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**TECHNICAL SPECIFICATION**

**95/5 LEAD FREE  
PLUMBING SOLDER**



**TECHNICAL SPECIFICATION:** Oatey 95/5 Lead Free Plumbing Solder is a solid wire solder for use in plumbing applications where frequent and extreme temperature changes and vibrations occur. 95/5 Solder is commonly used for potable water applications, refrigeration lines and cooling equipment. 95/5 Solder complies with CA & VT lead content regulations.



**PRECAUTIONS**

Read all cautions and directions carefully before using this product. Apply flux with brush- do not apply with fingers. Wash hands thoroughly after use and before eating. Wear safety glasses with side shields and rubber gloves. EYE AND SKIN IRRITANT. HARMFUL IF SWALLOWED. VAPOR MAY BE HARMFUL. Use only in well ventilated area. Eye or skin contact may cause intense irritation and injury. In case of contact with eyes or skin, flush with water and seek medical attention immediately. If inhaled, get fresh air and seek medical attention if ill feelings persist. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information. For emergency first aid help, call 1-877-740-5015.

**PHYSICAL/CHEMICAL PROPERTIES**

Alloy composition	Tin & Antimony
Appearance	Silver Solid Wire
Melting Range	450° F to 464° F

**DIRECTIONS FOR USE**

Cut the pipe to the exact length required using a tube cutter. Be sure the pipe is cut square. Remove all burrs on the inside and outside of the pipe surface with a reamer tool. Remove all oil, grease and oxide corrosion from the surface of the piping to be joined using Oatey Abrasive Sandcloth, Utility Brushes or Nylon Grit Pads. The joining surfaces must be clean before soldering. Apply a small amount of approved flux to the pipe and fitting surface. Proper fluxing is important because the flux promotes the flow of the filler metal. Insert the pipe end into the fitting. Heat the joint area, using caution not to overheat the joint. Feed the solder wire into the joint. When the solder wire has drawn around the entire joint, remove the heat. When soldering process is complete, allow the joint to cool undisturbed. When joint is cool, remove any flux residual with a damp cloth.

**COMMON APPLICATIONS**

Oatey 95/5 is commonly used for potable water applications, refrigeration lines and cooling equipment.

Consult Oatey Technical Department for applications not specifically referenced above.

**INGREDIENTS (CAS Number)**

Tin (7440-31-5)  
Antimony (7440-36-0)

**COMPLIANCE & LISTINGS**



IAPMO Listed.



Maximum weighted average 0.25% lead  
Complies with CA & VT lead legislation

PRODUCT NUMBER	DESCRIPTION	GAUGE	PACK	CARTON WEIGHT
29031	1 oz. 95/5 Solid Wire Solder – Bulk	.081	20	12 lbs.
53026	1 oz. 95/5 Solid Wire Solder – Display	.081	12	1 lb.
53181	1 oz. 95/5 Solid Wire Solder – Carded	.081	12	1 lb.
53027	4 oz. 95/5 Solid Wire Solder – Display	.081	12	4 lbs.
53189	4 oz. 95/5 Solid Wire Solder – Carded	.081	12	4 lbs.
22004	8 oz. 95/5 Solid Wire Solder – Bulk	.117	10	5 lbs.
22017	1 lb. 95/5 Solid Wire Solder – Bulk	.117	25	25 lbs.
22018	1 lb. 95/5 Solid Wire Solder – Bulk	.117	10	11 lbs.