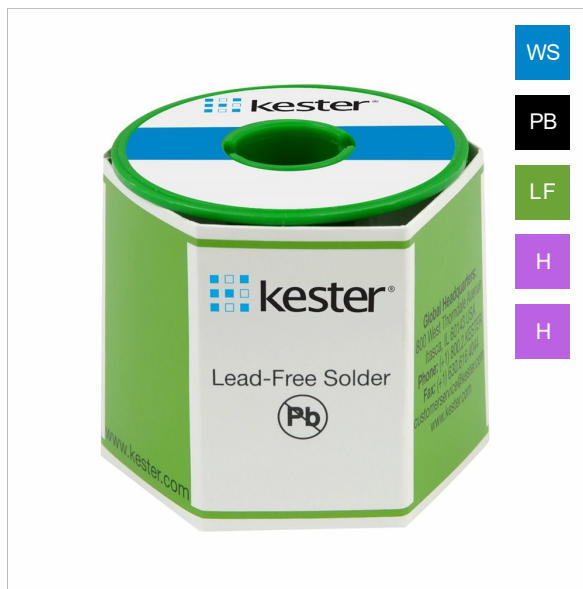


# PRODUCTS



## 331 Flux-Cored Wire

Kester 331 Organic Flux is a water-soluble formula for use in flux-cored solder wire. This cored solder version of the popular 2331-ZX Neutral Organic Water Soluble Liquid Flux is more effective than rosin fluxes in soldering difficult metals. The same fast action and mild properties are exhibited with 331 Organic Flux as with the liquid 2331-ZX. The flux is more heat stable than most organic fluxes, resulting in minimal smoke and odor. The residue can be completely removed with a simple heated water rinse. Deionized water is suggested to prevent introduction of chemistries from unknown water sources. 331 is classified as ORH1 per J-STD-004.

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| Alloy          | Flux | Diameter (in) | Diameter (mm) | Core | Flux % | Lead Content | Halogen Content  | Description                           | Part #     | Type          |
|----------------|------|---------------|---------------|------|--------|--------------|------------------|---------------------------------------|------------|---------------|
| Sn60Pb40       | 331  | 0.031         | 0.80          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn60Pb40 3.3%/331 .031 1 Lb SPL       | 2460406403 | Water-Soluble |
| Sn60Pb40       | 331  | 0.062         | 1.50          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn60Pb40 3.3%/331 .062 1 Lb SPL       | 2460406411 | Water-Soluble |
| Sn63Pb37       | 331  | 0.020         | 0.50          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn63Pb37 3.3%/331 .020 1 Lb SPL       | 2463376401 | Water-Soluble |
| Sn63Pb37       | 331  | 0.031         | 0.80          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn63Pb37 3.3%/331 .031 1 Lb SPL       | 2463376403 | Water-Soluble |
| Sn63Pb37       | 331  | 0.062         | 1.50          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn63Pb37 3.3%/331 .062 1 Lb SPL       | 2463376411 | Water-Soluble |
| Sn63Pb37       | 331  | 0.025         | 0.60          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn63Pb37 3.3%/331 .025 1 Lb SPL       | 2463376417 | Water-Soluble |
| Sn63Pb37       | 331  | 0.015         | 0.40          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn63Pb37 3.3%/331 .015 1 LB SPL       | 2463376422 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.020         | 0.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .020 1 LB SPL | 2470686401 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.031         | 0.80          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .031 1 LB SPL | 2470686403 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.040         | 1.00          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .040 1 LB SPL | 2470686407 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.050         | 1.27          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .050 1 LB SPL | 2470686409 | Water-Soluble |

