



# SUPERIOR No. 78



## SOFT SOLDER GEL FLUX

- Flux exerts powerful scavenging action.
- Non-fuming and water-soluble.
- Exhibits excellent capillary action.

### DESCRIPTION

**Superior No. 78** is a non-fuming, water-soluble Gel flux formulated for difficult-to-solder metals. The activators include zinc chloride, ammonium chloride, and hydrochloric acid. The flux exerts powerful scavenging action removing the oxide coatings and other impurities from most metals yielding strong joints. Due to its high viscosity, the flux does not migrate upon heating helping the solder stay in place.

### APPLICATIONS

**Superior No. 78** is excellent for use on stainless steel, monel, high chrome alloys, inconel, nickel, copper, brass, ferrous alloys and many more metals. It is not suitable for aluminum and magnesium.

### DIRECTIONS

**Superior No. 78** may be applied with a brush, swab, by dipping, or with a (semi) automatic dispenser. The flux is active between 95-425°C/200-800°F. Residues are water-soluble. A water temperature of 60°C/140°F ± 10°C/20°F is recommended for optimum cleaning. To insure complete removal of flux residues, first use water containing 2% HCl followed by as many hot water rinses as necessary. Product has a shelf life of two (2) years.

### PHYSICAL PROPERTIES

Form	Yellow/Green Gel
Specific Gravity	1.315 ± 0.045 @ 20-25°C/68-77°F
pH	0.10 ± 0.5 @ 20-25°C/68-77°F
Viscosity	6,900 ± 500 cps @ 20-25°C/68-77°F
Flash Point	None
Boiling Point	105°C/218°F
Spread Factor	80 Minimum
Soldering Temperature Range	95-425°C /200-800°F

**THIS PRODUCT IS RoHS COMPLIANT**

### SAFETY PRECAUTIONS

**Superior No. 78** contains zinc chloride, hydrochloric acid, and ammonium chloride. It is a corrosive product. Avoid contact with skin and eyes. If eyes come in contact with the flux, flush in eye fountain with water for 15 minutes and get immediate medical attention. If swallowed give plenty of water or milk and call a physician. For skin contact, wash the exposed area thoroughly and rinse with water for 15 minutes. Keep out of reach of children.

Disposal of flux and flux residues must be carried out in accordance with local and federal regulations. Refer to the Material Data Safety Sheet (MSDS) for additional safety information.

*Superior manufactures quality fluxes. Our business is solving problems.*



**Superior Flux  
& Mfg. Co.**

6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax:  
440-349-3003 www.superiorflux.com • e-mail: info@superiorflux.com