



# Castolin SP 5423

Ready-to-use, lead-free solder paste

## Description

Castolin SP 5423 is supplied as a ready-to-use paste. This paste comprises a tin-copper powder and a binder, mixed to optimal proportions to actively flux and join the metal surfaces.

This product is **lead and Cadmium-free**. Castolin SP 5423 is an easy-to-use product, even for those with little brazing experience.

## Application examples

- This product is designed for tinning and for soldering copper or brass parts, and also steel parts.
- Joining of plumbing and sanitary pipelines.
- Model building, decoration, etc.

## Chemical composition (%)

Sn	Cu
97	3

## Standard mechanical and physical characteristics

Solidus	230°C
Liquidus	250°C
Form	Paste
Product colour	Dark grey
Mechanical strength	40 MPa

Proportion flux-binder:  
25% basically comprising a mixture of zinc chlorides on an organic carrier material.

## Standards

NF A 81-362	Sn997
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## Instructions for use

### Preparation

- Degrease the surfaces and clean if necessary.
- Coat the surfaces to be joined or tinned with Castolin SP 5423 paste.
- Place the parts in their definitive position.
- Heat with a gentle flame up to the flux melting point (around 250 °C).
- Avoid overheating.
- Tinning
- For tinning, the part can be wiped when the alloy is still in liquid form in order to achieve a smooth, shiny appearance.

### Cleaning

- The flux residues are water soluble. The residues must be removed by washing in water or by wiping with a damp sponge or cloth.

## Form of delivery

Packaging: Fluxpack plastic box (100g)