

# LOCTITE ARAX

February 2016

## PRODUCT DESCRIPTION

LOCTITE ARAX provides the following product characteristics:

<b>Technology</b>	Flux
<b>Application</b>	Soldering - Cored wire

LOCTITE ARAX alloy is a tin/lead alloy used in traditional electronic assembly soldering applications.

## FEATURES AND BENEFITS

- Reduces labor cost
- Assists automatic soldering processes
- Correct proportion of extra fast acting flux applied to each joint
- Safe, fast and easy to use

## APPLICATIONS

Arax Cored Solder Wire is suitable for use on the following materials:

- Brass
- Bronze
- Cadmium Plating
- Copper
- Galvanized Ware
- Iron
- Lead
- Mild steel
- Nickel and nickel plating
- Silver
- Spring Steel
- Most stainless steel (using 96S ARAX)
- Tin Plate
- Zinc and zinc plating

## ADVANTAGES

LOCTITE ARAX cored solder wire solders faster than using solid solder with a separate flux since only one operation is required which produces a more uniform spreading of the solder. The flux is automatically applied at the correct time, in the correct proportion and in the correct place.

Pre-cleaning is not normally necessary and the speed of its fluxing actions ensures that the solder will flow between laps by capillary action, giving maximum strength with the minimum amount of solder.

LOCTITE ARAX cored solder wire contains multiple cores of flux to ensure flux continuity and more rapid flux flow than would be obtained with a single central core. The flux is faster, yet less acidic than zinc chloride or similar liquid fluxes and spitting is reduced.

## DIRECTIONS FOR USE

### Flux Residues

The residues of the Arax flux would, under dry conditions, be non-corrosive. However, as the work is usually exposed to humidity,

the residues after soldering would, over a long period of time, absorb moisture, becoming mildly corrosive.

The residues should, therefore, be removed with water (preferably warm). However, where the flame heating is employed, the flux will be extensively volatilized by the soldering operation. In addition, it will not contaminate plating baths.

This flux residue, if not removed, is considerably less corrosive than most separate fluid or paste fluxes. Consequently, if LOCTITE ARAX cored solder wire is being used in place of stick solder and a fluid and flux residue was not previously removed, there should be no need to do so when using LOCTITE ARAX.

## SUPPLY FORMS

LOCTITE ARAX is available in a range of alloys and wire diameters. This material is also available as a separate liquid or flux paste.

## GENERAL INFORMATION

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

### Not for Product Specifications

The technical information contained herein is intended for reference only. Please contact Henkel Technologies Technical Service for assistance and recommendations on specifications for this product.

### Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

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