



FLUIDEL 5 SOLDER WIRE

ALLOY Sn60 Pb40
Incorporated flux: CT2

GENERAL CHARACTERISTICS: 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 - 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: **Rosin Base: CT 2**

Amount of flux incorporated: BS441 Grades 1, 2 or 3. Grade 3 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 CT2

- Rosin base - RMA
- Halide: 0.4%
- Acidity index : 200
- 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 spools: 250g, 500g, 1kg and 3kg and 20kg.
- Packed in cartons of: 10-20 x 250 g, 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.