

## 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,  $\pm 0.01$ , 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

Test	Result	
	1081	16-1081
Color	Light Amber	Clear
Specific Gravity at 25°C (77°F) at 15.5°C (60°F)	0.957	0.787
	0.963	0.793
Solids Content	28.44	0
Flash Point (°F TCC)	65°	65°
J-STD-004A Flux Type	ORH0	N/A
Shelf Life	2 years from DOM	N/A

*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](http://www.indium.com/sds)

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