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**TECHNICAL SPECIFICATION**

**H-20<sup>95</sup>  
WATER SOLUBLE TINNING FLUX**



**TECHNICAL SPECIFICATION:** Oatey H-20<sup>95</sup> Water Soluble Tinning Flux cleans, tins and fluxes most commonly soldered metals including copper, brass, zinc, galvanized iron, lead and tin or copper-coated metals. Fluxing is a critical step in the soldering process. H-20<sup>95</sup> Tinning Flux is lead-free and ideal for copper systems including fire sprinkler, hydronic heating, potable water service and DWV piping. H-20<sup>95</sup> Tinning Flux remains active up to 700° F. H-20<sup>95</sup> Flux complies with CA & VT lead content regulations.



**PHYSICAL/CHEMICAL PROPERTIES**

Appearance	Greenish-Gray Paste
Shelf Life	1 year from manufacture date
pH	3-4
Solder Temp. Range	400-700 F

**DIRECTIONS FOR USE**

Paste Fluxes require only a small amount of flux applied to the joint. Clean all surfaces before soldering. Apply small amount of flux inside the fitting and outside of the pipe. Heat to temperature required for soldering. Do not overheat the piping. For small diameter piping, direct the heat near the joint. For large diameter piping, move the heat around the joint to ensure adequate solder flow around the circumference of the joint. NOT FOR USE WITH ALUMINUM, STAINLESS STEEL OR MAGNESIUM. DO NOT USE ON ELECTRICAL PARTS.

When soldering process is complete, allow joint to cool undisturbed. Remove any flux residual with a damp cloth. Do not store H-20<sup>95</sup> Tinning Flux above 120° F.

**PRECAUTIONS**

Read all cautions and directions carefully before using this product. Apply flux with brush- do not apply with fingers. Wash thoroughly after handling and before eating. Eye/Skin contact may cause intense irritation and injury. In case of eye/skin contact, flush freely with water and seek medical attention immediately. If swallowed, DO NOT INDUCE VOMITING, drink water and call a physician or poison control center immediately. Ingestion of this product could cause gastrointestinal distress. DO NOT REUSE EMPTY CONTAINER. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information. For emergency first aid help, call 1-877-740-5015.

**COMMON APPLICATIONS**

Oatey H-20<sup>95</sup> Water Soluble Tinning Flux can be used to solder most commonly soldered metals including copper, brass, zinc, galvanized iron and tin or copper-coated metals.

Consult Oatey Technical Department for applications not specifically referenced above.

**INGREDIENTS (CAS Number)**

- Triethanolamine Hydrochloride (637-39-8)
- Zinc Chloride (7646-85-7)
- Ammonium Chloride (12125-02-9)
- Surfactant Blend (N/A)
- Inert Fillers (N/A)
- Tin (7440-31-5)
- Copper (7440-50-8)
- Bismuth (7440-69-9)

**COMPLIANCE AND LISTINGS**



NSF Listed to Standard 61      Lead Free Flux  
Complies with CA & VT lead legislation

Flux Base meets ASTM Standard B 813

PRODUCT NUMBER	DESCRIPTION	PACK	CARTON WEIGHT
30140	1.7 oz. H-20 <sup>95</sup> Water Soluble Tinning Flux	12	4 lbs.
30142	8 oz. H-20 <sup>95</sup> Water Soluble Tinning Flux	24	16 lbs.
30143	16 oz. H-20 <sup>95</sup> Water Soluble Tinning Flux	24	15 lbs.
53068	1.7 oz. H-20 <sup>95</sup> Water Soluble Tinning Flux with Brush – Carded	12	2 lbs.