



# Technical Bulletin

JOHNSON MANUFACTURING COMPANY  
Princeton, Iowa 52768-0096

## JOHNSON'S WELL-DIP DIP SOLDERING FLUX Part No. 18-75 Series

### DESCRIPTION:

Johnson's Well-Dip Soldering Flux is specially blended for dip soldering radiator headers to seal the tube-to-header joints. This flux contains Zinc Chloride and Hydrobromic Acid to provide extra cleaning power at elevated solder pot temperatures or during extended dwell times.

### PHYSICAL DATA:

Specific Gravity	1.20± .005 @ 60° F (As Shipped)
pH	1-2
Solubility in Water	100%
Appearance	Clear, Light Yellow Liquid
Odor	Slight Wintergreen Smell

### USAGE:

For best results, the proper dilution range is from 1:1 to 2:1 (2 parts clean water to 1 part flux) however, further adjustment may be necessary based on the mass being soldered and the throughput.

### HANDLING:

Wear protective clothing and eye wear when handling this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information.

### 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.



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