

## 817 Soldering Flux

### Inorganic Acid Fluxes

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#### Product Description

Kester 817 Soldering Flux is an inorganic acid flux. Inorganic fluxes are solutions of inorganic salts for use as general all-purpose fluxes. These fluxes are active formulations for soldering difficult-to-solder metals. The Inorganic Acid Fluxes were developed for non-electronic soldering applications and provide maximum wetting, leaving residues which can be removed with water. The corrosive nature of the residues precludes their use for electrical or electronic applications. Flux residues should be carefully removed to prevent corrosion caused by residual chloride salts. All formulations can be used for soldering with an iron, torch, oven induction coils or resistance tools.

Although this is a mild flux, it is a very active solution developed for soldering nickel-chrome and stainless steel alloys where regular acid fluxes are not active enough to remove the resistant oxide coatings.

817 is 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:**  $1.422 \pm 0.015$

**Percent Solids:** 43.3

**Flash Point:** None

**Appearance:** Clear, colorless to light yellow liquid

#### Cleaning

All inorganic fluxes have the potential to form water insoluble, chloride complex residues such as lead chloride. Kester 5760 Neutralizer will solubilize these residues for complete removal with water. Complete removal of residues left when soldering with 817 can be assured by rinsing with a 1% solution of hydrochloric acid. This should be followed by a rinse with a 2 to 10% solution of 5760 Neutralizer and a final rinse with clean water.

## Storage, Handling and Shelf Life

Shelf life is 3 years from the date of manufacture when handled properly and held at 10 to 25 °C (50 to 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. Safety Data Sheets are available at <https://www.kester.com/downloads/sds>.

## Contact Information

To confirm this document is the most recent version, please contact  
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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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