

# ARCTEC® SF 110 SOFT SOLDER



a quality welding alloy

## GENERAL CHARACTERISTICS:

ARCTEC® SF 110 is a high grade soft solder containing silver and tin. It does not contain any lead, zinc or cadmium. Excellent for a variety of non ferrous metals except for aluminum and magnesium alloys. Use with an oxyacetylene, butane or propane torch and ARCTEC® # 3 Soft Solder Flux.

## APPLICATIONS:

ARCTEC® SF 110 is recommended for soldering a variety of metals such as stainless steel, copper, nickel alloys, brass, bronze and other nonferrous metal except aluminum and magnesium. For use on electrical appliances, food handling equipment and instrumentation.

## WELDING PROCEDURE:

Clean the weld zone free of all contaminants and remove surface oxides and by brushing with a stainless steel or fibre brush. Apply ARCTEC® #3 Soft Solder Flux to the joint. Heat area with oxyacetylene, butane, or propane flame. Add solder and continue heating until solder flows into joint. Electrical or other soldering irons may also be used. Flux residue may be removed using hot water and a brush.

## MECHANICAL PROPERTIES:

Average tensile strength*:	Copper to Copper 14,300 psi (98Mpa)	Stainless to Copper and Brass 10,000-28,000 psi (68-193Mpa)
Elongation:	21%	28%

*\*Caution: Tensile strengths on solder joints are average values only as several variables such as procedure used, material being soldered, joint design, fit up, etc. will affect the joint strength. Exact tensile strength values can only be determined by conducting test on the actual joint design utilized.*

## OPERATING PARAMETERS:

Solidus:	430°F (220°C)
Liquidus:	430°F (220°C)
Working Temperature:	430°F (220°C)

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