

**Sn60 Pb40 "RL"**

SN60 Pb40 – "RL" - This binary soldering alloy is produced from 'first smelting' of tin and lead and conforms to standards: NF 90550 – DIN 1707L – B.S.219 grade K/KP - BS EN alloy No. 2a.

Chemical Characteristics

Amount of Tin:	60 % ± 0.6%
Amount of Lead:	Remainder

Tin and lead from first melting purity: 99.90%

Chart of maximum impurities:

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: Rosin Base: RL:
NF 90550, J-Std-004 Class ROM1
DIN 8511 – FSW 26, EN ISO 9454 – 1.1.2

Amount of flux incorporated: BS441 Grades 1, 2 or 3
Grade 3 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	
Melting point	Solidus @183°C to Liquidus @ 190°C
Specific weight	~8.5 g/cm ³
Wire diameter	From 0.3 mm to 6 mm

***FLUX: RL3**

Rosin : Activated
Amine : 0.5%
Acidity index : 165
Non corrosive
Solderability: good on copper substrates and excellent on surfaces of tin and lead
Low splattering

Application Notes

Working temperature: 370°C - 420°C

Other Characteristics

Packaging: Supplied on spools 250gm, 500gm, 1kg, 3kg and 20kg
Packed in cartons of 10 – 20 x 250 gm, 20 x 500gm and others
Boxes and spools carry product information labels

Quality assurance: A certificate of conformity can be issued with each batch if requested at the time of ordering.

Storage: Shelf life 12 months at 20°C.