

ALPHA WS362 SERIES

Water Soluble Surface Mount Fluxes

GENERAL DESCRIPTION

ALPHA WS362 series of halide-free, water soluble, organic fluxes is designed for the soldering of surface mount and mixed technology assemblies, where the effective cleaning of residues becomes most critical. The densely-packed assemblies, associated with today's mixed technology boards, adds a difficulty to cleaning which makes the older technology water soluble fluxes non-optimal for applications requiring high ionic cleanliness.

ALPHA WS362-25 is recommended where maximum flux activity and solids are required, such as the soldering of assemblies with very dense component packing and with multilayer boards requiring relatively high preheat temperatures. After soldering, flux residues are highly water soluble and can be readily removed. This results in assemblies with the highest degree of ionic cleanliness and high surface insulation resistance.

FEATURES & BENEFITS

- Most cleanable water soluble flux. Highest ionic cleanliness and surface insulation resistance.
- Halide-Free. Maximum electrical integrity.
- Good activity with rapid wetting. Defect-free soldering.

USE

ALPHA WS362 flux can be applied by foam, spray or wave techniques. The recommended topside preheat temperatures are 82-104°C (180-220°F).

Post soldering flux residues should be removed after soldering as soon as possible. Thorough cleaning can be accomplished with 50-75°C (120-170°F) water. For critical cleanliness requirements, final rinsing with DI water may be required.

TECHNICAL SPECIFICATION

Physical Properties	Typical Values
	WS362-25
Appearance	Clear, pale yellow
Solids Content	25
Specific Gravity @ 25°C (77°F)	0.846 ± 0.005
pH of 5% Aqueous Solution	3.2
Halide Content (% Chloride)	None
Surface Insulation Resistance ⁽¹⁾	4.0 x 10 ⁹ ohms
Flash Point	17°C (62°F)
Recommended Alpha Thinner	425
IPC J-STD-004 Designation	ORMO

⁽¹⁾Meets ANSI/IPC-SF-818 Assembly Class 3 SIR Requirements with cleaning in 140°F DI water (tested at 85°C/85% RH).

PACKAGING

ALPHA WS362 series of fluxes is available in 1, 5 and 55 gallon containers.

HEALTH & SAFETY

Flammable liquid. Keep away from heat, sparks and open flames. Observe standard precautions for handling and use, such as well-ventilated areas and avoidance of prolonged or repeated contact with the skin. Avoid exposure to direct sunlight.

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