



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S B-120 ORGANIC PRODUCTION FLUX Part No. 17-60 Series

DESCRIPTION:

Johnson's B-120 represents a real advancement in the field of organic soldering flux chemistry, which is designed to put an end to the green corrosion long associated with the use of inorganic, chloride fluxes. This flux withstands higher temperatures than most other organic fluxes, it produces stronger solder bonds, and it leaves a cleaner work piece that is essentially free of corrosive residues.

Because Johnson's B-120 is so highly concentrated, it has many uses including: the high speed strip tinning of brass and copper coil or tube stock, for core baking and header dipping automotive radiators, as well as soldering most other heat exchangers, and it is especially good for face dip-soldering heater cores. Its aggressive formulation pulls lead/tin solders, even those having as little as 2% tin, deep into capillary spaces. When properly applied, and heated to full soldering temperatures, Johnson's B-120 produces strong solder bonds, before it nearly completely volatilizes, leaving little or no corrosive residues behind on surfaces, or in the tubes or water channels. As a result, products such as radiators and heater cores are less likely to suffer internal corrosion during extended shelf life.

This is truly one of the most unique organic soldering fluxes we know of. It tolerates most types of heat, including open flame, and it remains active until reaching approximately 575° F. Johnson's B-120 Organic Production Flux contains no amine complexes to retard the chelation process during eventual waste water treatment operations.

PHYSICAL DATA:

Specific Gravity	1.31 ± .005 @ 60° F (As Shipped)
pH	0-1
Physical Appearance	Yellow Color
Odor	Slight Acidic Odor

USAGE:

Apply flux with brush, spray, swab or dip. For hand soldering use as packaged, or dilute with equal parts of clean water. For header dipping radiators use up to 2:1 dilution, for strip tinning copper or brass use a 3:1 dilution, for face dipping heater cores dilute up to 4:1. For core baking operations this flux may be diluted with up to 13 parts of clean water.

HANDLING:

Johnson's B-120 contains free hydrobromic acid and therefore, store, mix, and use in non-metallic containers only. Wear protective clothing and eye wear when handling this flux. Avoid mixing this flux with other chemicals. Please refer to the *OSHA Material Safety Data Sheet* for additional information.



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

WASTE DISPOSAL:

This flux should be neutralized with soda ash or lime before disposal. Additional treatment may be required to remove heavy metals dissolved into this flux during use. Beyond this, we cannot make specific recommendations because local laws vary.