



742 Soldering Flux

Inorganic Acid Liquid Flux

Product Description

Kester 742 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:

- Halide-Free and Halogen-Free
- 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 50-70°C (122-158°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.

Storage, Handling and Shelf Life

742 is flammable. Store away from sources of ignition. Shelf life is 2 years from date of manufacture when handled properly and held at 10-25°C (50-77°F).



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.