



## 1630 Soldering Flux

### Water-Soluble Liquid Flux for Heat Sink Applications

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#### Product Description

Kester 1630 is a bromide based, chloride-free, inorganic salt activated flux containing less than 1% free acid. 1630 is an excellent flux for soldering copper, brass and all types of tin-based solders from low tin to lead free solders. 1630 has a bromide activator that will not turn copper or brass green during normal soldering operations. 1630 is also used for soldering nickel and mild steel. 1630 was developed for soldering electrical connections like fuses, and can be used to solder all copper based alloy joints. The inorganic salt activation system gives 1630 great heat stability over a long period of time using a wide variety of heating techniques.

#### Performance Characteristics:

- High activity for soldering most metals
- Will not discolor copper and brass
- Excellent heat stability
- 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:** 1.087  
Anton Paar DMA 35 @ 25°C

**Percent Free Acid (as HBr):** 0.50

#### Availability

1630 is supplied in non-returnable 1, 5 and 53 gallon containers.

## Application

1630 is usually applied by brush or dip method at room temperature. If the flux tank is heated, it might be necessary to make water additions to maintain the specific gravity.

## Process Considerations

Any machinery or construction materials, which might be exposed to direct contact with the flux, should also be able to withstand strong acids.

## Flux Control

1630 can be used as received. No mixing or dilution is required.

## Cleaning

Residues from 1630 do not have to be removed from soldering applications depending on the requirements of the operation. Post-soldering residues are water-soluble and can be cleaned easily in warm water, if desired.

## Storage and Shelf Life

Shelf life is 3 years from the date of manufacture when handled properly and held at 5-45°C (41-113°F). If the storage temperature exceeds this range, the flux should be brought to room temperature and thoroughly mixed before dilution or use. 1630 should be stored out of direct sunlight. 1630 should be mixed and kept in polyethylene, PVC or fiberglass reinforced polyester containers at all times.

## 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.