


Updated: 27/04/2012 N°02	SPECIFICATION	
Ref. : Wire	<u>Solder wire "Sn63Pb37"</u>	
Created : 03/05/01	Incorporated flux: R45	

1 - GENERAL CHARACTERISTICS:

This binary soldering alloy is produced from 'first smelting' of tin and lead and conforms to standards: ISO EN 9453 – DIN 1707L – B.S.219 grade AP - BS EN alloy No. 1a. J-STD 006

ADDITIONAL INFORMATION:

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

2 - CHEMICAL CHARACTERISTICS:

- 2.1 Amount of Tin : 63 % ± 0.5 %
 2.2 Amount of Lead : 37 % ± 0.5 %
 2.3 Tin-lead double refined at first melting, with an overall purity of 99.6 %.
 2.4 Chart of maximum impurities :

Ag	Cu	Cd	Sb	Bi	Fe	Zn	Al	As	Div
0.005	0.05	0.002	0.05	0.01	0.02	0.001	0.001	0.01	0.05

2.5 Available types of incorporated flux:

Rosin Halide Free: EL - R45 – RSNB **Rosin Mildly Activated:** RL – CT2
Rosin Activated: RD – RDV- CR **Synthetic Halide Free:** S45V
Hydro soluble: SR - HC2 **Others:** please consult us.

2.6 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 Sn60Pb40**

- 3.1 Melting point : Eutectic @183°C
 3.2 Specific weight : 8.4 g/cm³
 3.3 Wire diameter : From 0.3 mm to 5 mm
 3.4 Working temperature : 350 – 450 °C

***FLUX R45**

ROL0/J-STD 004
1.1.3 - FSW32 / ISO 9454
 Natural Rosin
 Halide free
 Acid value : 310

4- PACKAGING:

- 4.1 Supplied on spools : 500g (others on request)
 4.2 Packed in cartons of : 10kg.
 4.3 Identification : Boxes and spools carry product information labels.
 4.4 Quality assurance : A certificate of analysis can be issued for each manufactured batch on request.
 4.5 Storage : In original packaging at room temperature for 12 months.