DKL Metals Ltd. Bo'ness Road, Grangemouth, Stirlingshire, FK3 9XF

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Products for Automotive Body Repairs

THE USE OF DKL SOLDER PAINT AND CAR BODY SOLDERS

Solder paint has been used for many years to achieve a preparatory undercoat on steel body panels prior to loading with body solder. Although many modern manufacturers use polyester based body fillers, there is no substitute for a traditional metal loaded seam on a classic restoration. The use of DKL Solder Paint in the patching of vehicle bodies represents great economies not only in the amount of solder used, but also in labour time.

Being a viscous material, it can be applied to vertical panels and incurs no wastage by solder droppings. The panel can be tinned in selected areas and the solder and flux is applied to the surface in one operation.

In order to obtain good bonding, the panel or joint area which is to receive the patch should be thoroughly sanded to remove any surface contamination, dirt or welding residue.

DKL Solder Paint should be applied by brush to the area to be tinned and then heated by flame. Whilst the tinning is still molten, wipe the surface with a clean cloth or cotton waste to remove any flux residues. Once the panel or joint has been completely tinned, the body patching solder should be applied to the surface by "puddling" on to the panel in thick dabs or patches. Continue to play the flame over these patches to keep the solder soft and buttery and work over the panel to the desired shape. As the body patching solder has a pasty or plastic range, it is possible to build up the surface thickness with careful application of the flame. A great advantage of using body patching solder is that if the desired profile is not achieved first time, the panel can be re-heated and more solder applied.

Care should be taken that the tinned area is larger than that required to be loaded.

The soldered area should be cleaned after loading to remove any possible residues and then filed and sanded to obtain the correct profile. It is important to ensure the whole area is thoroughly cleaned to ensure there is no contamination which may cause blistering to any subsequent paint finish.

LEAD or LEAD FREE?

Historically, metal joints and seams were filled with a tin/lead/antimony based body solder with a tin content of around 27%. DKL B27 Body Solder is suitable for this application. The surfaces should be pre-tinned with Sn60Pb40 Solder Paint.

Where a lead free application is required, the surfaces should be pre-tinned with Pure Tin Solder Paint. ISO 9453:2020(E) Alloy 402 Sn97Cu3 can then used as a filler alloy.

Both alloys posses a good plastic range allowing the solder to be manipulated to shape without dropping even on vertical panels. The use of DKL B128 High Activity Soldering Flux may be beneficial to remove any additional oxidation which may occur during the process.

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AVAILABILITY

DKL Solder Paint is available in both Sn60Pb40 and Pure Tin grades. It is packaged in 1kg tubs.

DKL B128 High Activity Soldering Flux is available in 1 and 5 litre containers.

DKL B27 Body Solder is available in 250g sticks, 500g and 1kg bars.

DKL Sn97Cu3 Lead Free Body Solder is available in 250g sticks, 500g and 1kg bars.

HEALTH AND SAFETY

Eye and skin protection should be worn when handling and using this material. Avoid breathing fumes that may be evolved during use. Ensure adequate extraction is provided in the workspace. For more detailed information consult the Material Safety Data Sheet (MSDS) which is available on request.

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