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# ACID CORED SOLDER WIRE FOR METAL FABRICATION

## ARAX

- **Reduces labour costs**
- **Assists automatic soldering processes**
- **Correct proportion of extra fast acting flux applied to each joint**
- **Safe, fast and easy to use**
- **Replaces tinmans and blowpipe solders, fluid and paste fluxes, killed spirits**

### APPLICATIONS

Arax Cored Solder Wire is suitable for soldering to the following materials.

- Brass
- Bronze
- Cadmium plating
- Copper
- Galvanised ware
- Iron
- Lead
- Mild steel
- Nickel and nickel plating
- Resistance wires (most types) – flux residues should be removed
- Silver
- Spring steel
- Most stainless steels (using 96S Arax)
- Tin plate
- Zinc and zinc plating

### ADVANTAGES

Multicore Arax cored solder wire solders faster than using solid solder with a separate flux since only one operation is required which produces more uniform spreading of the solder. The flux is automatically applied at the correct time, in the correct proportion and in the correct place.

Pre-cleaning is not normally necessary and the speed of its fluxing actions ensures that the solder will flow between laps by capillary action, giving maximum strength with the minimum amount of solder.

Arax cored solder wire contains multiple cores of flux to ensure flux continuity and more rapid flux flow than would be obtained with a single central core. The flux is faster, yet less acidic than zinc chloride or similar liquid fluxes and spitting is reduced.

Soldering with Arax cored wire is therefore simpler, neater, safer and cleaner.

### FLUX RESIDUES

The residues of the Arax flux would, under dry conditions, be non-corrosive, however as the work is usually exposed to humidity, the residues after soldering would, over a long period of time, absorb moisture, becoming mildly corrosive.

The residues should therefore be removed with water (preferably warm), but where flame heating is employed the flux will be extensively volatilised by the soldering operation. In addition, it will not contaminate plating baths.

This flux residue, if not removed, is considerably less corrosive than most separate fluid or paste fluxes. Consequently, if Arax cored solder wire is being used in place of stick solder and a fluid flux and the flux residue was not previously removed, there should be no need to do so when using Arax cored solder wire.

### SUPPLY FORMS

Arax cored solder wire is available in a range of alloys and wire diameters. Arax is also available as a separate liquid or flux paste.

## HEALTH AND SAFETY

Users must refer to to the Material Safety Data Sheets relevant to specific Multicore Arax flux cored solder wires before use.



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