SOLDER WIRE "FLUIDEL 5"

Alloy Sn **Pb**
Incorporated flux: S45V

SOLDER WIRE - These binary soldering alloys are produced from 'first smelting' of tin and lead and conform to standards: NF 90550, DIN 1707L, B.S.219 Grade KP and BS EN Alloys.

Chemical Characteristics

Amount of Tin:	** % ± 0.6%
Amount of Lead:	Remainder
Tin and lead from first melting purity:	99.96%.

Chart of maximum impurities, example:

Cu	Ag	Cd	Sb	Bi
0.01%	0.005%	0.001%	0.02%	0.01%

Fe	Zn	Al	As	Others
0.02%	0.001%	0.001%	0.01%	0.05%

Incorporated Flux: **Colophony Free**: S45V conforming to HSE Laboratory requirement.

Amount of flux incorporated: BS441 Grades 1, 2 or 3. Grade 1 is standard unless stated on spool label.

BS441 Flux Grade	---------- Mass of flux ---------		
	Minimum	Nominal	Maximum
1	1.0 %	1.3 %	1.5 %
2	1.7 %	2.0 %	2.6 %
3	2.7 %	3.0 %	3.4 %

Physical Characteristics, standard:

*ALLOY 60/40	
Melting point	Solidus @183°C to Liquidus @ 190°C
Specific weight	8.5
Wire dimensions	Diameters from 0.3 mm to 6 mm
Working temperature	370 to 420 °C

***FLUX S45V**

- Colophony free, synthetic resin base
- Halide: 0 %
- Acidity index : 220
- Non corrosive
- Solderability: good on Copper substrates and excellent onto surfaces of tin and lead
- Complies with copper mirror test
- Low spattering

Packaging

- Supplied on spools: 250g, 500g, 1kg, 3kg, 20kg.
- Packed in cartons of: 10-20 x 250 g, 20 x 500g, and others
- Boxes and spools carry product information labels.
- Quality assurance: Certificates of Conformity can be issued for each shipment batch if requested at the time of ordering.
- Shelf life 12 months at 20°C.

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