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TECHNICAL SPECIFICATION

**H-20⁵
WATER SOLUBLE PASTE FLUX**



TECHNICAL SPECIFICATION: Oatey H-20⁵ Water Soluble Paste Flux cleans 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-20⁵ Paste Flux is lead-free and ideal for copper systems including fire sprinkler, hydronic heating, potable water service and DWV piping. H-20⁵ Paste Flux remains active up to 700° F. H-20⁵ Flux complies with CA & VT lead content regulations.



PHYSICAL/CHEMICAL PROPERTIES

Appearance	Off-White to Light Yellow Paste
Shelf Life	1 year from manufacture date
Solder Temp. Range	400-700 F
pH	3-4

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-20⁵ Paste 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 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.** 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 swallowed, **DO NOT INDUCE VOMITING.** Drink water and call physician or poison control center immediately. Ingestion of this product may cause gastrointestinal distress. If inhaled, get fresh air and seek medical attention if ill feelings persist. Keep container closed when not in use. **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-20⁵ Lead Free Paste 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)

COMPLIANCE & LISTINGS



NSF Listed
to Standard 61



IAPMO Listed



Lead-Free Flux
Complies with CA & VT
lead legislation

Meets ASTM Standard B 813

PRODUCT NUMBER	DESCRIPTION	PACK	CARTON WEIGHT
30130	1.7 oz. H-20 ⁵ Water Soluble Paste Flux	12	2 lbs.
30131	4 oz. H-20 ⁵ Water Soluble Paste Flux	24	7 lbs.
30132	8 oz. H-20 ⁵ Water Soluble Paste Flux	24	16 lbs.
30133	16 oz. H-20 ⁵ Water Soluble Paste Flux	12	15 lbs.
53067	1.7 oz. H-20 ⁵ Water Soluble Paste Flux with Brush – Carded	12	2 lbs.