

# PRODUCT DATA SHEET

# Indalloy® Flux #2

## Introduction

**Indalloy® Flux #2** is a specialty acid-based liquid flux formulated for the purpose of soldering high chromium-containing alloys, including stainless steel. **Indalloy® Flux #2** also has proven to be an effective flux for soldering to NiTi (Nitinol) alloys. Other metals for use with **Indalloy® Flux #2** are: copper, brass, lead, chrome, galvanized iron, and steel.

Due to its corrosive nature, **Indalloy® Flux #2** 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 corrosion. **Indalloy® Flux #2** does not progressively corrode stainless steel (no neutralization necessary), but cleaning is still advisable as the flux/flux residue may still attack the solder. 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. The addition of Citric Acid to wash water may improve flux removal efficiency.

## Solder Alloy Compatibility

**Indalloy® Flux #2** is compatible with all types of solders.

## Flux Application

**Indalloy® Flux #2** can be brushed on, dispensed, or sprayed. However, due to the flux's corrosive nature, application equipment should be acid resistant.

## Technical Specifications

Indium Part Number (IPN)	84002
Activation Range	100–371°C
Specific Gravity	1.53gm/cc
Flash Point	Non-flammable
Chloride Content	No zinc or other heavy metal chlorides
pH	1–1.5
Appearance	Water white
Cleaning	Warm water (<50°C) and mechanical scrubbing
Shipping	Transport in accordance with applicable regulations and 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.

## From One Engineer To Another®

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