

## PRODUCT DATA SHEET

# Wave Solder Flux #1010

## Water-Soluble

### Introduction

**Wave Solder Flux #1010** is a versatile VOC-free water-soluble wave flux that provides excellent solderability on difficult to solder assemblies. **Wave Solder Flux #1010** is biodegradable and cleans to low ionic levels, leaving the assembly with high surface insulation resistance (SIR).

### Features

- Non-flammable
- High activity
- Wide process window
- Use with Pb-free and SnPb assembly processes

### Process Recommendations

**Wave Solder Flux #1010** should be applied by ultrasonic spray for best results. Topside board temperatures can range from 100–150°C (300°F) depending on equipment capability and assembly requirements. Preheat temperature should be adjusted to ensure complete water removal before contact with the solder wave.

A thin uniform flux deposition of 500–1,000 micrograms per square inch of flux solids should be applied as a starting point.

Because **Wave Solder Flux #1010** is water-based, it does not require frequent acid value monitoring. If thinning is required, deionized water should be used.

**Wave Solder Flux #1010** may freeze if exposed to temperatures below 0°C (32°F). If the flux becomes frozen, bring to room temperature until thawed and agitate. The material is not affected by freezing.

Flux residue cleans best in water 49–60°C (120–140°F). A final rinse in deionized water will produce the best results.

### Physical Properties

Test	Result
Color	Clear
Specific Gravity @ 25°C (77°F) @ 15.5°C (60°F)	1.055 1.058
Solids Content	20%
Flash Point (°F TCC)	None
J-STD-004A Flux Type	ORH1
Shelf Life	2 years

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

### 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 Materials 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

Please refer to the SDS document within the product shipment, or contact our local team to receive a copy.

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.

*All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified.  
Indium Corporation is an ISO 9001:2015 registered company.*

## From One Engineer To Another®

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