Oatey 50692

Oatey 50692 Safe-Flo Wire Solder Kit Instruction Manual

Model: 50692

1. Product Overview

The Oatey Safe-Flo Wire Solder Kit (Model 50692) is designed for lead-free plumbing applications, specifically for joining copper piping. This kit provides all necessary components for effective and safe soldering, meeting the requirements of the Safe Drinking Water Act.

Kit Contents:

- Wire Solder: Lead-free alloy (copper, bismuth, tin, silver) with a low melting point for uniform flow.
- Tinning Flux: Smooth, non-runny paste that cleans, fluxes, and pre-tins copper piping.
- Abrasive Cloth: Used for removing oxidation from copper surfaces.
- Application Brush: For easy and even application of flux.



Image 1.1: The Oatey 50692 Safe-Flo Wire Solder Kit, showing the solder wire, flux container, and application brush within its packaging.

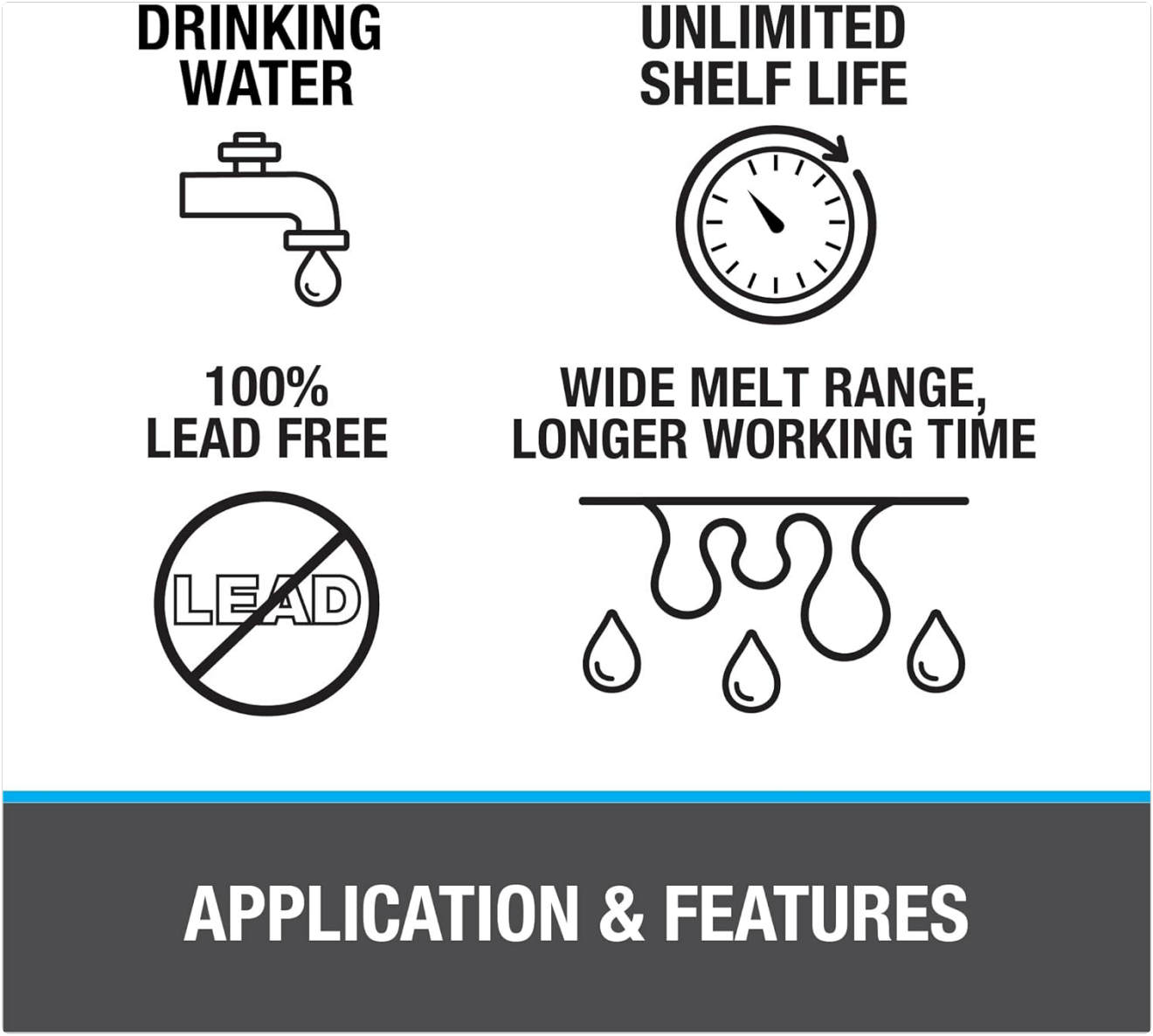


Image 1.2: Visual representation of key product features, including 100% lead-free composition, suitability for drinking water lines, unlimited shelf life, and a wide melt range for longer working time.

