

# 1800

## Magnet Wire Flux

### For Heat Sink Applications

#### Product Description

Kester 1800 is a neutral, water based, non-halide, organic acid flux formulated for soldering magnet wire. Kester 1800 is non-flammable and because water is not a volatile solvent, it is easy to control in use. Kester 1800 is water-soluble, which assures easy removal by aqueous cleaning methods after soldering. Kester 1800 is used for soldering magnet wire, terminals ends, and electronic assemblies. The unique chemistry of Kester 1800 allows it to remain active for a short period at very high temperatures, up to 500°C (932°F), to remove solderable magnet wire coatings. Kester 1800 is an excellent flux for soldering copper that leaves virtually no residues at elevated temperatures.

#### Performance Characteristics:

- High activity for soldering most metals
- Will not discolor copper and brass
- Excellent heat stability

#### Physical Properties

**Specific Gravity:** 1.087 ± 0.010

Antoine Paar DMA 35 @ 25°C

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

#### Availability

Kester 1800 is supplied in non-returnable one, five and fifty-three gallon containers.

## Application Notes

### Flux Application:

Kester 1800 is usually applied by brush or dip method. Kester 1800 is normally applied 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:

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

### Cleaning:

Residues from Kester 1800 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 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. Kester 1630 should be stored out of direct sunlight. Kester 1800 should be mixed and kept in polyethylene, PVC or fiberglass reinforced polyester containers at all times.

### Health & Safety:

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

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