



# Lead-Free Brass Soldering Tips

As the plumbing industry transitions to lead-free brass pipe, valves, and fixtures to meet the requirements of the 2014 Reduction of Lead in the Drinking Water Act, it's important to understand the best practices for soldering in the new 'lead-free' world. Soldering lead-free brass can be a little tricky, but if you follow these basic steps, you should not have any issues in making a solid joint:



- 1** Squarely cut pipe to appropriate length. Ream pipe, smoothing cut edges and removing any burrs.



- 2** Clean all copper pipes and fittings with Oatey high carbon steel brush, abrasive cloth, emery cloth or other abrasive materials, then wipe with a clean cloth.



- 3** Apply a thin coat of **Oatey H-20<sup>95</sup> Water Soluble Tinning Flux** to outside of pipe and inside of fittings. Place the pipe completely in the fitting.



#30143 shown



#23001 shown



- 4** Heat the joint with a propane, acetylene, or MAPP torch, evenly heating the pipe and fitting and **Oatey Silver Lead Free Plumbing Solder**. The most important elements in soldering lead-free brass fittings are using high quality flux (Oatey H-20<sup>95</sup>) and solder (Oatey Silver Lead Free Plumbing Solder) with a wide melt temperature range to insure **EVEN HEAT DISTRIBUTION AROUND THE FITTING** until the solder begins to draw.

**YOU HAVE TO HEAT AROUND THE FITTING – moving the torch to insure that one side of the item being soldered does not get too hot. DO NOT OVERHEAT!**



- 5** Allow the joint to cool naturally. Clean the joint and excess flux with a clean, damp rag. Never shock cool with water as it may result in unnecessary stress to the joint.

**Should you have further questions regarding soldering and fluxing lead-free brass material products, please consult your Oatey Representative or contact Oatey Technical Support at 1-800-321-9532**

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