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**TECHNICAL SPECIFICATION**

**50/50 ALLOY  
BAR SOLDER**



**TECHNICAL SPECIFICATION:** Oatey Bar Solder is a general purpose alloy of 50% tin and 50% lead. 50/50 Bar Solder is most commonly used for copper drain piping, tin plating, seaming joints and sheet metal. 50/50 Bar Solder can be used to solder copper and most copper alloys including lead, nickel alloys and steel. **50/50 BAR SOLDER CONTAINS LEAD. IT IS ILLEGAL TO USE LEAD ALLOY SOLDERS IN POTABLE WATER SYSTEMS (DRINKING WATER).**



**PHYSICAL/CHEMICAL PROPERTIES**

Alloy composition	Tin & Lead
Appearance	Silver Solid Bar
Melting Range	361° F to 421° F

**DIRECTIONS FOR USE**

Remove all burrs on the inside and outside of the surface. Remove all oil, grease and oxide corrosion from the surface using Oatey Abrasive Cloth, Utility Brushes or Nylon Grit Pads. The joining surfaces must be clean before soldering. Apply a small amount of approved flux to the pipe and fitting surface. Proper fluxing is important because the flux promotes the flow of the filler metal. Insert the pipe end into the fitting. Heat the joint area, using caution not to overheat the joint. Feed the solder wire into the joint. When the solder wire has drawn around the entire joint, remove the heat. When soldering process is complete, allow the joint to cool undisturbed. When joint is cool, remove any flux residual with a damp cloth.

Tin/Lead solders are not recommended for applications involving high stress or vibration. It is illegal to use lead alloy solders in potable water systems (drinking water).

**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. Use only in well ventilated area. 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 inhaled, get fresh air and seek medical attention if ill feelings persist. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information. For emergency first aid help, call 1-303-623-5716 COLLECT.

**COMMON APPLICATIONS**

Oatey Bar Solder is a general purpose alloy of 50% tin and 50% lead. 50/50 Bar Solder is most commonly used for copper drain piping, tin plating, seaming joints and sheet metal. 50/50 Bar Solder can be used to solder copper and most copper alloys including lead, nickel alloys and steel.

Consult Oatey Technical Department for applications not specifically referenced above.

**INGREDIENTS (CAS Number)**

Tin (7440-31-5)  
Lead (7439-92-1)

**APPROVALS AND LISTINGS**

Meets Military Specification QQ-S-571E

PRODUCT NUMBER	DESCRIPTION	PACK	CARTON WEIGHT
21305	1.25 lb. 50/50 Bar Solder – Bulk	10	12.5 lbs.
20307	1.25 lb. 50/50 Bar Solder – Bulk	40	50 lbs.