2. Safety Information

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Always read and follow all safety warnings and instructions provided with the product.

When working with soldering equipment and materials, always observe the following safety precautions:

- Wear appropriate personal protective equipment (PPE), including safety glasses or goggles and heat-resistant gloves.
- Ensure adequate ventilation in the work area to disperse fumes. Avoid inhaling fumes directly.
- Handle hot soldering tools and materials with extreme care to prevent burns.
- Keep flammable materials away from the work area.
- Store all components in a cool, dry place, out of reach of children and pets.
- Do not ingest flux or solder. Wash hands thoroughly after handling.

3. Setup and Preparation

Proper preparation is crucial for creating strong, leak-free solder joints.

1. **Clean the Copper Pipe:** Use the abrasive cloth included in the kit to thoroughly clean the ends of the copper pipes and fittings that will be joined. Remove all oxidation, dirt, and grease until the copper shines. A clean surface ensures proper solder adhesion.
2. **Inspect Components:** Ensure that the pipes and fittings are free from dents, burrs, or other imperfections that could affect the joint.
3. **Dry Fit:** Assemble the pipes and fittings without solder to ensure they fit together correctly and that the joint is properly aligned.

4. Operating Instructions (Soldering Process)

Follow these steps for effective soldering using the Oatey Safe-Flo Wire Solder Kit:

1. **Apply Flux:** Using the application brush, apply a thin, even coat of Oatey H-2095 Tinning Flux to the cleaned surfaces of both the pipe end and the inside of the fitting. The flux helps clean the surfaces further and allows the solder to flow properly.



Image 4.1: A person demonstrating the application of Oatey H-2095 Tinning Flux to the end of a copper pipe using the provided brush, preparing it for soldering.

2. **Assemble the Joint:** Immediately after fluxing, push the pipe into the fitting, twisting slightly to ensure even distribution of the flux.
3. **Heat the Joint:** Using a suitable heat source (e.g., propane torch), apply heat evenly to the fitting, not directly to the solder. Heat the joint until the flux begins to bubble and turn clear. The copper will also start to change color.
4. **Apply Solder:** Once the joint is sufficiently hot, remove the heat source and touch the Oatey Safe-Flo Wire Solder to the joint where the pipe meets the fitting. The solder should melt quickly and be drawn into the joint by capillary action, forming a complete seal. Do not overheat the joint, as this can burn the flux and prevent proper solder flow.
5. **Cool and Clean:** Allow the joint to cool naturally without disturbing it. Once cool, wipe away any excess flux residue with a damp cloth.

The lead-free solder wire has a low melting point, which facilitates its flow into the seated joint, making it ideal for copper plumbing installation.

5. Maintenance

Proper care and storage of your soldering kit components will ensure their longevity and effectiveness.

- **Clean Tools:** After each use, clean the application brush thoroughly to remove flux residue.
- **Store Solder and Flux:** Keep the wire solder coiled and the flux container tightly sealed when not in use. Store them in a cool, dry place to prevent contamination and maintain product integrity.
- **Dispose of Waste:** Dispose of any used abrasive cloth or excess materials according to local regulations.

6. Troubleshooting Common Issues

If you encounter issues during the soldering process, consider the following:

- **Solder Not Flowing:**
  - *Cause:* Insufficient heat or improperly cleaned surfaces.
  - *Solution:* Ensure the joint is heated evenly and sufficiently. Re-clean and re-flux surfaces if necessary.
- **"Cold" Solder Joint (Dull, Pitted Appearance):**
  - *Cause:* Joint moved during cooling or insufficient heat.
  - *Solution:* Reheat the joint, apply more solder if needed, and allow it to cool undisturbed. Ensure adequate heat is applied during soldering.
- **Excessive Solder Buildup:**
  - *Cause:* Too much solder applied or joint not hot enough to draw solder in.
  - *Solution:* Apply solder sparingly, only touching it to the joint when the copper is at the correct temperature to draw it in.

7. Specifications

Attribute	Detail
Brand	Oatey

Model Number	50692
Item Weight	7.4 ounces
Product Dimensions	12 x 5 x 2.25 inches
Solder Size	1 oz. (wire)
Flux Size	1.7 oz. (tinning flux)
Material	Lead-free metal alloy (solder), Paste (flux)
Compliance	Meets Safe Drinking Water Act requirements

8. Warranty and Support

For information regarding product warranty or technical support, please contact Oatey customer service directly. Visit the official Oatey website or refer to the product packaging for contact details.
Oatey Website: www.oatey.com

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