

ALPHA[®] WS-856

NEUTRAL WATER-SOLUBLE FLUX

DESCRIPTION

Alpha WS 856 is formulated for defect-free soldering in processes employing water cleaning. It has a buffered activation system containing no free acid, and has a neutral pH. Its post-soldering residues are also non-acidic.

ALPHA WS 856 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 connections, even if cleaning is delayed for several hours. Flux residues remain water soluble and no corrosion products are visible.

TECHNICAL SPECIFICATIONS

Physical Properties	Typical Values
Appearance	Clear Liquid
Specific Gravity @ 25°C (77°F)	0.832 ± 0.005
Percent Nonvolatiles	15
Flash Point (TCC)	17°C (62°F)
Typical pH of 5% Solution	6.6
Shelf Life	24 months
J-STD-004	ORH1

THINNING

The consistency of 856 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 0.822 and 0.842 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 in water at 135°F or above, 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.

The water effluent is neutral, eliminating the need for pH adjustment prior to disposal. However, local regulations may require pretreatment to remove dissolved lead from the water effluent.

PACKAGING

ALPHA 856 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 856 is flammable, keep away from heat, spark and open flames.

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