



# SAFE FLO® SILVER LEAD FREE PLUMBING SOLDER TECHNICAL SPECIFICATION

Job Name _____	Item # _____
Location _____	
Engineer _____	Contractor _____
PO # _____	Tag _____
Representative _____	

## DESCRIPTION

- Safe-Flo Solder complies with CA & VT lead content regulations.
- Safe Flo Silver Lead Free Solder is not recommended for use on aluminum.

## APPLICATION / USES

- Oatey Safe Flo Silver Lead Free Plumbing Solder is recommended for use on potable water systems for sweating joints in a copper water distribution system.
- Safe Flo Silver Lead Free Solder is also effective on brass alloys, chrome alloys, galvanized steel and cast iron piping.

Consult Oatey Technical Department for applications not specifically referenced above.

## APPROVALS AND LISTINGS

- IAPMO Listed
- Meets Military Specification QQ-S- 571E
- Maximum weighted average 0.25% lead  
Complies with CA & VT lead legislation
- Compliant with the requirements of ASTM B32 and the requirements of NSF/ANSI/CAN 61.



## PHYSICAL PROPERTIES / INGREDIENTS

### INGREDIENTS (CAS Number):

Tin (7440-31-5), Copper (7440-50-8), Bismuth (7440-69-9), Silver (7440-22-4)

### PHYSICAL/CHEMICAL PROPERTIES

Alloy composition	Tin, Copper, Bismuth, Silver
Appearance	Silver Solid Wire
Melting Range	420° F to 460° 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. 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 1-877-740-5015.**



## DIRECTIONS

Cut the pipe to the exact length required using a tube cutter. Be sure the pipe is cut square. Remove all burrs on the inside and outside of the pipe surface with a reamer tool. Remove all oil, grease and oxide corrosion from the surface of the piping to be joined. Surfaces may be cleaned with abrasive sandcloth or a steel wire brush. 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.

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PRODUCT NUMBER	DESCRIPTION	GAUGE	PACK	CARTON WEIGHT
23000	8 oz. Silver Lead Free Solder – Bulk	.117	10	5 lbs.
23001	1 lb. Silver Lead Free Solder – Bulk	.117	25	25 lb.
23002	5 lb. Silver Lead Free Solder – Bulk	.117	10	50 lbs.
29030	1 oz. Safe Flo Silver Solder – Bulk	.084	20	2 lbs.
29024	8 oz. Safe Flo Silver Solder – Bulk	.117	10	6 lbs.
290242	8 oz. Safe Flo Silver Solder – Display	.117	10	6 lbs.
29024D	8 oz. Safe Flo Silver Solder – Display	.117	24	13 lbs.
29025	1 lb. Safe Flo Silver Solder – Bulk	.117	10	11 lbs.
290252	1 lb. Safe Flo Silver Solder - Display	.117	12	12 lbs.
29025D	1 lb. Safe Flo Silver Solder – Display	.117	20	22 lbs.
53061	1 oz. Safe Flo Silver Solder – Carded	.084	12	1 lbs.
530612	1 oz. Safe Flo Silver Solder – Display	.084	12	1 lbs.
53180	1 oz. Safe Flo Silver Solder – Carded	.084	12	1 lbs.
53062	4 oz. Safe Flo Silver Solder – Carded	.117	12	4 lbs.
530622	4 oz. Safe Flo Silver Solder – Display	.117	12	4 lbs.
53188	4 oz. Safe Flo Silver Solder – Carded	.117	12	4 lbs.
53064	8 oz. Safe Flo Silver Solder – Carded	.117	12	8 lbs.
53195	8 oz. Safe Flo Silver Solder – Carded	.117	12	8 lbs.
50683	4 oz. Safe Flo Silver Plumbing Kit – Carded	.117	12	6 lbs.
50684	4 oz. Safe Flo Silver Plumbing Kit – Carded w/o display insert	.117	12	6 lbs.
50691	4 oz. Safe Flo/H-20-5 flux solder kit – Carded	.117	12	6 lbs.
506912	4 oz. Safe Flo/H-20-5 flux solder kit - Display	.117	12	6 lbs.
50692	4 oz. Safe Flo/H-20-95 flux solder kit – Carded	.117	12	6 lbs.
53013	1 oz. Hobby Solder Kit – Carded	.063	12	1 lbs
53186	1 oz. Hobby Solder Kit – Carded	.063	12	1 lbs

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