

PRODUCT DATA SHEET

Indalloy® Flux #3

Introduction

Indalloy® Flux #3 is a high-viscosity liquid flux formulated for the purpose of soldering aluminum. **Indalloy® Flux #3** also has proven to be an effective flux for soldering to NiTi (Nitinol) alloys. Other metals for use with **Indalloy® Flux #3** are: copper, brass, chrome, and stainless steel.

Due to its corrosive nature, **Indalloy® Flux #3** 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. 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 #3 works best with tin-containing alloys. It is not recommended for indium-containing alloys due to indium's sensitivity to chloride-induced corrosion.

Flux Application

Due to the higher viscosity, **Indalloy® Flux #3** is probably best applied by brush or swab. Any flux application equipment should be resistant to halide corrosion.

Technical Specifications

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|--------------------------|--|
| Indium Part Number (IPN) | 84003 |
| Activation Range | 96–343°C |
| Specific Gravity | 1.33gm/cc |
| Flash Point | 93°C |
| Chloride Content | Contains chlorides |
| pH | 8 |
| Appearance | Yellow to pale green |
| 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.

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Form No. 97809 (A4) R1 



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