



Stellar Technical Products
707 East Gardena Blvd.
Gardena, CA 90248

Technical Report

STEL-FLO Lead-Free Tri-Bar SOLDER

for Sheet Metal & Roofing Fabrications

Description:

Stel-Flo Lead-Free Solder is a reliable replacement for 50/50 Tin/Lead solders. Stel-Flo's 97% Tin/ 3% Copper alloy has a proven ten-year track record in the U.S. Stel-Flo is compatible as a metal joining material with copper, galvanized steel, tin/zinc tern-coated steels, pure zinc sheet and stainless steel.

Product Shape & Size:

Stel-Flo Lead-Free Solder comes standard as a 5/16" x 5/16" x 17" long triangular-shaped extruded bar. Each Stel-Flo "Tri-Bar" weighs approximately ¼ lb. and is packed in 50 lb. cases.

Stel-Flo Benefits:

- Lead-Free – exceeds all known state and federal requirements
- Compatible with same fluxes as 50/50 solder
- Compatible with most base metals
- 21% lower density than 50/50; 21% more lineal feet / lb.
- Stronger than 50/50 – stronger stress-to-rupture (creep resistance) at both 68F and 212F (in hot and cold cycling)

Physical Data:

<u>Property</u>	<u>Stel-Flo Lead-Free</u>	<u>50Tin/50Lead</u>	<u>Pure Tin</u>
Melting Range	441 – 590 F	361 – 421 F	450 F
Tensile Strength (Bulk)	6200 PSI	6000 PSI	2000 PSI

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****Quality Soldering Materials & Production Supplies****