


Updated: 16/02/10 N°01		
Ref. : Wire	<b>SPECIFICATION</b> <u>Fluidel 5 Solder Wire</u>	
Created: 16/07/02	<u>Alloy Sn 60 Pb38Cu2</u> <b>Incorporated flux: A11</b>	

### 1 – GENERAL CHARACTERISTICS:

The copper content in this ternary alloy offers better 'flow' than standard alloys – better 'wetting' and prolongs tip life. The alloy is more ductile at the joint for improved mechanical resistance to joint fracture from any 'in service' vibration. Joints are bright with a good profile. This ternary alloy is best for soldering to bare copper conductors especially suitable for soldering to winding wires or without solderable enamel.

The alloy conforms to standards: NFC 90550 designated under section B.Sn60Pb38Cu2.  
DIN 1707L – BS EN alloy No. 25.

### ADDITIONAL INFORMATION:

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

### 2 – CHEMICAL CHARACTERISTICS:

- 2.1 Amount of Tin : 60 % ± 0.5%
- 2.2 Amount of Lead : 38 % ± 0.5%
- 2.3 Amount of Copper : 2 % +0/-0.5%
- 2.4 Chart of maximum impurities:

Ag	Cd	Sb	Bi	Fe	Zn	Al	As	Others
0.005%	0.002%	0.05%	0.01%	0.02%	0.001%	0.001%	0.01%	0.05%

- 2.5 Incorporated flux : **A11**
- 2.6 Amount of flux incorporated : Standard = 2 % other on request

### 3– PHYSICAL CHARACTERISTICS:

#### **\*ALLOY:**

- 3.1 Melting point : Solidus @183°C to liquidus @ 189°C
- 3.2 Specific weight : 8.5
- 3.3 Wire dimensions : Diameters from 0.5 mm to 5 mm
- 3.4 Working temperature: 370 to 420 °C

#### **\*FLUX A11**

Blend of rosin and modified rosin.  
Halide: 1.1 %

### 4– PACKAGING:

- 4.1 Supplied on green spools : 250g and 500g. (DIN spools on request)
- 4.2 Packed in cartons of : 12 – 24 – 48 x 250 g. 12 – 24 – 50 x 500g.
- 4.3 Boxes and spools carry product information labels.
- 4.4 Quality assurance : Certificates of Conformity can be issued for each shipment batch if requested at the time of ordering.
- 4.5 Shelf life : 12 months at 20°C.