| Alloy          | Flux | Diameter (in) | Diameter (mm) | Core | Flux % | Lead Content | Halogen Content  | Description                                | Part #     | Type          |
|----------------|------|---------------|---------------|------|--------|--------------|------------------|--|------------|---------------|
|                |      |               |               |      |        | Free         | Halogen          | .050 1 LB SPL                              |            | Soluble       |
| Sn96.5Ag03Cu.5 | 331  | 0.062         | 1.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .062 1 LB SPL      | 2470686411 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.025         | 0.60          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .025 1 LB SPL      | 2470686417 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.015         | 0.40          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .015 1 LB SPL      | 2470686422 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.010         | 0.25          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .010 1 LB SPL      | 2470686442 | Water-Soluble |
| K100LD         | 331  | 0.020         | 0.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | K100LD 3.3%/331 .020 1 LB SPL              | 2495746401 | Water-Soluble |
| K100LD         | 331  | 0.031         | 0.80          | 66   | 3.3%   | Lead-Free    | Contains Halogen | K100LD 3.3%/331 .031 1 LB SPL              | 2495746403 | Water-Soluble |
| K100LD         | 331  | 0.062         | 1.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | K100LD 3.3%/331 .062 1 LB SPL              | 2495746411 | Water-Soluble |
| K100LD         | 331  | 0.025         | 0.60          | 66   | 3.3%   | Lead-Free    | Contains Halogen | K100LD 3.3%/331 .025 1 LB SPL              | 2495746417 | Water-Soluble |
| K100LD         | 331  | 0.015         | 0.40          | 66   | 3.3%   | Lead-Free    | Contains Halogen | K100LD 3.3%/331 .015 1 LB SPL              | 2495746422 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.062         | 1.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .062 4 LB SPL      | 2570686411 | Water-Soluble |
| Sn95Ag05       | 331  | 0.062         | 1.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn95Ag05 3.3%/331 .062 4 LB SPL            | 2570706411 | Water-Soluble |
| Sn60Pb40       | 331  | 0.062         | 1.50          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn60Pb40 3.3%/331 .062 5 LB SPL            | 2660406411 | Water-Soluble |
| Sn95Sb05       | 331  | 0.062         | 1.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn95Sb05 3.3%/331 .062 18 LB SPL           | 2700016411 | Water-Soluble |
| Sn40Pb60       | 331  | 0.093         | 2.50          | 66   | 3.3%   | Leaded       | Contains Halogen | Sn40Pb60 3.3%/331 .093 20 LB SPL           | 2840606413 | Water-Soluble |
| Sn63Pb37       | 331  | 0.093         | 2.50          | 50   | 1.1%   | Leaded       | Contains Halogen | Sn63Pb37 1.1%/331 .093 20 Lb SPL           | 2863376470 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.015         | 0.40          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .015 100 GRAM SPL  | 9070686422 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.010         | 0.25          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 3.3%/331 .010 100 GRAM SPL  | 9070686442 | Water-Soluble |
| Sn63Pb37       | 331  | 0.020         | 0.50          | 58   | 2.2%   | Leaded       | Contains Halogen | Sn63Pb37 2.2%/331 0.02 250 GRAM SPL        | 9163376400 | Water-Soluble |
| Sn63Pb37       | 331  | 0.031         | 0.80          | 58   | 2.2%   | Leaded       | Contains Halogen | Sn63Pb37 2.2%/331 0.031 500 GRAM SPL       | 9263376402 | Water-Soluble |
| Sn63Pb37       | 331  | 0.025         | 0.60          | 58   | 2.2%   | Leaded       | Contains Halogen | Sn63Pb37 2.2%/331 0.025 500 GRAM SPL       | 9263376416 | Water-Soluble |
| Sn96.5Ag3Cu0.5 | 331  | 0.031         | 0.80          | 58   | 2.2%   | Lead-Free    | Contains Halogen | Sn96.5Ag3Cu0.5 2.2%/331 .031 500 GRAM SPL  | 9270686402 | Water-Soluble |
| Sn96.5Ag03Cu.5 | 331  | 0.025         | 0.60          | 58   | 2.2%   | Lead-Free    | Contains Halogen | Sn96.5Ag03Cu.5 2.2%/331 0.025 500 GRAM SPL | 9270686416 | Water-Soluble |
| Sn96.5Ag3Cu0.5 | 331  | 0.020         | 0.50          | 66   | 3.3%   | Lead-Free    | Contains Halogen | Sn96.5Ag3Cu0.5 3.3%/331 .020 1LB SPL       | 40500928   | Water-Soluble |

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