

Solder and Soldering Accessories



1. Scope

This standard covers the requirements for solder and soldering accessories such as acid brushes and plumber's candles.

This standard applies to the following Seattle City Light (SCL) stock numbers:

Stock No.	Description
728504	Wire, solder, rosin core, 50/50, 3/32 in
728536	Wire, solder, 40/60, 1/8 in
728514	Wire, solder, silver, 50, 1/16 in
760625	Brush, acid, 3/8 in wide x 6 in long
728016	Candle, plumber's, 5 in x 1-1/4 in

2. Application

Tin-lead solders (Stock Numbers 728504 and 728536) can be used to join copper and most copper alloys, lead, nickel alloys and steel. Use for general purpose soldering and electrical applications. Lead-bearing solders are not to be used in potable water systems.

Silver solder (Stock Number 728514) is useful in brazing electrical connections and as a cadmium free replacement for 50% silver alloys. It has a wide melting range suitable for bridging gaps where poor fit-ups are encountered.

Acid brushes are used to apply flux or to clean solder.

Plumber's candles are used in a process called "lead wiping" which joins cable or pipe. The wax is used on wiping cloths to prevent molten lead from sticking to the cloth.

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3. Industry Standards

Products shall meet the applicable requirements of the latest revision of the following industry standards:

ANSI/ASTM B32 – Standard Specification for Solder Metal

ANSI/AWS A5.8 – Specification for Filler Metals for Brazing and Braze Welding

4. Requirements

Product requirements shall be as defined in Section 7.

5. Packaging

Products shall be packaged to prevent damage during shipping, handling, and storage.

Individual packages shall be legibly marked with:

- Manufacturer name
- Manufacturer catalog number
- Product description
- Seattle City Light stock number

Shipping containers shall be legibly marked with:

- Seattle City Light purchase order number
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6. Issuance

Stock Unit: Stock No. 760625 and 768016: EA
 Stock No. 728504 and 728536: LB
 Stock No. 728514: CO

7. Approved Manufacturers

Stock No.	Description	Manufacturer	Part No.
728504	Wire, solder, rosin core, 50/50, 3/32 in <ul style="list-style-type: none">▪ Solidus, 361°F▪ Liquidus, 421°F▪ 1-lb spool	Harris Products Group	50R51
728536	Wire, solder, 40/60, 1/8 in <ul style="list-style-type: none">▪ Solidus 361°F▪ Liquidus 448°F▪ 1-lb. spool	Harris Products Group	406061
728514	Wire, solder, silver, 50, 1/16 in <ul style="list-style-type: none">▪ 50% silver brazing alloy▪ Cadmium free▪ Solidus, 1270°F▪ Liquidus, 1425°F▪ #5035 – 5 coil per pack▪ #5031 – 1 coil per pack	Harris Products Group	5035 5031
760625	Brush, acid <ul style="list-style-type: none">▪ No. 1▪ Width, 3/8 in▪ Length, 6 in▪ Trim, 3/4 in▪ Flat brush, stiff horsehair or bristle rifling▪ Metal handle	National Novelty Brush Co.	#1-ACID
768016	Candle, plumber's <ul style="list-style-type: none">▪ Length, 5 in▪ Diameter, 1-1/4 in	Candle-Lite Company	5416595

8. Sources

Neuansourinh, Ponet; SCL Standards Engineer and originator of 7639.65
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SCL Stock Catalog page 76-41; January 13, 2014

www.candle-lite.com

www.harrisproductsgroup.com

www.nnbc-pa.com