



SOLDERING





LEAD FREE SOLDERS

STAY-BRITE® SILVER SOLDER - LEAD FREE NSF

Silver-bearing solders are often used throughout the refrigeration/air conditioning industry instead of brazing alloys. Both Stay-Brite and Stay-Brite 8 produce an overall component with greater strength than a brazed component whose base metals are weakened by annealment from high brazing heat. Stay-Brite solders bond with all of the ferrous and nonferrous alloys. Joints soldered with Stay-Brite solders exhibit considerably higher than necessary elongation for sound, dissimilar metal joints and vibration applications. Stay-Brite 8 is especially effective in filling loosely fitted couplings. Use for all metals with the exception of aluminum. This is a low temperature solder excellent for many HVAC connections.

Product	Chemical Composition	Specifications	Solidus	Liquidus
Stay-Brite 8	6% Ag 94% Sn	NSF 51	430°F 535°C	430°F 535°F

Product	Chemical Composition	Specifications	Solidus	Liquidus
Stay-Brite	4% Ag 96% Sn	ASTM B32 Sn96 NSF 51 • J-STD-006 Sn96Ag 04A	430°F 221°C	430°F 221°F

STAY-BRITE® KIT - LEAD FREE SOLDER

Use for all metals with the exception of aluminum. Low temperature solder excellent for many HVAC connections.

Chemical Composition	Specifications	Solidus	Liquidus
4% Ag 96% Sn	ASTM B32 Sn 96 NSF 51 • J-STD-006 Sn96 Ag 04A	430°F 221°C	430°F 221°C

BRIDGIT® NSF

Lead-free solder widely used in plumbing applications where lead-bearing solders are prohibited. Contains nickel, making joints tremendously strong. Wide range makes Bridgit an excellent alloy for large diameter fittings and ill-fitted or non-concentric pipes. Fills gaps and caps off easily and effectively.

Specifications	Solidus	Liquidus	ASTM B32
ASTM B32 HB • NSF to ANSI NSF61 Conforms to 1986 Safe Drinking Act	460°F 238°C	630°F 332°F	Alloy Grade HB

NICK® NSF

Nick is a lead-free plumbing solder having been specifically formulated as a replacement for the tin/lead solders. It has a wide melting range (291° F - 144° C) that allows operators to fill small tight fitting pipe connections and also to bridge gaps in large, loose fitting or non-concentric pipe. Its ease of application in all types of copper joints, makes it the preferred solder of experienced operators and is the most forgiving in the hands of the less experienced. Nick is a patented alloy which meets all Federal requirements for lead-free solders mandated by the Federal Safe Drinking Water Act Amendments of 1986. (Public Law 99-339)

Solidus	Liquidus	ASTM B32-89
438°F 225°C	729°F 387°C	Alloy Grade HN

PART NO. SB8	SIZE
SB811	1/32" DIA - 1# SPOOL SPECIAL ORDER
SB831	1/16" DIA - 1# SPOOL
SB855	3/32" DIA - 5# SPOOL
SB861	1/8" - 1# SPOOL
SBRC65	SBRC-1/8" DIA - 5# SPOOL
SB61/2POP	1/8" - 8 oz SPOOL

PART NO. STAY-BRITE	SIZE
SB11	1/32" - 1# SPOOL
SB31	1/16" - 1# SP
SB51	3/32" - 1# SPOOL
SB61	1/8" - 1# SPOOL
SB625	1/8" - 25# SPOOL
SB65	1/8" - 5# SPOOL



PN: SB861
Stay-Brite 8
1/8" - 1# SPOOL

**USA
MADE IN**

**RoHS
COMPLIANT**

PART NO.	SIZE
SBSKPOP	KIT WITH FLUX



**USA
MADE IN**

**RoHS
COMPLIANT**

PART NO.	SIZE
BRGT31	1/16" - 1# SPOOL SPECIAL ORDER
BRGT51	3/32" - 1# SPOOL
BRGT61	1/8" - 1# SPOOL
BRGT65	1/8" - 5# SPOOL
BRGT625	1/8" - 25# SPOOL
BRGT61/2POP	1/8" - 8 oz. SPOOL



PN: BRGT61
BRIDGIT SOLDER
1/8" - 1# SPOOL

**USA
MADE IN**

**RoHS
COMPLIANT**

PART NO.	SIZE
NICK61	1/8" - 1# SPOOL



PN: NICK61
1/8" - 1# SPOOL

**USA
MADE IN**

**RoHS
COMPLIANT**

LEAD FREE SOLDERS



SPEEDY®

Speedy has a faster melting range, which allows operators to fill small, tight-fitting pipe connections quickly. Speedy's low temperature, free following nature decreases cycle time while reducing setup time. Speedy can be used with Stay-Clean paste or liquid flux, as well as Bridgit paste flux. Speedy is a lead-free, low temperature alloy formulated for joining copper pipe in potable water systems. This tin-based alloy conforms to the 1986 Federal Safe Drinking Water Act Amendment.

Solidus	Liquidus
450°F 232°C	555°F 290°C

USA
MADE IN

RoHS
COMPLIANT

PART NO.	SIZE
SPDY61	1/8" - 1# SPOOL
SPDY625	1/8" - 25# SPOOL SPECIAL ORDER

PN: SPDY61
1/8" - 1# SPOOL



95/5

Tin-antimony solder well suited for applications where moderately elevated temperature is a factor. With higher electrical conductivity and high fluidity, 95/5 is recommended for lead free installation of small diameter, tight fitting connections. Not recommended for use on brass or HVAC connections.

