Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

LLOYD'S STAINLESS STEEL FLUX
Part No. 03-00 Series

DESCRIPTION:

Lloyd's Stainless Steel Flux is a highly agressive flux for soldering all alloys of stainless steel as well as most other difficult-to-solder metals, except aluminum, magnesium and titanium. This flux works very well when heated soldering coppers are used to prevent warping of light gage metals. Other uses include the tinning of tough cast iron bearing shells, prior to babbitting. This balanced chemical and acid formulation produces strong solder bonds that are bright and shiny. It works well with common solders such as 50/50, as well as most non-leaded solders like Johnson's IA-423, #460, 492, 497 and 95/5.

PHYSICAL DATA:

Specific Gravity	**1.25 ± .005 @ 60° F (As Shipped)**
pH	**0-1**
Flashpoint	**150°F TOC**
Solubility in Water	**100%**
Appearance	**Clear, Amber Liquid**
Odor	**Alcohol Odor**

USAGE:

This flux is generally used as shipped, however it may be diluted with water for certain applications. Lloyd's Stainless Steel Flux residues are corrosive and must be completely removed from the workpiece. The use of hot water and a mild detergent helps speed the removal process.

HANDLING:

Always wear protective clothing and eye wear when handling this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information. Store, mix and use in non-metallic containers only. In addition to strong acids, this flux also contains alcohol and therefore is combusitble. Store away from heat, sparks and open flame.

WASTE DISPOSAL:

Lloyd's Stainless Steel Flux must be neutralized before discharging into the sewer. Beyond this, we cannot make specific recommendations due to variations in local laws.