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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
Sn60Pb40	331	0.025	0.60	66	3.3%	Leaded	Contains Halogen	Sn60Pb40 3.3%/331 .025 1 LB SPL	2460406417	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	0.040	1.00	66	3.3%	Leaded	Contains Halogen	Sn63Pb37 3.3%/331 .040 1 LB SPL	2463376407	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

Alloy	Flux	Diameter (in)	Diameter (mm)	Core	Flux %	Lead Content	Halogen Content	Description	Part #	Type
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
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	0.050	1.27	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .050 1 LB SPL	2495746409	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
Sn95.8Ag3.5Cu.7	331	0.020	0.50	28	2.8%	Lead-Free	Contains Halogen	Sn95.8Ag3.5Cu.7 #28/331 0.02 250 GRAM SPL	9170596442	Water-Soluble
Sn96.5Ag3Cu0.5	331	0.020	0.50	58	2.2%	Lead-Free	Contains Halogen	Sn96.5Ag3Cu0.5 2.2%/331 .020 250 GRAM SPL	9170686400	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

Alloy	Flux	Diameter (in)	Diameter (mm)	Core	Flux %	Lead Content	Halogen Content	Description	Part #	Type
Sn95.8Ag3.5Cu.7	331	0.025	0.60	28	2.8%	Lead-Free	Contains Halogen	Sn95.8Ag3.5Cu.7 #28/331 0.025 500 GRAM SPL	9270596442	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
Sn60Pb40	331	0.031	0.80	66	3.3%	Leaded	Contains Halogen	331 3.3% Sn63Pb37 0.8mm 1 lb spool	40500461	Water-Soluble
Sn96.5Ag3Cu0.5	331	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	331 3.3% Sn96.5Ag3Cu0.5 0.8mm 1/2kg Spl	40500864	Water-Soluble
Sn96.5Ag3Cu0.5	331	0.020	0.50	66	3.3%	Lead-Free	Contains Halogen	331 3.3% Sn96.5Ag3Cu0.5 0.5mm 1lb Spl	40500928	Water-Soluble

Process Compatible Products

2331-ZX Soldering Flux



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