USA
MADE IN

RoHS
COMPLIANT

PN: 95561/2POP
95/5
1/8" - 8 oz SPOOL



PART NO.	SIZE
95531	1/16" DIA - 1# SPOOL
95551	3/32" DIA - 1# SPOOL
95561	1/8" DIA - 1# SPOOL
95565	1/8" DIA - 5# SPOOL
95561/2POP	1/8" - 8 oz SPOOL

Chemical Composition	Solidus	Liquidus	ASTM B32
Sn-95% Sb-5%	452°F 233°C	464°F 240°C	Sb5, J-STD-006 Sn95, Sb05A

ALSOLDER 500 - ALUMINUM SOLDER

Solder alloy for torch or iron. Used to join all solderable aluminum alloys to each other and to dissimilar metals. Also for zinc die-cast. Forms excellent, corrosion resistant joints on the tough to solder aluminum alloys. Also beneficial as a high temperature solder on most other metals. Not recommended for magnesium.

Procedure:

- Clean the area to be soldered
- Apply Stay Clean aluminum flux
- If using an open flame, heat indirectly with the torch in motion (do not direct the torch on the flux)
- Heat until the flux becomes a nut brown color
- Apply the alloy
- Discontinue heat as soon as flow
- Allow to cool. Remove flux residue with wire brush and hot water

Features:

- Tensile strength - Up to 20,000 PSI
- Solidus - 391°F
- Liquidus - 482°F
- Good color match on aluminum and zinc die cast

USA
MADE IN

RoHS
COMPLIANT

PN: 500K
KIT



Description	Chemical Composition	Solidus	Liquidus	Typical Application
Alsolder 500 Aluminum Solder Kit	15% Zn 85% Sn	391° F 199° C	482° F 250° C	Forms excellent corrosion-resistant joints on the tough-to-solder aluminum alloys. Use for copper to aluminum connections.

GAL VIZ

A special self-fluxing solder alloy for repairing damaged galvanized coatings. Gal Viz provides excellent corrosion resistance. It has a working temperature of about 600° F. Apply while base metal is hot. A clean wire brush will aid in tinning the surface with Gal Viz. It can also be tinned with a paddle or cloth. Do not direct flame on the alloy. Heat the base metal and rub the rod on the metal. When it melts, the temperature is correct.

PART NO.	SIZE
GLVIZ90	1/4" x 14" - 5# PKG





COMMON SOLDERS

40/60

With some exceptions, these tin-lead solders can be used to join copper and most copper alloys, lead, nickel alloys and steel. Tin-lead solders are not recommended for joints subject to high stress or vibration in the cooling industry due to lack of sufficient elongation properties. These solders are also available with rosin or acid core. **It is illegal to use lead solders in both public and private potable water systems.**

Chemical Composition	Solidus	Liquidus	ASTM B32
Sn-40%	360° F	460° F	Sn40A
Pb-60%	182° C	238° C	

**USA
MADE IN**

PART NO.	SIZE
406061	1/8" - 1# SPOOL
40A61	ACID CORE 1/8" - 1# SPOOL
40A65	ACID CORE 1/8" - 5# SPOOL
40R61	ROSIN CORE 1/8" - 1# SPOOL



CAUTION:

Lead-bearing solders are not to be used in potable water systems.

60/40

With some exceptions, these tin-lead solders can be used to join copper and most copper alloys, lead, nickel alloys and steel. Tin-lead solders are not recommended for joints subject to high stress or vibration in the cooling industry due to lack of sufficient elongation properties. These solders are also available with rosin or acid core. Similar to 50/50 but flows faster due to narrow melting range. **It is illegal to use lead solders in both public and private potable water systems.**

Chemical Composition	Solidus	Liquidus	ASTM B32
Sn-60%	360° F	375° F	Sn60
Pb-40%	182° C	191° C	

**USA
MADE IN**

PART NO.	SIZE
60401B	1# BAR
604031	1/16" - 1# SPOOL
604061	1/8" - 1# SPOOL
60R11	ROSIN CORE-1/32" - 1# SPOOL
60R31	ROSIN CORE-1/16" - 1# SPOOL
60R51	ROSIN CORE 3/32" - 1# SPOOL
60R61	ROSIN CORE-1/8" - 1# SPOOL
60R61/2POP	1/8" - 8 oz ROSIN CORE
60R31/2POP	1/16" - 8 oz. SPOOL ROSIN CORE

PN: 60R61/2POP
60/40
1/8" - 8 oz. SPOOL



CAUTION:

Lead-bearing solders are not to be used in potable water systems.

50/50

With some exceptions, these tin-lead solders can be used to join copper and most copper alloys, lead, nickel alloys and steel. Tin-lead solders are not recommended for joints subject to high stress or vibration in the cooling industry due to lack of sufficient elongation properties. These solders are also available with rosin or acid core. Note: It is illegal to use lead solders in both public and private potable water systems. **It is illegal to use lead solders in both public and private potable water systems.**

Chemical Composition	Solidus	Liquidus	ASTM B32
Sn-50%	360°F	420°F	Sn50, J-STD-006
Pb-50%	182°C	216°C	Sn50,Pb50a

**USA
MADE IN**

PART NO.	SIZE
5050TB	TRI BAR - 1#
50501B	1# BAR
505061	1/8" DIA - 1# SPOOL
505065	1/8" DIA - 5# SPOOL
5050620	1/8" - 20# SPOOL
50R31	ROSIN CORE 1/16" - 1# SPOOL
50R51	ROSIN CORE 3/32" - 1# SPOOL
50R61	ROSIN CORE 1/8" - 1# SPOOL
505061/2POP	1/8" - 8 oz SPOOL POP
50A61	ACID CORE 1/8" - 1# SPOOL

PN: 505061/2POP
50/50
1/8" - 8 oz. SPOOL



CAUTION:

Lead-bearing solders are not to be used in potable water systems.