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# SELECTRODE 5110 Liquid Soldering Flux

## INTERNATIONAL CLASSIFICATIONS

A-A51145C Type 1 Form B

## FEATURES & APPLICATIONS

5110 is a high active liquid flux used for removal and prevention of oxide, build up from all metals other than containing aluminum, magnesium, or titanium. Used primarily for the soldering of ferrous metals (i.e. stainless and steel) where a more aggressive flux is desired. Recommended for tin/lead, tin/antimony, tin/silver and many other solders. Not recommended for use on electrical applications.

## PHYSICAL PROPERTIES

<b>Form</b>	Clear Liquid
<b>Effective Temperature Range</b>	Up to 700°F (371°C)

**Soldering Techniques:** 5110 can be used with soldering iron and torch. Joint area should be thoroughly cleaned. Best results are obtained when maintaining a joint clearance of no more than .006". The entire joint area should be completely covered with 5110 flux. Heat part directly with a soft flame. As soon as flux starts to bubble, add solder to the joint. Continue heating until solder flows through the entire joint. Allow to cool slowly. Flux residue can be removed with hot water.

## SAFETY PRECAUTIONS

**First Aid:** If contact in eyes, flush immediately with water for 15 minutes. If swallowed, induce vomiting. Never give anything by mouth to an unconscious person. Call a physician.