

StainTin 157 PA

Low Temperature, Self-Fluxing, Tin-Silver Soldering Paste

DESCRIPTION

Eutectic StainTin 157PA is a paste soldering alloy particularly suited to stainless steels, thoroughly compatible with most copper, aluminum and carbon steel alloys. The corrosion resistance of deposits in service ensure they remain bright and tarnish-free for a reliable, clean joint.

- Free-flowing eutectic alloy with good capillary action
- Controlled Viscosity for easy, precise application
- Excellent choice for automated brazing and soldering
- Ideal for 300 Stainless steels in Food, medical and delicate applications

APPLICATIONS

For soldering dairy utensils, food-handling equipment, plumbing fixtures, potable water containers and piping. Also useful for joining electrical connects.

PROCEDURE FOR USE

Preparation: Clean joint area with RotoClean® OS or use a proprietary VOC free solvent. Thoroughly mix the 157PA so that the flux and metal particles are well amalgamated and show a smooth consistency. Use a fine brush or spatula to apply the paste.

Note: It is important not to allow any movement while the solder alloy cools and solidifies.

Note: For the best results maintain joint clearances between 0.001" and 0.005".

TECHNIQUE: Heat insert parts slowly and indirectly to reduce thermal shock so as to promote uniform flow.

Note: During the melting phase it is important that the parts being soldered do not move. Observe flow indications so that all contact surfaces are fully soldered.

POST WELDING: Allow parts to cool naturally. Parts can be quenched to help with flux residue removal.

TECHNICAL DATA:

Tensile Strength: 105 N/mm² (15,000 psi)

Shear Strength: 68 N/mm² (10,000 psi)

Electrical Conductivity - IACS: 16.5%

Thermal Expansion Coef.: 12 x 10⁻⁶ in / F
(20 - 212°F)

Solidus Temperature1: 430°F (220°C)

Liquidus Temperature2: 430°F (220°C)

Maximum Brazing Temp.: 450°F (230°C)