

KappRad Soldering Instructions

Successful Soldering with KappRad

1. Pre-clean the parent metal or metals to be joined. Use Emory cloth, a wire brush, sandblasting, etc. Prepare aluminum surfaces with a stainless steel wire brush.
2. Apply Kapp's noncorrosive liquid Golden Flux to the repair area. You may easily use the rod to apply the flux.
3. Use a soft flame, heat gun or soldering iron to heat the parent metal adjacent to the repair area. A direct flame on the repair area is likely to overheat the solder and flux.
4. 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 or flux, pull the torch tip back even farther from the work surface and keep it moving.
5. The flux will begin to bubble and turn light brown. Besides preparing the parent metal for the solder, these changes indicate the proper working temperature. If the flux turns black, let the area cool, clean it up and start over.
6. When the flux turns brown, it is time to apply the rod. Drag the rod over the area to be soldered until it begins to flow. **STOP APPLYING THE HEAT!** If additional layers are needed, continue to drag the rod over the area.
7. Sometimes it is necessary to heat the tip of the rod with the flame to help the solder flow easier and quicker onto the repair area.

DO NOT HEAT THE ROD TO THE MELTING POINT!

8. Observe the solder deposit. The solder should bond smoothly. **DO NOT OVERHEAT!** The rod will melt if overheated, but will not bond properly.
9. If you stopped soldering and want to apply more solder or flow out the deposit more, add more flux and reheat. The flux will help the bonding process, whether adding more rod or just flowing out the previous deposit.
10. Remove the excess flux with warm water and a wire brush.