PRODUCT INFORMATION

FELDER-ISO-Core® "RA" – lead-free

**Flux-cored, halide-containing activated soft solder wire,
flux according to DIN EN 29454.1, 1.1.2.B
respectively DIN EN 61190-1-3, ROM1**

RoHS-conformity according to 2002/95/EG*

FELDER-ISO-Core® "RA" – lead-free

Article no.: (55)18.....

Description

Standard solder wire for hand soldering in the electrical engineering, electro mechanics and partly also in the electronics. The flux distinguishes itself through its high temperature resistance and does not spatter during the reflow soldering. An optimal wetting as well as standard excelling spreading values make this lead-free solder wire an advanced product among the cored solders.

***Lead-free FELDER-ISO-Core® "RA"-solder wires do not contain any substances that are subject to restriction by directive 2002/95/EG ("RoHS").**

Lead-free standard solder alloys

Alloy	ISO EN 9453	DIN EN 61190	Melting range	Article no.
Sn100Ni+ (SnCu0.7)	S-Sn99Cu1(AgNiGe)	Sn99Cu.7	227 °C	551894....
Sn99Ag+ (SnCu0.7Ag0.3)	S-Sn98AgCu1(NiGe)	-	217 – 227 °C	551881....
Sn96Ag+ (SnAg3Cu0.5)	S-Sn96Ag3Cu1(NiGe)	Sn96Ag03Cu0.4	217 – 219 °C	551876....
Sn95Ag+ (SnAg3.8Cu0.7)	S-Sn95Ag4Cu1(NiGe)	Sn96Ag04Cu0.7	217 °C	551884….
Sn96.5Ag3Cu0.5	S-Sn96Ag3Cu1	Sn96Ag03Cu0.4	217 – 219 °C	1876….
Sn95.5Ag3.8Cu0.7	S-Sn95Ag4Cu1	Sn96Ag04Cu0.7	217 °C	1884....
Sn95Ag5	S-Sn95Ag5	Sn95Ag05	221 – 240 °C	1892….
Sn96.5Ag3.5	S-Sn96Ag4	Sn96Ag04	221 °C	1896....
Sn97Ag3	S-Sn97Ag3	-	221 – 224 °C	1895….
Sn99.3Cu0.7	S-Sn99Cu1	Sn99Cu.7	227 °C	1894....
Sn97Cu3	S-Sn97Cu3	-	227 – 310 °C	1897....
Further lead-free alloys can be delivered on customer's request.				

Patents

FELDER GMBH produces all NiGe-alloys with the licence for Fuji-patents (JP 3296289, USP 6.179.935 B1 and DE 198 16 671 C2), as well as (if desired) all SAC-solders according to Senju-patent (JP 3027441) and ISURF-patent (US 5.527.628).

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Properties

Flux type	:	Halogen activated 1.1.2.B, (ROM1, F-SW26)
Flux content	:	2.5 % standard
Flux spreading	:	1 – (standard), 3 – und 5 – cores
Halide content	:	1.0 %
Ø in mm	:	0.25, 0.35, 0.50, 0.75, 1.00, 1.50, 2.00, 3.00, 4.00, 5.00, 6.00
Spool sizes in kg	:	0.10, 0.25, 0.50, 1.00, 2.50, 5.00

Impurity/tolerances

e.g.: SAC 305

Element content (%)	**Ag** 3.0± 0.2	**Al** 0.0010	**As** 0.0030	**Bi** 0.0200	**Cd** 0.0010	**Cu** 0.5± 0.2	**Fe** 0.0050
Element content (%)	**Pb** 0.0700	**Sb** 0.0400	**Sn** 96.5± 0.5	**Zn** 0.0010			

e.g.: Sn100Ni+

Element content (%)	**Ag** 0.0600	**Al** 0.0010	**As** 0.0030	**Bi** 0.0200	**Cd** 0.0010	**Cu** 0.7± 0.2	**Fe** 0.0050
Element content (%)	**Ge** 0.01±0.002	**Ni** 0.07±0.02	**Pb** 0.0700	**Sb** 0.0400	**Sn** 96.5± 0.5	**Zn** 0.0010	

Washing

The bright, solid flux residues will provoke also with nonferrous metals no corrosion. Therefore, they can remain on the soldering joint. On usage in the electronic production we recommend the removal of the flux residues with all current PCB'S cleaners on alkaline basis.

Storage

Store dry and dust-free as far as possible. Best before end of 24 months.

Advices for Handling

Please refer to the corresponding EG safety data sheet

Further Advices

We are delighted to produce all solder wires according to your company standard.

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