SOLDERING MATERIALS
EN ISO 9001:2001
SOLDECO France
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TECHNICAL DATA SHEET

Alloy / grade acc. to EN ISO 9453:2014	Sn63Pb37 (101)
Form of the product:	Cored solder wire
Name of the flux:	F4V12

1. General characteristics

Cored solder wire Sn63Pb37 acc. to EN ISO 9453:2014 standard with 1 or 3 cores of F4V12 flux. Alloy Sn63Pb37 manufactured of high purity raw materials. Product designed for popular soldering applications, industrial applications in electronics and electrical engineering where meeting the requirements of the RoHS Directive is not requested.

2. Chemical characteristics

2.1. Content of tin: 62.5 – 63.5%
2.2. Content of lead: remain (36.5 – 37.5%)
2.3. Minimum purity of used raw materials: 99.90%
2.4. % composition acc. to EN ISO 9453:2014 standard:

Fe	Ni	Al	Cu	As	Zn	Ag	Sb	Bi	Sn	Cd	Au	In	Pb
max 0.02	max 0.01	max 0.001	max 0.08	max 0.03	max 0.001	max 0.1	max 0.2	max 0.1	62.5 - 63.5	max 0.002	max 0.05	max 0.1	remain

3. Physical characteristics

3.1. Melting temperature: 183°C (eutectic)
3.2. Density: 8.40 g/cm^3
3.3. Soldering tip temperature: above 300°C (recommended 320 - 420°C)

4. F4V12 flux

Rosin based, halide content flux.

4.1. Flux type: SW-26 (acc. to DIN 8511)
1.1.2 (acc. to EN ISO 9454)
ROL1 (acc. to IPC-J-STD-004B)
4.2. Halide content: 0,5%
4.3. Acid number: 190 mgKOH
4.4. Flux content: 1.0-2.5%, 1 or 3 cores

5. Product description

5.1. Available diameters: 0.25 – 4.00 mm
5.2. Cored solder wire on 100 g, 250 g, 500 g and 1 kg reels.
5.3. Packed in 10 kg cartons, except 100 g reels packed in 6 kg cartons.
5.4. Reels and cartons marked with alloy type, flux type, flux content, diameter, net weight and batch number.

6. Product storage

In original packaging at average temperature of 20 °C.