



TECHNICAL DATA SHEET

Sn63Pb37 Solder Wire (No Clean & Rosin Cored)

PRODUCT DESCRIPTION

- High purity Alloy that is composed of 63% Tin and 37% Lead from Virgin Metals.
- Applies at Hand or Feed Soldering Process in Electronic & Electrical Assemblies.
- Non-Corrosive and No Impact of Residues form at Post Soldering which means of passes in Pin Probe & Flying Probe Tests for No Clean Wires.
- If requires, Residues shall clean with appropriate Liquid Application.
- Précised amount of Flux cored from state-of-the-art-Technology Process.

APPLICATION

This application is suitable for hand Soldering Process in Electronic & Electrical Assemblies. Soldering Iron Set Temperatures ranging from 350°C to 400°C are recommended to get desired Solder Joints. Application has designed with No-Clean Flux Cored in Solder & Residues may form on Joints which may contribute no impact to Circuit Assemblies. Cleaning should be done when Rosin Cored Solder Wire used.

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	Sn/Pb37	JIS-Z-3282 A CLASS
3	Melting Point	183 ^o C (NA for Rosin Cored Wires)	DSC
4	Flux Content	1.3%, 1.8%,2%& 2.2% ±0.1 %	JIS-Z-3283
8	Packaging	500gm,	
9	Diameter/Tolerance	16SWG,18SWG,20SWG,22SWG,24 SWG & 26 SWG	JIS-Z-3283
11	Features	Excellent solder joint reliability. Superior joint strength. Excellent thermal & Mechanical fatigue resistance. Low cleaning required after solder joint	
12	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 ⁹ up	IPC-TM-650, 2.6.14.1

ALLOY COMPOSITION.

(Sn)	(Pb)	(Sb)	(Cu)	(Bi)	(Zn)	(Fe)	(Al)	(As)	(Cd)
REM	36.5~ 37.5	0.12 MAX	0.05 MAX	0.10 MAX	0.002 MAX	0.02 MAX	0.002 MAX	0.03 MAX	0.002 MAX

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

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