



# kester®

Technical Data Sheet

## Acid Cored Wire for Lead-bearing and Lead-free alloys

### Product Description

Kester Acid Core is a highly active inorganic acid type of flux developed for general-purpose soldering applications where a flux-cored solder wire is desirable. Rapid soldering can be accomplished on all common metals except aluminum and manganese. Acid flux is particularly useful for soldering excessively oxidized metals. Kester Acid Core possesses excellent thermal stability to function under prolonged high temperature conditions as with torch or flame soldering. It is not recommended for electrical or electronic soldering applications due to the corrosive nature of the residue.

#### Performance Characteristics:

- Highly reliable post-soldering residue
- Minimal residue
- Compatible with leaded and lead free alloys
- Classified as ROL0 per J-STD-004
- Compliant to Bellcore GR-78

### RoHS Compliance

This product meets the requirements of the RoHS (Restriction of Hazardous Substances) Directive, 2002/95/EC Article 4 for the stated banned substances. (Applies only if this core flux is combined with a lead-free alloy)

#### Suggested Alloys

50/50 and 40/60 - Tin/Lead:

General purpose - for non-electrical applications such as galvanized gutters, sheet metal, radiator repair and stained glass soldering.

96/4 - Tin/Silver:

High strength, non-tarnishing. Use for jewelry, plumbing and food service equipment repairs. Blends in well with stainless steel.

95/5 - Tin/Antimony:

For joining copper tubing in air-conditioning and refrigeration equipment. Also for soldering copper pipe and fittings for drinking water systems.

## Availability

Acid cored wire is available in a wide variety of alloys, wire diameters, flux percentages and roll sizes in both leaded and lead free alloys. Please refer to [www.kester.com](http://www.kester.com) for wire diameters, flux percentages and roll sizes that are available.

The standard wire diameter for most applications is 1.00mm (0.031in). Wire diameters range from 0.25 - 6.00mm (0.010 to 0.250in). The amount of flux in the wire dictates the ease of soldering for an application. For most applications, core 66 (3.3% flux by weight) is recommended. Other core sizes, 50 and 58, (1.1% and 2.2% respectively) are available. Kester Acid Core is packaged on spools of different sizes to accommodate a variety of applications.

Note: Core size 50, 58 and 66 = 1.1%, 2.2% and 3.3% flux core.

## Process Considerations

Solder iron tip temperatures should range between 315-400°C (600-750°F) for suggested alloys. Heat both surfaces to be soldered with the iron prior to adding Kester Acid cored wire. Apply the solder wire to a surface. Do not apply the wire directly to the soldering iron tip. If needed, Kester 3350 Inorganic Acid Flux or SP-30 Soldering Paste Flux may be used as compatible fluxes to aid in soldering joints.

## Cleaning

The flux residue after soldering is hygroscopic and corrosive. The work should be allowed to cool undisturbed until the solder solidifies. The flux residue is then removed with a hot water rinse. For more thorough cleaning requirements, rinse with a 2-10% solution of Kester 5760 Neutralizer followed by a thorough hot water rinse.

## Storage and Shelf Life

Kester Acid Cored Wire has no limited shelf life when handled properly. Storage must be in a dry, non-corrosive environment. Over time, the surface of wire may lose its shine and appear a dull shade of gray. This is a surface phenomenon and is not detrimental to product functionality.

The expiration date determined by the date of manufacture printed on the product and Certificate of Analysis will represent the manufacturer's warranty period which is the time frame wherein Kester will replace defective product. Flux-cored solder wires with alloys containing more than 70% lead have a 2 year warranty from the date of manufacture. All other alloys have a 3 year warranty from the date of manufacture.

## Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet (SDS) and warning label before using this product.