

Product Data Sheet

Wave Solder Flux 1025 Water-Soluble

Features

- High activity
- Low solids
- Leaves shiny solder joints
- Cleans to low ionic levels

Introduction

Wave Solder Flux 1025 is a high activity, versatile, water-soluble wave soldering flux formulated to maximize yields and reduce defects on surface-mount and mixed-technology assemblies. It has a broad processing range and provides excellent wetting.

Process Recommendations

Wave Solder Flux 1025 can be applied by foam, dip, wave or spray fluxing equipment. When foam fluxing the following guidelines will provide the best results:

- Keep foam head, wave height or pot level consistent through appropriate adjustments. Replace flux after every forty (40) hours of operation.
- Adjust the specific gravity to the nominal level of +/- 0.01 either with automated equipment or manually with a hydrometer. Evaporated solvent should be replenished by the addition Indium 16-1020 thinner.
- Add fresh flux to maintain the appropriate level.
- Clean fluxing equipment regularly to remove debris, trapped oil or water. When foam fluxing, clean the foaming stone in D.I. water first, then in then in Indium 16-1020 thinner.
- Residues rinse away in 120-140°F water. Cleaning should be completed directly after the soldering process.

Safety Precautions

All fluxes with low flash points should be handled with caution. Store in a dry, well-ventilated area away from sparks, flames and direct heat.

Packaging

- 5 gallon containers
- 55 gallon drums

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.

Material Safety Data Sheet

The MSDS for this product can be found online at <http://www.indium.com/techlibrary/msds.php>

Physical Properties

Test	Result	
	1025	16-1020
Color:	Light Straw Color	Clear
Specific Gravity: @25°C (77°F) @15.5°C (60°F)	0.952	0.876
	0.956	0.881
J-STD-004A		
Flux Type Classification	ORH1	NA
Solids Content	19.76%	0
Flash Point (°F TCC)	54	54

This product data sheet is provided for general information only. It is not intended, described which are sold subject exclusively to written warranties and limitations and shall not be construed, to warrant or guarantee the performance of the products thereon included in product packaging and invoices.

Form No. 97718 R2

S O L D E R

INDIUM CORPORATION OF AMERICA®

www.indium.com
askus@indium.com
PRC +86 (0)512 628 34900
SINGAPORE +65 6 268 8678
UK +44 (0) 1908 580400
USA +1 315 853 4900



ISO 9001
REGISTERED