

# Indalloy Flux #1

## Introduction

**Indalloy Flux #1** is a non-acid\*, non toxic\*, Pb-free, amber colored paste flux for use on copper, brass, galvanized iron, lead, zinc, tin, silver, nickel, mild steel, terne plate and malleable iron. Its strong detergent action cleans as it solders.

**Due to its possible corrosive nature, Indalloy Flux #1 is not recommended for electronics applications.**

## Cleaning

Flux residue removal is mandatory and may be accomplished by means of warm water and mechanical scrubbing. Cleaning should be performed as soon as possible after the soldering operation to avoid possible corrosion. The cleaning water temperature should not exceed 50°C. Excessive water temperature may cause secondary reactions and result in corrosion and/or pitting. A warm water sonication may also be a means of flux residue removal.

## Solder Alloy Compatibility

**Indalloy Flux #1** works well with all common soft solders. The chloride content may cause corrosion of indium based solders.

## Flux Application

Due to its paste like viscosity, **Indalloy Flux #1** is probably best applied by swabbing. Any flux application equipment should be corrosion resistant.

## Technical Specifications

|                          |   |
|--------------------------|---|
| Indium Part Number (IPN) | 84001   |
| Activation Range         | 100–338°C   |
| Specific Gravity         | 1.1 gm/cc   |
| Flash Point              | >204°C  |
| Chloride Content         | Ammonium Chloride<br>(No Zinc Chloride)                                     |
| pH                       | 6.5–7   |
| Appearance               | Amber   |
| Cleaning                 | Warm Water (<50°C) and<br>Mechanical Scrubbing                              |
| Shipping                 | Transport in accordance with<br>applicable regulations and<br>requirements. |

*All information is for reference only. Not to be used as incoming product specifications.*

## Technical Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Material Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder properties, alloy compatibility and selection of solder preforms, wire, ribbon and paste. Indium Corporation's Technical Support engineers provide Rapid Response to all technical inquiries.

## Safety Data Sheets

The SDS for this product can be found online at <http://www.indium.com/sds>

This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the products described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

Form No. 97807 R1

[www.indium.com](http://www.indium.com)

[askus@indium.com](mailto:askus@indium.com)

ASIA: Singapore, Cheongju: +65 6268 8678  
 CHINA: Suzhou, Shenzhen: +86 (0)512 628 34900  
 EUROPE: Milton Keynes, Torino: +44 (0) 1908 580400  
 USA: Utica, Clinton, Chicago, Rome: +1 315 853 4900



©2014 Indium Corporation

ISO 9001  
REGISTERED