



TECHNICAL DATA SHEET

Sn60Pb40 Solder Wire (No Clean & Rosin Cored)

PRODUCT DESCRIPTION

- High purity alloy that is composed of 60% Tin and 40% Lead from virgin metals.
- Applies at hand or feed soldering processes in Electronics & Electrical assemblies.
- Non-corrosive and no impact of flux residues forming at post soldering which means of passing in pin probe & flying probe tests for No Clean solder wires.
- If required, flux residues shall be cleaned with appropriate liquid application.
- Précised amount of flux cored from state-of-the-art-technology manufacturing process.

APPLICATION

This application is suitable for hand soldering process in Electronics & Electrical assemblies. Soldering iron set temperatures ranging from 350°C to 425°C are recommended to get desired solder joints. Application has designed with No-Clean flux cored in solder and residues may form on joints which may contribute no impact to circuit assemblies in the case of No Clean solder wires. Cleaning should be done when rosin cored solder wire used subject to in-house specification.

STORAGE AND HANDLING

- Do not use fire near storage area.
- Store in dry, cool and non-corrosive environment.
- Wear Personal Protective Equipments while handling.
- Wear Personal Protective Equipments while processing.

PRODUCT SPECIFICATION

NO	Item	Specification	Standard
1	Appearance	Bright and shiny finishes	NA
2	Alloy	SnPb40	IPC J-STD-006B
3	Melting Point	183°C	DSC
4	Flux Content	1.3%, 1.8%,2% & 2.2% ±0.1 %	JIS-Z-3283
5	Flux Type	F4, R, RC	NA
6	Packaging	500gm	
7	Diameter/Tolerance	16SWG,18SWG,20SWG,22SWG,24 SWG & 26 SWG	JIS-Z-3283
8	Shelf Life	5 Years	NA
9	Features	Excellent solder joint reliability. Superior joint strength. Excellent thermal & mechanical fatigue resistance. No cleaning or low cleaning required after solder joint	
10	Purpose	For use in applications requiring good activation.	



PHYSICAL PROPERTIES.

No	Test Item	Test Result	Test Method
1	Silver Chromate Test	PASS	IPC-TM-650, 2.6.33
2	Copper Mirror Test	PASS	IPC-TM-650, 2.6.32
3	Copper plate Corrosion	PASS	JIS-Z-3197, 6.6.1
4	S.I.R Test	1×10 ⁹ up	IPC-TM-650, 2.6.3.3
5	Electro Migration Test	1×10 ¹² up	IPC-TM-650, 2.6.14.1

ALLOY COMPOSITION.

(Sn)	(Pb)	(Sb)	(Cu)	(Bi)	(Zn)	(Fe)	(Al)	(As)	(Cd)
REM	39.5~ 40.5	0.20 MAX	0.08 MAX	0.10 MAX	0.003 MAX	0.02 MAX	0.005 MAX	0.03 MAX	0.002 MAX

For more details, please visit Our Website at www.persangalloy.com or write to us.

Regd Off & Works:
353, GIDC Estate, Waghodia-391760. Dist : Vadodara.
Phone: +91 2668 262718-9. Fax : +91 2668 262556
E-Mail : sales@persangalloy.com URL:www.persangalloy.com