



4700 W. 160th St.  
Cleveland, OH 44135  
PH:800-321-9532  
FX:800-321-9535  
www.oatey.com

**TECHNICAL SPECIFICATION**

**NO. 95  
LEAD FREE TINNING FLUX**



**TECHNICAL SPECIFICATION:** Oatey No. 95 Lead Free Tinning Flux cleans, tins and fluxes most commonly soldered metals including copper, brass, zinc, galvanized iron, lead and tin or copper-coated metals. No. 95 contains lead free solder powder which helps draw in the solder wire. Fluxing is a critical step in the soldering process. No. 95 Tinning Flux provides superior wetting properties for better solder flow and can be used with most soft solders. No. 95 Tinning Flux 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. 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.

**PHYSICAL/CHEMICAL PROPERTIES**

Appearance Greenish-Gray Paste  
Shelf Life 2 years from manufacture date  
Solder Temp. Range 400° F to 700° F  
pH 3 - 4

**DIRECTIONS FOR USE**

Tinning 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 No. 95 Tinning Flux above 100° F.

**COMMON APPLICATIONS**

Oatey No. 95 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**

Petrolatum (8009-03-9)  
Zinc Chloride (7646-85-7)  
Ammonium Chloride (12125-02-9)  
Tin (7440-31-5)  
Copper (7440-50-8)  
Bismuth (7440-69-9)

**APPROVALS AND LISTINGS**



NSF Listed to Standard 61



Lead Free Flux Complies to CA & VT lead legislation

Meets Military Specification MIL-F-14256

| PRODUCT NUMBER | DESCRIPTION  | PACK | CARTON WEIGHT |
|----------------|--|------|---------------|
| 30374          | 1.7 oz. No. 95 Tinning Flux  | 12   | 4 lbs.        |
| 30374D         | 1.7 oz. No. 95 Tinning Flux – Display Carton                           | 48   | 8 lbs.        |
| 30373          | 1.7 oz. No. 95 Tinning Flux with Brush – Carded                        | 12   | 4 lbs.        |
| 53201          | 1.7 oz. No. 95 Tinning Flux with Brush – Carded without carton inserts | 12   | 4 lbs.        |
| 30372          | 8 oz. No. 95 Tinning Flux  | 24   | 14 lbs.       |
| 30372D         | 8 oz. No. 95 Tinning Flux- Display Carton                              | 24   | 15 lbs.       |
| 30375          | 16 oz. No. 95 Tinning Flux   | 12   | 14 lbs.       |