

# KESTER® 1630 SOLDERING FLUX

## Water Soluble Liquid Flux for Heat Sink Applications

### DESCRIPTION

Kester 1630 Soldering Flux 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.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### FEATURES & BENEFITS

- 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.

### TECHNICAL DATA

Category	Results	Procedure/Remarks
<b>Physical Properties</b>		
Specific Gravity	1.087	Anton Paar DMA 35 @ 25 °C
Percent Free Acid (as HBr)	0.50	

## 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.

## PROCESSING GUIDELINES

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, Handling and Shelf Life

Shelf life is 3 years from the date of manufacture when handled properly and held at 5 to 45 °C (41 to 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.

## AVAILABILITY

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

## RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area.



## SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

## CONTACT INFORMATION

[www.macdermidalpha.com](http://www.macdermidalpha.com)

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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