

Update: 16/04/2020	TECHNICAL DATA SHEET	
Ref: Wire	Solder Wire	
Created on: 03/05/2001	Pb93.5Sn5Ag1.5 CR	



GENERAL CHARACTERISTICS:

High melting point (HMP) solders wire, with incorporated flux for soldering equipment in electronics.
Conforms to standards ISO 9453 : alloy n° 191.

CHEMICAL CHARACTERISTICS:

Amount of Tin : 5 % ± 0.2%
Amount of lead : Rest
Amount of Silver : 1.5%. ± 0.3%
Tin-lead-silver double refined at first melting, with an overall purity of 99.6%
Type of cored flux : CR
Amount of cored flux : available in 2.2% (standard). Other: consult us.

PHYSICAL AND CHEMICAL CHARACTERISTICS:

ALLOY : Pb93.5Sn5Ag1.5

Melting point : Solidus 296°C - Liquidus 301°C
Specific weight : 11.04 g/cm³
Wire diameter : from 0.5mm to 5 mm

FLUX : CR

Natural rosin.
Chloride content : 1.1 %
Acid value: 220 mgKOH/g
(ECI >0,7 %)
Fast soldering.
CR flux is classified 1.1.2 according to standard ISO EN 9454.
CR flux is an activated rosin flux.
Cleaning is recommended after soldering.

USING CHARACTERISTICS:

Working temperature : 350°C to 460°C (typical)

PACKAGING / STORAGE:

Solder wire : Various types of reels available adapted to Customer's needs.
Depending on diameter and length.
Other product shape : On request
Storage : In original packaging at room temperature for 24 months.

SAFETY:

Material Safety Data Sheet available on request. Please consult it before use.

ADDITIONAL INFORMATION:

Quality Certificate available on request.

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



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