

# ALPHA<sup>®</sup> WS-857

## WATER-SOLUBLE FLUX

### DESCRIPTION

**ALPHA WS-857** is a liquid flux formulated for producing defect-free assemblies in wave soldering processes employing water cleaning.

### APPLICATION

**ALPHA WS-857** is a low-smoking, efficient foam flux. Using moderate air flow rates, its fine-bubble foam head is fast-breaking, and recovers rapidly for effective coverage at high production speeds. This highly active flux will produce bright shiny solder connections.

### THINNING

The consistency of **ALPHA WS-857** should be maintained by the addition of thinner to compensate for evaporation losses. It is recommended that the specific gravity @ 25°C / 77°F be maintained between 0.860 and 0.875 by the addition of thinner. Only ALPHA 425 Thinner should be used for this purpose to ensure consistency of flux foaming and soldering characteristics.

### RESIDUE REMOVAL

The residues wash off easily to very low levels of ionic contamination. Water washing can be done without the use of rinse aids and with little or no foaming. The flux is formulated so that the cleaning process water effluent is completely biodegradable. Local regulations may require pretreatment to raise the pH and remove dissolved lead from the water effluent.

### TECHNICAL DATA

PHYSICAL PROPERTIES	TYPICAL VALUES
Appearance	Clear, Pale Yellow Liquid
Specific Gravity @ 25°C (77°F)	0.865 ± 0.005
Percent Nonvolatiles	18
Flash Point (TCC)	17°C (62°F)
Typical pH of 5% Solution	2.8
Recommended Alpha Thinner	425
IPC J-STD-004 Classification	ORH1

### PACKAGING

**ALPHA WS-857** is available in 1, 5, and 55 gallon containers.

### SAFETY

Please refer to the product MSDS as the primary source of health and safety information. Observe standard precautions for handling and use, such as well-ventilated areas and avoidance of prolonged or repeated contact with the skin. **ALPHA WS 857** is flammable; keep away from heat, spark and open flames.

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