

■ General Description

ELFLUX 6001 WW SS is a very active, solvent-based water-soluble flux. ELFLUX 6001 WW SS has been developed especially for dip soldering and roller-tinning applications. Regarding its activity ELFLUX 6001 WW SS is positioned between the rosin-based fluxes and the fluxes containing zinc chloride. The active components decompose at soldering temperature and leave only small amounts of residues.

■ Areas of Use

ELFLUX 6001 WW SS works well on copper and copper alloys, on tinned surfaces as well as electroplated nickel and silver surfaces, or even on low-alloyed steel.

In many cases the minor residues are not corrosive since the active components decompose during the soldering process and evaporate. In case of applications where the soldering temperature is reached only locally only the minimum required flux quantity should be applied. Flux that is not heated up to soldering temperature may subsequently lead to corrosion. The same is true for flux splatters. In such cases flux residues should be washed off with water

■ Classification

ELFLUX 6001 WW SS is classified as ORH1 acc. to DIN EN 61190-1-1.

■ Technical Specification

| | ELFLUX 6001 WW SS | Thinner 200 |
|-----------------------------------------------|---------------------------|---------------------------|
| Appearance | Clear, transparent liquid | Clear, transparent liquid |
| Smell | Alcoholic | Alcoholic |
| Density [g/cm ³] (20 °C) | 0.876 ± 0.003 | 0.784 ± 0.003 |
| Solids content [%] (per IPC-TM-650 2.3.34) | 9.8 | None |
| VOC content [%] | 73, Solvent-based | 100, solvent-based |
| Acid number [mg KOH/gFlux] | 62.5 ± 2.5 | < 1 |
| Halides [%] | 2.1 (as chloride) | None |
| pH value (20 °C) | 3 ± 1 | Neutral |
| Flash point [°C] | 12 | 12 |
| Ignition temperature [°C] | 399 | 399 |
| Recommended thinner | 200 | |

■ Application

The flux can be applied by dipping, brushing, or spraying.

■ Process Control

Thinner 200 is used to control the density of ELFLUX 6001 WW SS.

■ **Cleaning**

Cleaning of the flux residues: the residues can be washed off with tap water.

■ **General Safety Precautions**

ELFLUX 6001 WW SS should be used according to industrial standards of practice. For safety advice please refer to the material safety data sheet.

■ **Packing Sizes**

ELFLUX 6001 WW SS, as well as Thinner 200, is available in containers of 10 L and 20 L.

■ **Storage**

ELFLUX 6001 WW SS is flammable. Store away from sources of ignition. Observe a temperature range of 5 – 25 °C.

■ **Shelf Life**

Under adequate conditions ELFLUX 6001 WW SS can be stored in original unopened containers for a minimum of 12 months.

The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.