

ALPHA[®] 855

Neutral Water-Soluble Organic Flux

DESCRIPTION

ALPHA 855 is a liquid flux formulated for use in mass soldering processes employing water cleaning. It uses a buffered, organic activation system containing no free organic acid, and has a neutral pH. Its post-soldering residues are also non-acidic.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

APPLICATION GUIDELINES

ALPHA 885 is an 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, even if cleaning is delayed for several days. Flux residues remain water-soluble, and no corrosion products are visible.

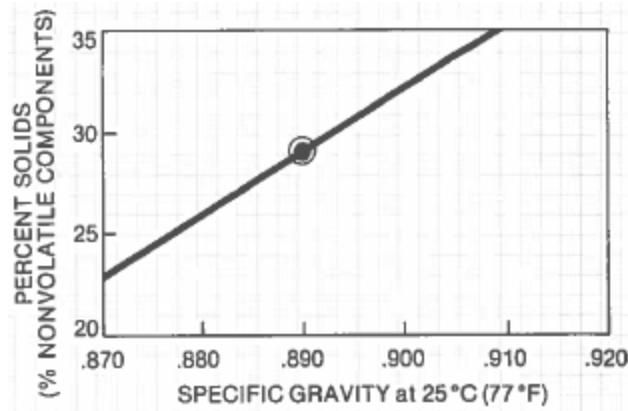
ALPHA 855 is suitable for soldering to the following metals.

Brass	Bronze	Cadmium	Copper
Gold	Iron	Iron Alloys*	Nickel
Silicon Bronze	Silver Solder (Plate)	Terne (Plate)	Tin / Nickel (Plate)

* Under favorable conditions only.

Residue Removal: The residues wash off easily even with lukewarm water, 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 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.

Thinning: The solids content of **ALPHA 855** should be maintained by the addition of thinner to compensate for evaporation losses. In general, it is recommended that the solids content not be allowed to increase by more than 5% before the addition of thinner. Only ALPHA 425 Thinner should be used for this purpose, to ensure consistency of flux foaming and soldering characteristics. Flux solids content is readily controlled by simple hydrometer measurement in conjunction with the graph shown below.



TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, pale yellow liquid	Pounds per Gallon @ 25 °C (77 °F)	7.4
% Solids (Nonvolatile Content)	29%	Shelf Life (from Date of Mfg.)	540 days
Specific Gravity @ 25 °C (77 °F)	0.890 ± 0.005	Flash Point (T.C.C.)	17oC
pH (5% Solution)	7.2	Packaging Size	1, 5, 55 gallons

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



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.**

CONTACT INFORMATION

To confirm this document is the most recent version, please contact
Assembly@MacDermidAlpha.com
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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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