PRODUCT SPECIFICATION

Lastek 3102 PA

Soldering paste for stainless steel

CLASSIFICATION

GENERAL DESCRIPTION

Silver containing paste for soldering stainless steel, copper alloys and other metals, delivered in a syringue with a dispensor.
The paste 3102PA is composed of metal powders and a flux; you don't have to use a separate flux. Its high fluidity assures increased productivity.
Lastek 3102PA is corrosion resistant so that the joint remains shiny even after longtime exposure to atmospheric and corrosive conditions.
Free of cadmium, zinc and lead and can be used for soldering metals that are in contact with food.

APPLICATIONS

Joining stainless steel sheets and tubes.
Joining of steel, cast iron, copper, bonze, nickel-silver and galvanized or cadmiumplated workpieces.
Filling holes, pits, depressions, tool marks and scratches.
Recipients for diary products, refrigerators, soft drink machines, machinery for food industry, jewellery.
Applications where the temperature of the workpieces has to remain very low.

Soldering temperature: 230 °C (450 °F)
Density: 7.5 g/cm³ (0.26 lb/in³)
Electrical resistivity: 0.125 ohm.mm²/m (4.92 ohms/in/in²)

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Sn : 96.50	**Ag :** 3.50			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	140 MPa		

GENERAL INFORMATION

Welding positions	NA
Shielding gas	NA
Packing	30 ml in a syringe
Polarity	NA

Tips & tricks	Clean the joint area and apply the paste in the desired quantity at the opening of the joint. Apply dots or lines of paste on areas that overlap (permitting the flux and binder to escape). Heat the joint area and the paste gradually to remove the binder (do not point the flame directly to the paste, so that the paste is heated by conduction). Flux and alloy will flow in the direction of the hottest part. Stop heating and allow the alloy to solidify before removing any fixtures. When using a soldering iron: apply paste on the parts to be joined and heat the parts with the soldering iron. Remove flux residues in warm water.