

# ALPHA<sup>®</sup> RADSOL 2101

## Dipping Flux

### DESCRIPTION

**ALPHA Radsol 2101** is a non-chelating, non-corrosive residue flux formulated primarily for Copper/Brass heat exchanger manufacture. Developed as part of the Radsol 2000 range, it is principally used as a dipping flux for header plate to core soldering.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### FEATURES & BENEFITS

- Content high activity – excellent wetting and high quality joints.
- Zinc chloride free - ensuring inert, non-corrosive post soldering residues.
- Will not form stable Chelates – spent flux or wash waters, contaminated with heavy metals from soldering, can be treated by normal neutralizing effluent disposal plants without risk of chelate complexing (guarantees complete removal of heavy metals from properly treated effluent liquors).
- Non-carbonizing – will not leave solid or oily black residues.
- High temperature stability – ideal with high temperature and Lead-free soft solders.

**APPLICATION GUIDELINES**

Suitable for use with conventional or lead free soldering on Copper and Copper alloy components, primarily radiators. Dilution with water is recommended for most end-dipping applications, up to 1:2 or 1:4, depending on product and process. As a general rule, the lowest strength flux mixture compatible with satisfactory bonding should be the target. The dipping process must just cover the header plate. Neither flux nor solder should contact the fin material so that all flux used is heated to the soldering temperature and is thereby made inactive.

**TECHNICAL DATA**

Item	Typical Values	Item	Typical Values
Appearance	Clear colourless to pale yellow liquid	Flash Point (T.C.C.)	Not applicable
Specific Gravity @ 20 °C (68 °F)	1.125 to 1.155 g/cm <sup>3</sup>	Boiling Point	100 °C
Odor	Slightly Acrid	Shelf Life (from Date of Mfg.)	1.5 Years
pH, @100% w/w	< 1	Packaging Size	25 & 200 Liters

**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacDermidAlpha.com/assembly-solutions/knowledge-base](http://MacDermidAlpha.com/assembly-solutions/knowledge-base)**

**CONTACT INFORMATION**

**To confirm this document is the most recent version, please contact  
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE . Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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