



- Easy to use
- Savings from accurate dosing
- Food-grade 100% pure tin
- Controlled grading

SOLDER PAINTS

Solder paint is a uniform mixture of metal powder and flux. This "all in one" concept saves time and ensures that the quantity of solder to be deposited is accurately dosed. Food-grade 100 % pure tin is ideal for tinning copper saucepans.

Code	Description	Solid	Liquid	Packaging
29347	Solder paint Sn40 - 450 g tubs	183 °C	245 °C	Loose
29348	Solder paint Sn40 - 1 Kg tubs	183 °C	245 °C	Loose
29346	Solder paint Sn60 - 800 g and 1 Kg tubs	183 °C	187 °C	Loose
33451	Solder paint Sn100 - 1 Kg tubs	232 °C		Loose

SOLDER PASTES

Solder paste is a type of paste that allows more precise joining of parts that do not require such powerful fluxing. The choice of powders and the quality of the flux used allow more meticulous use as part of a perfectly controlled process. This product is supplied in syringes to allow extremely precise application and ensure superior join quality.

Code	Description	Solid	Liquid	Packaging
799010	I SCR7 96.5Sn 3.5Ag PM2S	221 °C		30 cc syringes
701210	FL RS7/B adhesive flux			30 cc syringes
80006	Méta DR031 62/36/Ag2 - 85 % - 400 Pa	178 °C	190 °C	500 g cartridges
35589	PM2S (T2) SCR3 cream: Sn62 Pb36 Ag2 400Pa 85%	178 °C	190 °C	500 g tubs or cartridges

POWDERS

Our powders are obtained from primary metal, which undergo a special manufacturing process in a vacuum to yield a perfectly calibrated, totally unoxidised metallic powder.

Standard alloys	Solid	Liquid	Standard alloys	Solid	Liquid
Sn100	232 °C		Sn63Pb37	183 °C	
Sn96Ag4	221 °C		Sn62Pb36Ag2	178 °C	190 °C
Sn99Cu1	227 °C		Sn43Pb43Bi14	144 °C	163 °C
Sn42Bi58	138 °C		Sn10Pb88Ag2	268 °C	299 °C
Sn60Pb40	183 °C	188 °C			



CHARACTERISTICS

Pastes and pastes are formed of uniform dispersions of a powdered solder alloy in a flux and a suspended medium. Powders consist of uniform particles of the required alloy.

Pastes packaging:

500 g tubs/500 g cartridges

10 cc or 30 cc syringes (approx. 30 g or 100 g)

Pastes storage:

12 months in a refrigerator at 10°C +/- 5°C

Normal service temperature: 20 to 25°C

Short-term maximum temperature: 2 h at 45°C

TYPICAL APPLICATIONS

Solder paints are produced for a wide range of industrial applications:

Joining copper, brass, copper alloys and steel.

Tinning steel products.

Assembling pipes and fittings for plumbing, heating and air conditioning systems.

Repairing car radiators, mechanical systems, sprinklers, etc.

Creams are used in all industrial sectors requiring soft, simple, safe, precise and effective soldering.

FLUX FOR PASTES

Unlike pastes, which contain a highly-activated universal flux, creams use different fluxes for different applications. As such, our paste range includes seven different fluxes, each formulated for a particular type of activation:

Flux	Activation
RMA 500	Resin base - medium activation
OA 800	Resin base - organic activation
4100	High zinc chloride activation
IA 72	Medium zinc chloride activation
OA68+	High organic activation
ISCR7	Resin base - high activation
ISCR3	Resin base - medium activation

INSTRUCTIONS FOR USE

Our solder pastes are designed to be applied with a paintbrush or using wide-needled syringes. Use a blowtorch to melt the alloy.

The combined action of the flame and the flux distributes the paint evenly, making for watertight joints and adequate mechanical strength.

Our solder pastes are designed to be applied:

- By manual or automatic dosing via a syringe,
- By spreading the cream through a screen-printing screen.

The paste can then be remelted, either in a flame, in a furnace, by induction or by electric heating elements.

Solder pastes are particularly well-suited to industrial requirements. Using these pastes simplifies the brazing procedure and shortens the manufacturing cycle.

NOTES

Solder paints

As the flux is based on zinc chloride with additives that become inflammable if overheated, all reasonable precautions should be taken when heating with a blowtorch.

Solder pastes

We supply formulations containing zinc chloride-free fluxes and lead- and cadmium-free powders that comply with applicable occupational safety and environmental regulations.

Powders

Store the powder in a cool, dry place. Prolonged exposure to a damp atmosphere may cause caking.

We can provide technical advice to help you choose the most appropriate formulation and usage.

All the information in this document is provided for guidance only and Métaconcept declines all liability in respect thereto.