



## KappZapp4SOS™ - Stainless One Step Solder

### Description

**KappZapp4SOS™** Tin-Silver solder is an NSF-compliant Lead-free Cadmium-free solder designed specifically for one step soldering of stainless steel components. It also provides a strong and ductile joint with a high tolerance to vibration and stress on Copper and Brass. Its highly active flux core paired with its wide workable range of 430-440°F (221-227°C) makes it the ideal solder for stainless steel applications in any orientation. In many cases, a stronger overall assembly exists after joining with KappZapp4SOS™ than with higher temperature Silver brazing alloys.

### Benefits & Features

**KappZapp4SOS's** highly active acid core effectively breaks down the tough oxide layer on stainless steel and ensures a strong bond is made in one step. This solder's low slushy range of 430-475°F (221-246°C) minimizes the heat applied and distortion of thin wires, tabs, and sheets.

### Applications

- Stainless Steel, copper and brass plumbing, tube, and sheet applications
- Fabrication, ducting, food containers, storage bins, and cooling coils for refrigerators
- Food and potable water safe
- Used in the food processing industry for the manufacture/repair of Stainless Steel parts and components
- Paired with Kapp Comet™ Flux when extra flux is needed
- **Acid-Cored Solders are not recommended for electrical/electronic applications, unless the joint area can be thoroughly cleaned of any residue. Consider KappZappR™ Rosin-Cored Solders for electrical / electronic applications**

### Properties

Composition	
Sn (Tin):	96%
Ag (Silver):	4%
Technical Data	
Melting Range:	430-475°F (221-246°C)
Tensile Strength (Copper):	14,200 psi
Tensile Strength (Stainless Steel):	28,000 psi
Shear Strength:	11,600 psi
Elongation:	49%
Electrical Conductivity:	16.5%
Sn=Tin, Ag=Silver	



This product complies with NSF/ANSI/CAN Standard 372: Drinking Water System Components – Lead Content. Product also complies with NSF/ANSI/CAN 61 and conforms with Lead content requirements for “Lead-free” plumbing as defined by California, Vermont, Maryland, and Louisiana state laws and the U.S. Safe Drinking Water Act in effect as of January 4, 2014. Weighted average lead content < 0.25%; Solder and flux lead content < 0.20%.

This alloy complies with the European RoHS and REACH directives. No lead, cadmium or mercury used in production.

**Product Variants - Available in standard forms:** 1/8" (.125") 3.2mm. Custom alloys and forms are our specialty. Call a Kapp representative to discuss what size and diameter are right for you.