

## ALPHA 857 WATER SOLUBLE FLUX

### DESCRIPTION

**Alpha 857** is a liquid flux formulated for producing defect free assemblies in wave soldering processes employing water cleaning.

### FEATURES & BENEFITS

#### FEATURES

FAST WETTING

FULLY WATER SOLUBLE

EXCELLENT SOLDERABILITY

EASY FOAMING

#### BENEFITS

DEFECT FREE SOLDERING

EASILY CLEANED

WIDE PROCESS WINDOW

### APPLICATION

**Alpha 857** is a low smoking, efficient foam flux. Using moderate air flow rates, it's fine bubble foam head is fast breaking, and recovers rapidly for effective coverage at high production speeds.

The consistency of **Alpha 857** should be maintained by the addition of thinner to compensate for evaporation losses. It is recommended that the specific gravity at 25°C be maintained within the range 0.860-0.875. Only **Alpha 425** Thinner should be used for this purpose, to ensure consistency of flux foaming and soldering characteristics.

The residues wash off easily to very low levels of ionic contamination. Water washing can be achieved without the use of rinse aids, and with little or no foaming. The flux is formulated so that the cleaning process water effluent is completely biodegradable. Local regulations may require pretreatment to raise the pH and remove dissolved lead from the water effluent.

For high reliability applications, it is recommended that assemblies are checked for ionic contamination using a MIL approved contaminometer such as the **Alpha Ionograph** or the **Alpha Omegameter**.

**Alpha Metals** also supply a range of complimentary materials designed for water cleaning including: Water soluble solder pastes, e.g. **WS609**, water soluble temporary solder masks, e.g. **K2680**, water soluble solder pot oils, e.g. **K590** and water soluble cored solder wire, e.g. **Purecore**.

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## PHYSICAL PROPERTIES

Appearance	Clear, pale yellow liquid
Solids Content, % wt/wt	18
Specific Gravity @ 25°C	0.865 ± 0.005
Typical pH of 5% solution	2.8
Flash Point (T.C.C.)	15.5°C
Recommended Alpha Thinner	425

## HEALTH & SAFETY

Observe standard precautions for handling and use. Use in well ventilated areas. **DO NOT SMOKE.** Avoid prolonged or repeated contact with the skin by the use of solvent resistant gloves. Avoid contact with eyes.

Flammable, keep away from sparks and open flames. Empty containers can still be a flammable hazard from residual vapours.

Remove skin splashes by immediate washing with soap and water.

In order to carry out your full COSHH assessment, consult the product Material Safety Data Sheet (MSDS)

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