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| Updated: | SPECIFICATION |  |
| Ref. : Wire | <u>Solder Wire</u> | |
| Created : 04/07/2013 | <u>Alloy "Sn62Pb36Ag2"</u> Incorporated flux: EL | |

1 - GENERAL CHARACTERISTICS :

Low temperature (LMP) solder wire with incorporated flux for soldering equipment in electronics, telecommunications, rework or SMT. Being nearly Eutectic this alloy offers good flow characteristics and the alloy combination gives bright, high integrity joints. Conform to standards: NF 90550 – DIN 1707-8511 – QQS 571E – MIL.F.142560
B.S.219 code 62S, BS EN alloy No.30.

ADDITIONAL INFORMATION:

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

2 - CHEMICAL CHARACTERISTICS :

- 2.1 Amount of Tin : 62 % ± 0.7%
 2.2 Amount of Lead : 36 % ± 0.4%
 2.3 Amount of Silver : 2% ± 0.1%
 2.4 Tin-lead-silver double refined at first melting, with an overall purity of 99.6 %.

2.5 Chart of maximum impurities:

| | | | | | | | | |
|-------|--------|-------|-------|-------|--------|--------|-------|--------|
| Cu | Cd | Sb | Bi | Fe | Zn | Al | As | Others |
| 0.05% | 0.002% | 0.05% | 0.01% | 0.02% | 0.001% | 0.001% | 0.01% | 0.05% |

2.6 Available types of incorporated flux:

Rosin Halide Free: EL - R45 - RSNB **Rosin Mildly Activated: RL – CT2**
Rosin Activated: RD – RDV- CR **Synthetic Halide Free: S45V**
Hydro soluble: SR - HC2 **Others: please consult us.**

2.7 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: **Sn62Pb36Ag2**

- 3.1 Melting point : Solidus @178°C to liquidus @ 180°C
 3.2 Specific weight : 8.4 g/cm
 3.3 Wire diameter : From 0.3 mm to 5 mm
 3.4 Working temperature : 320 – 370 °C Typical

***FLUX EL – ROL0**

Halide: 0.0 %
 Acid value : 260
 Based on very pure rosin, most of halide compounds are removed by soldering process.
 The residues are non-corrosive.

4- PACKAGING:

- 4.1 Supplied on spools : 500g (Black DIN winding on request)
 4.2 Packed in cartons of : 10kg.
 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.