


Update : 13/01/2012	<b>TECHNICAL DATA SHEET</b>  <b><u>Sn63 Pb37 Eutectic</u></b>  <b><u>'NITRALLOY'</u></b>	
Ref. : Alloy		
Created 02/02/01		

### **1 - GENERAL CHARACTERISTICS :**

An alloy for flow soldering printed circuits to the highest standard, produced from very high quality metals which are smelted under a nitrogen atmosphere, this process minimises the formation of superficial oxide formation during manufacture. When used, *NITRALLOY* stays bright and faults such as bridges, flags and spikes are reduced to an absolute minimum. Maximum advantage can be gained from *NITRALLOY* bar solder when used with flow solder machines having a "nitrogen blanket" facility although increased performance will be gained in conventional "open atmosphere" types.

This alloy exceeds the requirements laid down in the Standards:

**ISO EN 9453, DIN 1707 and B.S.219 code AP, BS EN alloy No.1a. – J-STD 006**

### **2 - CHEMICAL CHARACTERISTICS :**

- 2.1 Tin and lead from first melting.
- 2.2 Amount of Tin : 62.5% to 63.5 %
- 2.3 Amount of lead : Remainder
- 2.4 Purity Rating : > 99.95%.

Cu	Ag	Cd	Sb	Bi	Fe	Zn	Al	As	S	Cl	P	others
<0.05 %	<0.005 %	<0.002 %	<0.05 %	<0.01 %	<0.02 %	<0.001 %	<0.001 %	<0.01 %	<0.001 %	<0.001 %	<0.001 %	<0.05 %

### **3- PHYSICAL CHARACTERISTICS :**

- 3.1 Melting point : Solidus to Liquidus @ 183°C Eutectic.
- 3.2 Working temperature : 230 to 250°C. Optimum @ 235 °C
- 3.3 Specific Weight : 8.4

### **4 - SUPPLIED AS :**

- 4.1 Bars : Extruded approx. 900g Bars in cartons of 24.  
( Exact Tare weight stated ).
- 4.2 Sticks : 250g in Cartons of 25 Kgs.
- 4.3 Granules : Containers of 20 Kgs.
- 4.4 Ingots : Approx. 3.9 Kgs
- 4.5 Wire : On spools of 15 Kgs. – 20 Kgs.

### **5 - STORAGE :**

- 5.1 - Original packaging, at an average temperature of 20°C.