

Low Temperature, Self-Fluxing, Tin-Silver Soldering Paste

StainTin® 157PA



BRAZING

- Free-flowing eutectic alloy with good capillary action
- Controlled Viscosity for easy, precise application
- Excellent choice for automated brazing and soldering
- Ideal for 300 Stainless steels in Food, medical and delicate applications



DESCRIPTION:

Eutectic StainTin 157PA is a paste soldering alloy particularly suited to stainless steels, **thoroughly** compatible with most copper, aluminum and carbon steel alloys.

The corrosion resistance of deposits in service ensure they remain bright and tarnish-free for a reliable, clean joint.

TECHNICAL DATA:

Typical Tensile Strength: 15,000 psi (105 N/mm²)
Yield Strength: 3,600 psi
Shear Strength: 10,000 psi
Electrical Conductivity - IACS: 16.5%
Thermal Expansion Coef.: 12×10^{-6} in/ °F (20-212°F)
Solidus Temperature¹: 430°F (220°C)
Liquidus Temperature²: 430°F (220°C)
Maximum Brazing Temp: 450°F (230°C)
Heating Methods: Oxy-fuel torch, induction, resistance heating and furnace soldering

¹ The solidus temperature is the highest temperature at which the part remains solid i.e. the start of melting.

² The liquidus temperature is the lowest temperature at which the part is molten i.e. complete melting.

TYPICAL APPLICATIONS:

For soldering dairy utensils, food-handling equipment, plumbing fixtures and potable water containers and piping. Also useful for joining electrical connectors*.

WELDING PARAMETERS:

Preparation: Clean joint area with RotoClean® OS or use a proprietary VOC-free solvent. Thoroughly mix the 157PA so that the flux and metal particles are well amalgamated and show a smooth consistency. Use a fine brush or spatula to apply the paste.

Note 1: *It is important not to allow any movement while the solder alloy cools and solidifies.*

Note 2: *For best results maintain joint clearances between 0.001" and 0.005".*

Technique: Heat insert parts slowly indirectly to reduce thermal shock so to promote uniform flow.

Note: *During the melting phase it is important that the parts being soldered to not move. Observe flow indications so that all contact surfaces are seen to be soldered.*

Post-brazing: Allow parts to cool naturally. Parts can be quenched to help with flux residue removal.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



Eutectic Corporation
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
P 800-558-8524 • F 262-255-5542
www.eutectic.com

Eutectic Services
12300 Carmen Avenue
Milwaukee, WI 53225 USA
P 800-558-8524 • F 262-255-5542



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