



## FLUIDEL 5 SOLDER WIRE

# ALLOY Sn 60 Pb40

**SOLDER WIRE** - 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 KP and BS EN Alloy No. 2a.

### Chemical Characteristics

Amount of Tin:	60 % ± 0.6%
Amount of Lead:	Remainder
Tin and lead from first melting purity:	99.96%.

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: **Organic Water Soluble Halide Free: SR**

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 5 mm
Working temperature	370 to 420 °C

### \*FLUX SR

- Water soluble organic flux
- Halide: 0 %
- Acidity index : 85
- Non corrosive
- Solderability: good on Copper substrates and excellent onto surfaces of tin and lead
- Water washable - must be cleaned in water for all applications.

### Packaging

- Supplied on spools: 250g, 500g, 1kg and 3kg.
- Packed in cartons of: 20 x 250 g, 20 x 500g, 16 x 1kg and 6 x 3kg.
- 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.