

# Soldering paste for fittings

<b>Description</b>	amasan Lotpaste LF Nr. 3
<b>Test mark</b>	as per DVGW-GW2 and -GW7: DV-0101AP2021 (FI 002) and RAL quality mark
<b>Condition</b>	pasty
<b>Form of delivery</b>	box with 100 g contents box with 250 g contents
<b>Description as per norm</b>	flux DIN EN 29454-1 3.1.1.C (F-SW 21) metal DIN EN 29453, S-Sn97Cu3 (L-SnCu3), material no. 2.3691 working temperature: approx. 270°C, melting range: 230°C - 250°C 60 % of total weight
<b>Percentage of solder</b>	
<b>Chemical compound</b>	On basis of zinc chloride and ammonium chloride with additives
<b>Removal of residues by rinsing</b>	The flux residues are 100 % water-soluble
<b>Application</b>	ready-to-use soldering paste for pre-tinning and soldering together with amasan solid solder no. 3 and copper tubes. Suitable for cold water-, hot water- and heating installation up to 110°C as per DVGW-working leaflet GW 2 and GW 7. Tubes which are very dirty and highly oxidized should be cleaned with metalfree amasan cleaning fleece before soldering.
<b>Note</b>	<p>amasan soldering paste LF contains soldering powder, water-soluble flux and binder. It is used as flux together with solid solder. It has to be paid attention to the fact that the type of solder contained in the soldering paste corresponds to the alloy of the solid solder. amasan soldering paste LF therefore is available corresponding to the amasan solid solders no. 1, no. 3 and no. 4.</p> <p>amasan soldering pastes LF are in accordance with the requirements of the new DVGW-working leaflet GW 7. This working leaflet settles the percentage of metal of the soldering pastes, the maximum percentage of pickle in the flux and the removal of residues by rinsing as per DIN 1988.</p>
<b>Special features</b>	<ul style="list-style-type: none"><li>• amasan soldering paste LF No. 3 is completely homogeneous, consequently no separation of flux and metal powder.</li><li>• no time-consuming stirring of the soldering paste causing waste on stirring rod.</li><li>• good adhesion on application</li><li>• overheating of the soldering joint is avoided as the melting of the solder and along with this the appropriate working temperature is easily recognizable.</li><li>• solid soldering</li><li>• quick and complete removal of the small amount of water-soluble residues by rinsing with cold or warm water</li><li>• a brush is supplied with each bottle</li></ul>



## Instructions for use

Clean joints to be soldered with cleaning fleece. Apply soldering paste economically and evenly with a brush only on the end of the pipe and push it firmly into the fitting. Heat the soldering joint evenly and allow the solder to melt until a soldered ring is visible. Clean the soldering joint outside with a damp cloth. Rinse piping according to regulations. Work to be done in well-ventilated area.