

## 385-SEL

Rev: 14.1

**Date** 2025.09.02  
**Language** English  
**SDS** 950309



## Summary

385-SEL is a REL0 classified, alcohol-based flux for selective soldering. It is based on synthetic resins and shows high SIR values.

| Flux code            | 385-SEL |
|----------------------|---------|
| PROCESS              |         |
| No-Clean process     | 9       |
| Post-solder cleaning | 6       |

| INDUSTRY APPLICATION            |   |
|---------------------------------|---|
| Consumer electronics            | 6 |
| Standard industrial electronics | 8 |
| Hi-Rel electronics (automotive) | 9 |

| PROCESS CAPABILITY             |   |
|--------------------------------|---|
| Dip Soldering                  | 6 |
| Drag soldering                 | 9 |
| Dropjet fluxing                | 9 |
| High Pre-heat compatible       | 6 |
| High soldering temp compatible | 6 |
| Long contact time compatible   | 7 |
| Reduces spreading of flux      | 6 |
| Reduces solderballing          | 8 |
| Reduces bridging               | 8 |
| Improves TH filling            | 8 |
| Brilliant joint appearance     | 9 |
| Cosmetic Cleanliness           | 9 |
| ICCT compatible                | 9 |
| Conformal coating compatible   | 9 |

| Legend                                           |        |
|--------------------------------------------------|--------|
| <i>Especially made for this purpose</i>          | 9 - 10 |
| <i>Generally qualified for this purpose</i>      | 7 - 8  |
| <i>Generally usable, but not the best choice</i> | 5 - 6  |
| <i>Generally not usable for this purpose</i>     | 3 - 4  |
| <i>Wrong choice</i>                              | 1 - 2  |

## CLASSIFICATION

|                       |         |
|-----------------------|---------|
| DIN EN 29454-1: 1994  | 1.2.3.A |
| IPC-J-STD-004-A: 2004 | REL0    |

## PROPERTIES

|                |                |           |
|----------------|----------------|-----------|
| Density        | @20°C [kg/dm³] | 0.804     |
| Acid number    | [mg KOH/g]     | 18.8      |
| Solid content  | [% w/w]        | 1.9       |
| Water content  | [% w/w]        | 1         |
| VOC content    | [% w/w]        | Remainder |
| Filmformer(s)  |                | Resin     |
| Color          |                | Colorless |
| Odor           |                | Alcoholic |
| Flashpoint COC | [°C]           | 11.9      |
| Thinners       |                | 425-00    |

## TEST REPORTS

|                           |         |
|---------------------------|---------|
| Certificate of Compliance | website |
| Application Note          | english |

## PACKAGING AND STORAGE

|                                  |                |        |
|----------------------------------|----------------|--------|
| Packaging bottle (HDPE) [liter]  | (HDPE) [liter] | 1      |
| Packaging can (HDPE) [liter]     | (HDPE) [liter] | 5 / 10 |
| Recommended shelf-life in Months |                |        |
| Storage temperature              | 20-25 °C       | 12     |

Check material compatibility with every process change!

Industrial chemical product.

Read MSDS before use.

## Disclaimer:

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