



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S NO.1 STAINLESS STEEL FLUX Part No. 02-00 Series

DESCRIPTION:

Johnson's No. 1 Stainless Steel Flux is a zinc chloride flux solution that contains free hydrochloric acid, for use where an extremely aggressive flux is required for good soldering. Primarily used for soldering stainless steels, chrome plate and other difficult-to-solder metals, Johnson's No. 1 can also be used as a general purpose flux for other metals by dilution with water.

PHYSICAL DATA:

Specific Gravity	1.300 ± .005 (As Shipped)
pH	0-1
Solubility in Water	100 %
Appearance	Clear, Light Yellow Liquid

SPECIFICATIONS:

Johnson's No. 1 Stainless Steel Flux conforms to the following government specifications: O-F-506c Flux, Soldering - Liquid - Type II, Form B; MIL-F-4995, Flux, Soldering - Type III; A-A-51145C, Type II, Form B (July 18, 1985)

USAGE:

This flux may be used as shipped, or diluted with water. When diluted two (2) parts of water to one (1) part flux, it still yields a solution with the specific gravity of approx. 1.10, and a pH of 0.

HANDLING:

Wear protective clothing and eye wear when handling this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information. Store, mix and use in non-metallic containers only. This flux is non-flammable.

WASTE DISPOSAL:

Johnson's No. 1 Stainless Steel Flux must be neutralized before discharging into the sewer. Beyond this, we cannot make specific recommendations due to variations in local laws.



TO ORDER CALL (800) 747-0030, FOR SUPPORT CALL (563) 289-5123, TO SEND FAX (563) 289-3825, EMAIL TO johnsonmfg@aol.com