaning of residues
- Chemically compatible with most solder masks and board laminates
- Classified as INH1 per IPC J-STD-004

RoHS Compliance

This product meets the requirements of the Restriction of Hazardous Substances (RoHS) Directive, 2015/863 for the stated banned substances.

Physical Properties

Specific Gravity (typical): 1.095 ± 0.005

Anton Paar DMA 35 @ 25 °C

Percent Solids (theoretical): 18.0

Halide Content (% , typical): 13.0

pH: <1

Mettler-Toledo MA235 pH/Ions Analyzer

Application Notes

742 can be used as received or thinned down to maximum 1 part flux to 5 parts water volume.

Cleaning

Flux residues from 742 should be carefully removed to prevent corrosion caused by residual chloride salts. Hot water from 50 to 70 °C (122 to 158 °F) is best for removal. For critical cleanliness, Kester 5760 Cleaner diluted 1:4 parts with water should be used to neutralize chloride during soldering.

Recycling Services

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



Storage, Handling and Shelf Life

Shelf life is 2 years from date of manufacture when handled properly and held at 10 to 25 °C (50 to 77 °F). Typical appearance of 742 ranges from colorless to light yellow. 742 will darken overtime, but this does not affect the overall performance of the flux.

Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet and warning label before using this product. Safety Data Sheets are available at this [link](#).

Contact Information

To confirm this document is the most recent version, please contact Assembly@MacDermidAlpha.com

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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