



Galvanite_{tm} Soldering Guidelines

Step 1 Pre-clean the parent metal. Use emery cloth, a wire brush, sandblasting, etc. Cleaning galvanized steel surfaces is often done with a stainless steel wire brush. Breaking the oxide coating by agitation is an important key to successful Galvanite_{tm} application.

Step 2 Use a soft flame, heat gun or soldering iron to heat the parent metal repair area. If you use a direct flame, please keep it moving. A direct flame held on the repair area is likely to overheat the solder.

DO NOT DIRECTLY HEAT THE SOLDERING ROD!

Step 3 Hold the torch tip 4 to 6 inches away from the parent metal. If it is necessary to apply the flame directly to the rod to get it started, pull the torch tip back even farther from the work surface and keep it moving.

Step 4 Drag the rod over the area to be soldered, until it begins to flow.

ONCE THE ROD FLOWS, STOP APPLYING THE HEAT!

If additional layers are needed, continue to drag the rod over the area.

Step 5 Sometimes it is necessary to heat the tip of the rod with the flame to help the solder flow more easily onto the repair area.

DO NOT HEAT THE ROD TO THE MELTING POINT!

Step 6 Observe the solder deposit. The solder should bond smoothly.

DO NOT OVERHEAT!

The solder rod will melt if overheated, but will not bond properly. Spread the solder deposit evenly over the repair area. A stainless steel brush works well for this step.

Step 7 If you stopped soldering and want to apply more solder or flow out the deposit more, let it cool below the solid temperature, and reheat. The existing Galvanite will help the bonding process, whether adding more solder or just flowing out the previous deposit. If substantial time has elapsed since the original Galvanite_{tm} was applied, pre-clean the repair area again to remove any oxide coating that will impair bonding. Again, a SS brush works well for this step.

Step 8 Smooth the repair area and remove any excess Galvanite_{tm} with a wire brush.

Step 9 Repeat these steps to build up additional layers of Galvanite_{tm} Protection