S-65® COPPER

ACID-FREE SOLDERING FLUX FOR COPPER PIPING



PRODUCT DESCRIPTION
Acid-free soldering flux for copper piping.

FIELD OF APPLICATION
For soft soldering of copper (drinking) water, central heating and gas pipes to copper or brass fittings with a diameter up to 22 mm. To be used in combination with solid tin/silver or tin/copper solder.

PROPERTIES
· 100% water washable
· Soluble in water
· Acid-free
· Powerful cleaning effect
· Maximum temperature range 300°C
· With brush

CERTIFICATES & STANDARDS

Certificates	
kiwa	KIWA: Fluxes and tin plating pastes for soft soldering of capillary connections. Approved for drinking water. Certificate K6077 based on BRL K624.

Standards	
	ISO 9454-1 / 2.1.2.A

PREPARATION
Tools: Soldering iron or burner, lead-free soft soldering alloy, scouring fibre, pipe cutter, fitting brush, deburrer, heat shield, cloth

APPLICATION
Directions for use:
1. Sand joining surfaces well and clean (bare metal) with Griffon scouring fibre. 2. Apply flux evenly with brush to both joining surfaces. Avoid overuse of the flux. 3. Assemble joint. Use only well-fitting parts. Avoid overheating the flux, as this will hamper the flow of the solder. 4. Heat joint evenly and add tin solder. Allow the solder to melt onto the soldered seam and not in the flame or on the iron. Completely fill soldered seam. 5. Remove flux residue with water or a damp cloth. 6. Allow joint to cool in air.
Stains/residue: Immediately remove stains with water or a damp cloth.
Points of attention: Use Griffon Heat-Shield to protect walls, tiles, wallpaper, paint and plasterwork, for example.

TECHNICAL SPECIFICATIONS

Density approx.:	1,09 g/cm^3
pH-value approx.:	6
Viscosity approx.:	300 mPa·s

STORAGE CONDITIONS
Shelf life: At least 24 months after production.
Stored in unopened packaging between +5°C and +25°C.
Close packaging properly after use and store in a dry, cool, and frost-free location.
Limited shelf life after opening.

Our advice is based on extensive research and practical experience. However, in view of the large variety of materials and the conditions under which our products are applied, we assume no responsibility for the results obtained and/or any damage caused by the use of the product. Nevertheless, our Service Department is always at your disposal for any advice needed.