



# kester®

Technical Data Sheet

## 1800 Soldering Flux

### Magnet Wire Flux

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### Product Description

Kester 1800 Soldering Flux is a neutral, water-based, non-halide, organic acid flux formulated for soldering magnet wire. 1800 is non-flammable and because water is not a volatile solvent, it is easy to control in use. 1800 is water-soluble, which assures easy removal by aqueous cleaning methods after soldering. 1800 is used for soldering magnet wire, terminals ends and electronic assemblies. The unique chemistry of 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. 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



### 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:** 1.036 +/-0.010  
Anton Paar DMA 35 @ 25°C

**pH (5% solution, typical):** 6.8-7.4  
Mettler-Toledo MA235 pH/Ions Analyzer @ 25°C



### Availability

1800 is supplied in non-returnable 1, 5 and 53 gallon containers.

## Application

1800 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

1800 can be used as received. No mixing or dilution is required.

## Cleaning

Residues from 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 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. 1800 should be stored out of direct sunlight. 1800 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.