

Created
Date: 05/07/01

Ref: WIRE

SPECIFICATION

Fluidel 5 Solder Wire



Alloy Sn95 Sb5
Incorporated flux: Rosin Cored

1 - GENERAL CHARACTERISTICS:

This binary soldering alloy is produced from first smelting of tin and antimony and conforms to the standard - BS EN Alloy 18.

2 - CHEMICAL CHARACTERISTICS:

- 2.1 Amount of Tin : 95 % \pm 0.6%
2.2 Amount of Antimony : 5 % \pm 0.5%
2.3 Tin and antimony of first smelting purity
2.4 Chart of maximum impurities:

Cu	Ag	Cd	Pb	Bi	Fe	Zn	Al	As	Others
0.10	0.05	0.002	0.10	0.10	0.02	0.001	0.001	0.03	0.05

2.4 Available types of incorporated flux:

Rosin Activated: RMA & RA

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 Sn95Sb5**

- 3.1 Melting point : 230°C – 240°C
3.2 Specific weight : 7.25 g/cm³
3.3 Wire diameter : From 0.3 mm to 5 mm
3.4 Working temperature: ~350 °C - 420°C

***FLUX RMA & RA**

Halide: 0.5 %
Acidity index: N/A
Non corrosive
Solderability: Good on Copper substrates and excellent on surfaces of tin
Low spattering

4- PACKAGING:

- 4.1 Supplied on spools : 250g and 500g.
4.2 Packed in cartons of : 10 – 20 x 250 g. 10 – 20 x 500g.
4.3 Boxes and spools carry product information labels.
4.2 Quality assurance: A certificate of conformity can be issued for each manufactured batch if requested at the time of ordering.