

Handy Flo® 822 DF 822

GENERAL DESCRIPTION

Handy Flo 822 is a zinc chloride base, liquid flux developed for soldering of stainless steel, steel, copper, brass, nickel and plated base metals. This system is corrosive. The flux residue will need to be neutralized and removed following soldering operation. This system is recommended for use in most soldering applications including torch and furnace.

PRODUCT APPLICATION

Handy Flo 822 is recommended for use with solder filler metals that flow between 350°F - 500°F (177°C - 260°C). This product is recommended for use with many of the common Silvabrite® alloy formulations which include silver-tin, tin-lead, or tin-antimony combinations. Handy Flo 822 has been used in various applications including automotive and food handling industries.

POST CLEANING

This product is corrosive and a special post soldering cleaning or rinsing operation is required. Water rinse is not adequate for removal of this flux. The following is a recommended practice for removal of Handy Flo 822 flux residue:

- a. Hot water rinse
- b. 2% hydrochloric warm bath rinse
- c. Hot water rinse
- d. Neutralizing with baking soda or soda ash
- e. Hot water rinse

SOLDERING CHARACTERISTICS

Handy Flo 822 will produce satisfactory joints on most steels, brass, copper and plated assemblies. It is not recommended to use in aluminum bronze or other aluminum alloy applications. This product is corrosive and a post-braze cleaning or rinsing operation is required.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the paste products are stored away from direct heat. Paste may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

Handy Flo and DF products are available in a variety of packaging options including pint, quart, and gallon containers.

SPECIFICATIONS

Handy Flo 822 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-822.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Safety Data Sheet for Handy Flo 822/DF 822

WARRANTY CLAUSE

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