

ALPHA® WS-857

WATER-SOLUBLE FLUX

DESCRIPTION

ALPHA WS-857 is a liquid flux formulated for producing defect-free assemblies in wave soldering processes employing water cleaning.

APPLICATION

ALPHA WS-857 is a low-smoking, efficient foam flux. Using moderate air flow rates, its fine-bubble foam head is fast-breaking, and recovers rapidly for effective coverage at high production speeds. This highly active flux will produce bright shiny solder connections.

THINNING

The consistency of **ALPHA WS-857** should be maintained by the addition of thinner to compensate for evaporation losses. It is recommended that the specific gravity @ 25°C / 77°F be maintained between 0.860 and 0.875 by the addition of thinner. Only ALPHA 425 Thinner should be used for this purpose to ensure consistency of flux foaming and soldering characteristics.

RESIDUE REMOVAL

The residues wash off easily to very low levels of ionic contamination. Water washing can be done without the use of rinse aids and with little or no foaming. The flux is formulated so that the cleaning process water effluent is completely biodegradable. Local regulations may require pretreatment to raise the pH and remove dissolved lead from the water effluent.

TECHNICAL DATA

| PHYSICAL PROPERTIES | TYPICAL VALUES |
|--------------------------------|---------------------------|
| Appearance | Clear, Pale Yellow Liquid |
| Specific Gravity @ 25°C (77°F) | 0.865 ± 0.005 |
| Percent Nonvolatiles | 18 |
| Flash Point (TCC) | 17°C (62°F) |
| Typical pH of 5% Solution | 2.8 |
| Recommended Alpha Thinner | 425 |
| IPC J-STD-004 Classification | ORH1 |

PACKAGING

ALPHA WS-857 is available in 1, 5, and 55 gallon containers.

SAFETY

Please refer to the product MSDS as the primary source of health and safety information. Observe standard precautions for handling and use, such as well-ventilated areas and avoidance of prolonged or repeated contact with the skin. **ALPHA WS 857** is flammable; keep away from heat, spark and open flames.