



Technical Data

Versatile, dispensable paste flux improves the soldering process by removing oxidation and reducing surface tension.

General use

Electronic rework and repair; electromechanical and mechanical soldering with wire or preforms.

part #	features	residue removal	solder alloy compatibility
6-412 (no clean)	Clear, hard, nonbrittle residue, noncorrosive, nonconductive, resin based.	not required	All standard alloys.
6-411 (RMA)	Clear, soft residue, noncorrosive.	optional: solvent cleaning	All standard alloys.
6-415 (water soluble)	Residue will not char. Completely water soluble.	water cleaning plain water*	Alloys soldered at temperatures below 200°C.

Difficult-to-solder surfaces

Moderately oxidized.

part #	features	residue removal	solder alloy compatibility
6-410 (RA)	Alternative to RMA when greater activity is required.	recommended: solvent cleaning	All standard alloys.

Difficult-to-solder metals

Including stainless steel.

part #	features	residue removal	solder alloy compatibility
6-442 (water soluble)	Aggressive activity. Compatible with wide range of applications.	water cleaning plain water*	Alloys soldered at temperatures above 170°C.

Soldering with high temperature alloys

(200° to 350°C)

part #	features	residue removal	solder alloy compatibility
6-416 (water soluble)	Residue will not char. Completely water soluble.	water cleaning plain water*	Alloys soldered at temperatures above 200°C.

*Water temperature 60°C (140°F) 40 psi pressure.

For assistance or to place an order, please call **800-969-5525**.

Workmanship and Quality

FluxPlus™ is manufactured to the highest workmanship and quality standards. These fluxes meet or exceed the Joint Industry Standard J-STD-004 requirements for Soldering Fluxes. Published data is verified by independent A₂LA Certified laboratories.

Packaging

3 grams	3cc syringe
10 grams	10cc syringe
25 grams	30cc syringe
50 grams	55cc syringe

Shipping

FluxPlus™ is shipped direct from the factory via 2nd day air. All orders are shipped within 3 days.

Flux residue treatment

- 6-412 No clean. Residue is noncorrosive; dries to a clear, hard finish; and is designed not to be cleaned.
- 6-411 RMA. Residue is noncorrosive and remains soft. Cleaning is optional. To clean, use solvents or semi-aqueous materials.
- 6-410 RA. Residue should be cleaned using solvents or semi-aqueous materials.
- 6-415, 6-416, 6-442
Water Soluble. Residue can be cleaned with warm water; 60°C (140°F) at 40 psi is recommended.

Storage

Proper storage and handling is required. Do not expose FluxPlus™ to high ambient temperatures. Recommended storage temperature: 4° to 25°C (40° to 77°F).

Safety data

Care should be taken to prevent accidental ingestion or contact with the eyes. Use of this product can produce hazardous fumes. Use adequate ventilation and avoid breathing fumes. Wash hands thoroughly after use. Read Material Safety Data Sheet prior to use.

Warranty

We guarantee six months shelf life from date of shipment when stored in closed containers at 4° to 25°C (40° to 77°F). No warranty is made, either expressed or implied, with respect to FluxPlus™ materials, its merchantability, or its fitness for a specific application.

For application assistance or to place an order, please call **800-969-5525**.



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