# Technical Bulletin

**JOHNSON MANUFACTURING COMPANY**
Princeton, Iowa 52768-0096

## JOHNSON'S B-118 ORGANIC SOLDERING FLUX
**Part No. 17-00 Series**

### DESCRIPTION:

Johnson's B-118 is a highly concentrated organic flux that has many uses including high speed strip tinning of copper and brass, as well as manufacturing heat exchangers. B-118 is also especially good for face dip soldering heater cores because its aggressive nature pulls even high lead solders deep into capillary joints, yet leaves no corrosive residues in the water channels. Johnson's B-118 is the best organic torch soldering flux we know of; withstands heating to approximately 575° F using open flame.

Johnson's B-118 has been specially formulated to stop the problem of green corrosion associated with zinc chloride fluxes. When properly applied, then heated to full soldering temperature, this flux solders and then volatilizes into the atmosphere, leaving the work piece essentially free of corrosive residues. Products such as heater cores may then be placed in storage without internal corrosion.

### PHYSICAL DATA:

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| **Specific Gravity** | **1.218 ± .005 @ 60° F (As Shipped)** |
| **pH** | **0-1** |
| **Appearance** | **Light Yellow to Amber Color** |
| **Odor** | **Slight Organic Odor** |

### USAGE:

Apply flux with brush, swab, or dip method. For hand soldering use either as packaged or dilute with equal parts of clean water. For face dipping heater cores dilute up to 4:1. For some applications, this flux may be diluted up to 10:1.

### HANDLING:

Since Johnson's B-118 contains free acid, store, mix, and use in non-metallic containers only. Wear protective clothing and eye wear when handling this flux. Avoid mixing this flux with other chemicals. Please refer to the *OSHA Material Safety Data Sheet* for additional information.

### WASTE DISPOSAL:

This flux should be neutralized with soda ash or lime before disposal. Additional treatment may be required to remove heavy metals dissolved into this flux during use. Beyond this, we cannot make specific recommendations because local laws vary.