

# PRODUCT DATA SHEET

# 1081-T

## Wave Solder Flux

### Introduction

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

### Features

- Excellent solderability
- Wide process window
- Cleans to low ionic level

### Process Recommendations

**1081-T** 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 residue readily rinses away with warm water 49–60°C (120–140°F).

With reduced solids, **1081-T** is especially adaptable to spray application, but can also be applied by foam. If foam-fluxing, use the following guidelines for best results:

- Keep foam head, pot level, or wave height consistent through appropriate adjustments. Replace after every 40 hours of operation.
- Adjust the specific gravity to the nominal level of  $\pm 0.01$  with Indium Corporation's 16-1081-T Thinner.
- Add fresh flux to maintain the appropriate level.
- Clean fluxing equipment regularly to remove debris, trapped oil, or water. When foam-fluxing, clean foaming stone in Indium Corporation's 16-1081-T Thinner whenever the flux is changed, or as needed.

### Safety Precautions

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

### Physical Properties

Test	Result	
	1081-T	16-1081-T
Color	Light amber	Clear
Specific Gravity @ 25°C (77°F) @ 15.5°C (60°F)	0.908 0.913	0.804 0.809
Flash Point (°F TCC)	68	55
Solids Content	12.57%	0%
J-STD-004 Flux Type	ORH0	N/A
Shelf Life	2 years	N/A

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

### Thinning

Dilution is seldom required. If thinning is needed, it is suggested you use Indium Corporation's 16-1081-T Thinner.

### Packaging

- 5 gallon containers
- 55 gallon drums

### Safety

Flammable liquids should always be stored in a dry, well-ventilated environment away from open flames, sparks, or direct heat.

### 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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