

# Gemini<sup>®</sup> S

## Solder / Torch, Iron, Furnace

For all metals; stainless, copper, bronze, brass, Monel, cast iron, nickel, and all alloys (no white metals).

### Features

- High Strength 16,000 psi
- Easy To Use
- Very Low Temperature
- Stainless Color Match
- Use Acid Or Neutral Flux
- Ideal For Food Service
- Corrosion Resistant
- No Cadmium, Lead, Zinc Or Antimony
- Stays Bright
- High Silver Content

### Characteristics

**Gemini S** has a great variety of all purpose characteristics. In maintenance many metal repairs can be made with a low temperature solder-like material. **Gemini S** produces high strength joints that resist corrosion and stay bright.

No low cost metals such as lead, zinc, antimony or cadmium are used in this unusual product. The high silver content and flux make **Gemini S** a universal metal mending tool for hundreds of maintenance application.

### Technical

Temperature: 420°F (215°C)

Inches	1/8
(mm)	(3.2)

### Application

- Clean joint thoroughly.
- Apply **Gemini Solder Flux** (acid) for all applications except electrical.
- Apply **Gemini Neutral Flux** (rosin) for all electrical applications - both available separately.
- Apply heat indirectly by any heat source.
- Feed **Gemini S** when it begins to melt.
- Make certain heat is sufficient to draw the alloy through the entire joint.

# Gemini® SA

## Solder / Torch, Iron, Furnace

An acid flux core solder for all metals; stainless, copper, bronze, brass, Monel, cast iron, nickel, and all alloys (no white metals).

### Features

- High Strength 16,000 psi
- Easy To Use
- Very Low Temperature
- No Cadmium Or Lead
- Stainless Color Match
- Ideal For Food Service
- Corrosion Resistant
- No Zinc Or Antimony
- Stays Bright
- High Silver Content

### Characteristics

**Gemini SA** has a great variety of all purpose characteristics. In maintenance many metal repairs can be made with a low temperature solder-like material. **Gemini SA** produces high strength joints that resist corrosion and stay bright.

No low cost metals such as lead, zinc, antimony or cadmium are used in this unusual product. The high silver content and flux make **Gemini SA** a universal metal mending tool for hundreds of maintenance application.

### Technical

Temperature: 420°F (215°C)

Inches	1/16	1/8
(mm)	(1.6)	(3.2)

### Application

- Clean joint thoroughly.
- For extra cleaning and wetting action apply **Gemini Solder Flux** (available separately).
- Apply heat indirectly by any heat source.
- Feed **Gemini Solder Flux** when it begins to melt.
- Make certain heat is sufficient to draw the alloy through the entire joint.

# Gemini® SR

## Solder / Torch, Iron, Furnace

A rosin flux core solder for all metals; stainless, copper, bronze, brass, Monel, cast iron, nickel, and all alloys (no white metals).

### Features

- High Strength 16,000 psi
- Easy To Use
- Very Low Temperature
- No Cadmium Or Lead
- Corrosion Resistant
- No Zinc Or Antimony
- Stays Bright
- High Silver Content

### Characteristics

**Gemini SR** has a great variety of all purpose characteristics. In maintenance many metal repairs can be made with a low temperature solder-like material. **Gemini SR** produces high strength joints that resist corrosion and stay bright.

No low cost metals such as lead, zinc, antimony or cadmium are used in this unusual product. The high silver content and flux make **Gemini SR** a universal metal mending tool for hundreds of maintenance application.

### Technical

Temperature: 420°F (215°C)

Inches	1/16
(mm)	(1.6)

### Application

- Clean joint thoroughly.
- For improved cleaning and wetting action apply **Gemini Neutral Solder Flux** (available separately).
- Apply heat indirectly by any heat source.
- Feed **Gemini Solder Flux** when it begins to melt.
- Make certain heat is sufficient to draw the alloy through the entire joint.

# Gemini® SSP

## Solder Paste/Torch, Iron, Furnace

For all metals, including brass, Monel, cast iron, stainless, copper, bronze, nickel and all alloys (no white metals).

### Features

- Minimum Preparation
- Fast and Certain Results
- May Be Preplaced
- 16,000 psi
- Acid Type Flux Pre-Mixed
- Simple To Apply, Wipe-On Application
- Lead Free

### Characteristics

**Gemini SSP** is a high strength silver solder powder pre-mixed in a flux paste. It can be used to join all similar and dissimilar metals (except white metals). It is especially suitable where the part form allows it to be easily preplaced in joint locations that are hard to reach by conventional methods.

### Technical

Temperature: 420°F (215°C)

### Can Size

Available in 1# (454gm) Container

### Application

- Clean joint thoroughly.
- Paint solder paste on all surfaces to be joined.
- Heat slowly and avoid overheating.
- In furnace use 20% higher temperature.
- When flux rises to surface and darkens, job is done.
- Remove excess flux with warm water.

# Gemini® SCA

## Solder Paste/Torch, Iron, Furnace

For all metals including brass, Monel, cast iron, stainless, copper, bronze, nickel and all alloys (no white metals).

### Features

- 8,000 psi
- May Be Preplaced
- Acid Flux Pre-Mixed
- Simple Wipe On Application
- Minimum Preparation
- Fast and Certain Results

### Characteristics

**Gemini SCA** is a non-silver lead bearing solder/flux paste with strength for all conventional soldering jobs. The cream-like texture makes it ideal for tinning or for jobs that are too difficult to solder. It is simply painted on the surface and heat applied by torch, iron or furnace. It is not recommended for potable water systems. Contains lead.

### Technical

Temperature: 370°F (188°C)

### Can Size

Available in 4# (1814gm) Container

### Application

- Clean joint thoroughly.
- Paint solder paste on all surfaces to be joined.
- Heat slowly and avoid overheating.
- In furnace use 20% higher temperature.
- When flux rises to surface and darkens, job is done.
- Remove excess flux with warm water.