PRODUCT DATA SHEET
Wave Solder Flux 1081
Water-Soluble

Introduction
Wave Solder Flux 1081 is a water-wash organic flux suitable for all conventional tin-lead alloys. Wave Solder Flux 1081 exhibits excellent solderability with low ionic residues after aqueous cleaning.

Features
• Excellent solderability
• Wide process window
• Cleans to low ionic levels

Process Recommendations
Wave Solder Flux 1081 was developed for use in various electronic soldering applications where high halide-containing organic fluxes are too corrosive and rosin-based fluxes are too inactive.

The flux residues readily rinse away with warm water 49–60°C (120–140°F).

Wave Solder Flux 1081 is best applied by foam fluxing equipment. The best results can be obtained by following these guidelines:

1. Keep foam head, wave height, or pot level consistent through appropriate adjustments. Replace after 40 hours of operation.
2. Adjust specific gravity to the nominal level, ±0.01, with #16-1081 Thinner.
3. Add fresh flux to maintain the appropriate flux level.
4. Clean fluxing equipment regularly to remove debris, trapped oil, or water. When foam fluxing, clean foaming stone with #16-1081 Thinner whenever the flux is changed, or as needed.

Physical Properties

<table>
<thead>
<tr>
<th>Test</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>1081</td>
<td>16-1081</td>
</tr>
<tr>
<td>Color</td>
<td>Light Amber</td>
</tr>
<tr>
<td>Specific Gravity at 25°C (77°F)</td>
<td>0.957</td>
</tr>
<tr>
<td>Specific Gravity at 15.5°C (60°F)</td>
<td>0.963</td>
</tr>
<tr>
<td>Solids Content</td>
<td>28.44</td>
</tr>
<tr>
<td>Flash Point (°F TCC)</td>
<td>65°</td>
</tr>
<tr>
<td>J-STD-004A Flux Type</td>
<td>ORH0</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>2 years from DOM</td>
</tr>
</tbody>
</table>

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

Packaging
• 5-gallon containers
• 55-gallon drums

Safety
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. Consult the Safety Data Sheet for full details.

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 Sheet
The SDS for this product can be found online at www.indium.com/sds

From One Engineer To Another
Contact our engineers today: askus@indium.com
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