



## SF800-LR Soldering Flux

Zero-Halogen, Low-Residue and Low-Solid Liquid Flux for Photovoltaic Assembly

### Product Description

Kester SF800-LR is a zero-halogen, low-residue, low-solids, organic based liquid flux designed specifically for tabbing and stringing applications. The formulation delivers excellent solderability in module assembly processes utilizing conduction, IR and convection reflow. It is formulated to deliver minimum flux residue thus eliminating post cleaning after soldering. Cells are dry and cosmetically clean as they exit the tabber and stringer equipment. SF800-LR provides excellent solderability on all type of metalizations. The formulation of SF800-LR is also designed to deliver excellent peel force that result in long term stability of the solder joints.

#### Performance Characteristics:

- Extremely low residue - minimal post cleaning after soldering thereby maintenance of equipment is reduced
- Low Solids (around 1.5%)
- Excellent Peel Force Resistivity
- Fast Wetting
- High Reliability Liquid Flux
- Suitable for dipping and spraying application methods

### RoHS Compliance

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

### Physical Properties

**Appearance:** Clear, colorless liquid

**Specific Gravity:** 0.799  
Anton Paar DMA 35 @ 25°C

**Acid Number (theoretical):** 13.4 mg  
KOH/g of flux

**Solid Content (theoretical):** 1.5%

### Flux Application

SF800-LR can be applied by spraying or dipping application method.

### Process Considerations

SF800-LR is engineered for the PV industry. The chemical flux is designed for both automated tabber and stringer application, including hand soldering. Standard preheating and heat temperature can be used without special cooling or prebaking. Consult your Equipment Supplier or Kester Technical Support for further information.

## Cleaning

SF800-LR flux residues are non-conductive, non-corrosive and do not require removal in most applications. If residue removal is required, consult Kester Technical Support for cleaning recommendation.

## Storage and Shelf Life

SF800-LR is flammable. Store away from sources of ignition. Shelf life is 1 year from the 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 (SDS) and warning label before using this product.