

## DESCRIPTION

C-6 is a “neutral” organic water-soluble formula for use in flux-cored solder wire. “C-6” has specially been developed to be more heat stable as compare to normal organic water-soluble core flux. Due to its “neutral” organic nature, the flux is partially decomposed during the heat of soldering, resulting in residue which is able to be hold-on for several hours without causing corrosion problem on the joint before it is completely removed by warm water rinse, in comparison with an equivalent amount of organic acid flux which needs immediate washing of flux residue.

## APPLICATIONS

C-6 can be used for difficult-to-solder metals where rosin flux is too inactive. “C-6” is compatible with Hasaconi “WS-6031” and “WS-6033” Neutral Organic Water-Soluble post soldering fluxes. “C-6” can be easily adopted for soldering of electronic assemblies with aqueous cleaning systems. For electronic applications, the circuit board assembly must be designed for the use of organic fluxes and water cleaning.

## SPECIFICATIONS

Physical State	:	Wax like
Color	:	Milky
Spread Factor	:	95% min
(JIS Z 3197: 1999 8.3.1.1)		
Surface Insulation Resistance	:	$>10^{10} \Omega$ (after washing)
(JIS Z 3197: 1999 8.5.3)		
Copper Corrosion Test	:	Pass (after washing)
(JIS Z 3197: 1999 8.4.1)		
Water Solubility	:	$\infty$
pH Value	:	7.0

### RESIDUE PROPERTIES AND REMOVAL

C-6 will leave a residue after soldering which is hygroscopic and ionizable. Complete removal, particularly for electrical and electronic applications, is recommended. Removal of ionizable salts can best be accomplished by washing the assembly in water, followed by a thorough warm water rinse. If the residue is charred due to excessive heating during soldering, some mechanical method will have to be used to remove the decomposed char. Ionizable salts can still be removed by aqueous cleaning methods.

### HEALTH AND SAFETY

Adequate ventilation should be employed to remove flux fumes from the work area. Wash hands thoroughly with soap and water before eating or smoking after handling solder wire. For more information, please refer to Material Safety Data Sheet.

#### DISCLAIMER OF LIABILITY

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