


Updated: 11/05/2010	<b>TECHNICAL DATA SHEET</b>	
Ref. : wire	<b><u>Solder wire "Sn60Pb40"</u></b>	
Created date : 03/05/2001	<b><u>Incorporated flux HC3</u></b>	

**1 – GENERAL CHARACTERISTICS :**

This binary soldering alloy is produced from 'first smelting' of tin and lead and conforms to standards: NFC 90550 – DIN 1707L – B.S.219 grade KP - BS EN alloy No. 2a.

**ADDITIONAL INFORMATION:**

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in Europe).

**2 – CHEMICAL CHARACTERISTICS :**

- 2.1 Amount of Tin : 60 % ± 0.6%  
 2.2 Amount of Lead : 40 % ± 0.4%  
 2.3 Tin-lead double refined at first melting, with an overall purity of 99.6 %.  
 2.4 Chart of maximum impurities :

Ag	Cu	Cd	Sb	Bi	Fe	Zn	Al	As	Others
0.005%	0.05%	0.002%	0.05%	0.01%	0.02%	0.001%	0.001%	0.01%	0.05%

2.5 Amount of flux incorporated: BS441 Grades 1, 2 or 3

BS441 Flux Grade	----- Mass of flux -----		
	Minimum	Nominal	Maximum
1	1.0 %	1.3 %	1.5 %
2	1.6 %	2.2 %	2.6 %
3	2.7 %	3.3 %	3.9 %

**3- PHYSICAL CHARACTERISTICS :**

**\*ALLOY Sn60Pb40**

- 3.1 Melting point : Solidus @183°C to liquidus @ 190°C  
 3.2 Specific weight : 8.5 g/cm<sup>3</sup>  
 3.3 Wire diameter : From 0.3 mm to 5 mm  
 3.4 Working temperature : 300 – 400 °C

**\*FLUX HC3**

- Halide: 6.5 %  
 Residues must be cleaned after soldering

**4- PACKAGING :**

- 4.1 Supplied on green spools : 500g, 1Kg, other on request.  
 4.2 Packed in cartons of : 12Kg, 24Kg.  
 4.3 Identification : Boxes and spools carry product information labels.  
 4.4 Quality assurance : A certificate of conformity can be issued for each manufactured batch if requested at the time of ordering.  
 4.5 Storage : in original packaging at room temperature for 12 months.