

Update:	TECHNICAL DATA SHEET	
Ref: Wire	Lead Free Water-soluble Solder Wire	
Created on: 10/12/2014	Sn96.5 Ag3 Cu0.5 HY0	



GENERAL CHARACTERISTICS:

A high quality ternary alloy for mechanical or electrical applications which demand lead free solders on difficult-to-solder surfaces composed of tin, silver and copper. It is an efficient suitable alternative to Tin/Lead. Others benefits are increased joint strength and water-washable residues.

Conforms to standard ISO 9453 : alloy n° 711.

CHEMICAL CHARACTERISTICS:

Amount of Tin : Rest
Amount of Silver : 3% ± 0.2%
Amount of Copper : 0.5% ± 0.2%
Tin from first melting, Copper with purity of 99.95 %
Type of cored flux : HY0
Amount of cored flux : 2.2%. Other: consult us.

PHYSICAL AND CHEMICAL CHARACTERISTICS:

ALLOY : Sn96.5Ag3Cu0.5

Melting point : Solid 217°C to liquid 219°C
Specific weight : 7.3 g/cm³
Wire diameter : from 0.5mm to 5 mm

FLUX :HY0

Water-soluble organic flux.
Chloride free.
Acid number : 83 mgKOH/g
Easily washable with water, which limits significantly the washing time.
Residues must be cleaned after soldering.
Limits splashes.

USING CHARACTERISTICS:

Working temperature : 320°C to 370°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 12 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 Europe).



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