



# FLUIDEL 5 SOLDER WIRE

## ALLOY LEAD-FREE Incorporated flux S45V

**SOLDER WIRE** – The alloys are produced from 'first smelting' of tin and conform to standards: NF 90550, DIN 1707L, B.S.219 and BS EN Alloys.

### Chemical Characteristics

Sn95.5 Ag3.8 Cu0.7  
Sn96.5 Ag3.5  
Sn99.3 Cu0.7  
Tin from first melting purity: 99.96%.

Chart of maximum impurities, example:

Cd	Sb	Bi	Fe	Zn
0.01%	0.002%	0.001%	0.02%	0.01%

Al	As	Others
0.001%	0.01%	0.05%

Incorporated Flux: **Colophony Free, Halide Free Flux: S45V** conforming to HSE Laboratory requirement.

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:	
Sn95.5 Ag3.8 Cu0.7 Sn96.5 Ag3.5 Sn99.3 Cu0.7	- Eutectic 217 C - Eutectic 221 C - Eutectic 227 C
Wire dimensions	Diameters from 0.3 mm to 6 mm
Working temperature	270 to 420 °C

### FLUX S45V

- Colophony free, synthetic resin base
- Halide: 0 %
- Acidity index : 220
- Non corrosive
- Solderability: good on Copper substrates and excellent onto surfaces of tin and lead
- Complies with copper mirror test
- Low spattering

### Packaging

- Supplied on Din Reels: 250g, 500g, 1kg, 3kgs, 20kgs.
- Packed in cartons of: 10 - 20 x 250g. 20 x 500g and others.
- 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.