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TECHNICAL SPECIFICATION

**SAFE FLO® SILVER LEAD FREE
PLUMBING SOLDER**



TECHNICAL SPECIFICATION: Oatey Safe Flo Silver Lead Free Plumbing Solder is recommended for use on potable water systems for sweating joints in a copper water distribution system. Safe Flo Silver Lead Free Solder is also effective on stainless steel, brass alloys, chrome alloys, galvanized steel and cast iron piping. Safe-Flo Solder complies with CA & VT lead content regulations.



PRECAUTIONS

Read all cautions and directions carefully before using this product. Apply flux with brush- do not apply with fingers. Wash hands thoroughly after use and before eating. Wear safety glasses with side shields and rubber gloves. EYE AND SKIN IRRITANT. HARMFUL IF SWALLOWED. VAPOR MAY BE HARMFUL. Use only in well ventilated area. Eye or skin contact may cause intense irritation and injury. In case of contact with eyes or skin, flush with water and seek medical attention immediately. If inhaled, get fresh air and seek medical attention if ill feelings persist. 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.

PHYSICAL/CHEMICAL PROPERTIES

Alloy composition Tin, Copper, Bismuth, Silver
Appearance Silver Solid Wire
Melting Range 420° F to 460° F

DIRECTIONS FOR USE

Cut the pipe to the exact length required using a tube cutter. Be sure the pipe is cut square. Remove all burrs on the inside and outside of the pipe surface with a reamer tool. Remove all oil, grease and oxide corrosion from the surface of the piping to be joined. Surfaces may be cleaned with abrasive sandcloth or a steel wire brush. The joining surfaces must be clean before soldering. Apply a small amount of approved flux to the pipe and fitting surface. Proper fluxing is important because the flux promotes the flow of the filler metal. Insert the pipe end into the fitting. Heat the joint area, using caution not to overheat the joint. Feed the solder wire into the joint. When the solder wire has drawn around the entire joint, remove the heat. When soldering process is complete, allow the joint to cool undisturbed. When joint is cool, remove any flux residual with a damp cloth.

Safe Flo Silver Lead Free Solder is not recommended for use on aluminum.

COMMON APPLICATIONS

Oatey Safe Flo Silver Lead Free Plumbing Solder is recommended for use on potable water systems for sweating joints in a copper water distribution system.

Consult Oatey Technical Department for applications not specifically referenced above.

INGREDIENTS (CAS Number)

Tin (7440-31-5)
Copper (7440-50-8)
Bismuth (7440-69-9)
Silver (7440-22-4)

COMPLIANCE & LISTINGS



IAPMO Listed



Maximum weighted average 0.25% lead
Complies with CA & VT lead legislation

Meets Military Specification QQ-S- 571E
Meets ASTM B 32

PRODUCT NUMBER	DESCRIPTION	GAUGE	PACK	CARTON WEIGHT
29030	1 oz. Safe Flo Silver Solder – Bulk	.084	20	2 lbs.
53061	1 oz. Safe Flo Silver Solder – Display	.084	12	1 lb.
22002	4 oz. Safe Flo Silver Solder – Bulk	.117	10	4 lbs.
53062	4 oz. Safe Flo Silver Solder – Display	.117	12	4 lbs.
29024	8 oz. Safe Flo Silver Solder – Bulk	.117	10	6 lbs.
53195	8 oz. Safe Flo Silver Solder – Carded	.117	12	8 lbs.
29024D	8 oz. Safe Flo Silver Solder – Display	.117	24	12 lbs.
53064	8 oz. Safe Flo Silver Solder – Display	.117	12	8 lbs.
29025	1 lb. Safe Flo Silver Solder – Bulk	.117	10	11 lbs.
29025D	1 lb. Safe Flo Silver Solder – Display	.117	20	21 lbs.