



Technical Data Sheet

1、Application

- 1.1 This Certificate only for our Company's specified product Leaded Product, and suitable for any constituent and wire diameter with same alloy.
- 1.2 This Product suitable for high requirement of environmental protection for Manual or automatic Soldering. This product make from Fresh Raw Materials and Professional allocate. It has a widely used in environment friendly Electronics Industry. Product Standard is: GB/T 20422-2006.

2、Product Information

- 2.1 Name: Solder Wire
- 2.2 Model: Sn63/Pb37 (RMA flux FC5005)
- 2.3 Chemistry Expression: Sn-37/40Pb
- 2.4 Product Shape: Filaments
- 2.5 Customer's Requirements

Diameter, mm	0.30 mm	0.60 mm	0.80 mm	1.00 mm	1.20 mm	1.60 mm	1.80 mm	2.00 mm
Requirement								
Flux, %	1.40%	1.60%	1.80%	2.00%	2.20%	2.60%	2.80%	3.00%
Requirement								
Flux Type	R Type	RMA Type	RA Type	No Clean	Water Soluble	Aluminum Soldering		
Requirement								

2.6 Diameter Allowed Deviation (mm)

Diameter, mm	≤0.3	0.3~0.8	>0.80~2.5	>2.5~6.0	
Allowed Deviation	±0.02	±0.03	±0.05	±0.1	

Special Size is available

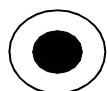
3、Chemical Component

Item	Chemical Component, %								
	Sn	Pb	Sb	Cu	Bi	Ag	Fe	Al	Cd
Sn-37Pb	All the Rest	37.00	< 0.10	< 0.050	< 0.10	< 0.10	< 0.02	< 0.001	< 0.010

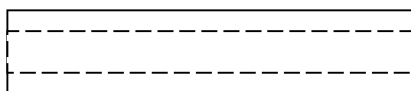
4、Raw Materials Standard

4.1 Product Out Look,,Long and round Shape with medium altitude, inside Flux

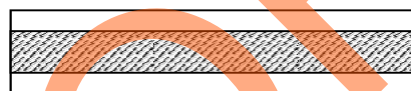
4.2 Structure Picture,,



Front View



Left View



Cross-section View

5、Materials Physical Characteristics and Testing Way.

5.1 Materials Characteristics

Specification	Melting Point(°C)	Proportion g/cm ³	Tensile Strength Mpa	Electrical Resistivity 10 ⁻⁹ ohm.m
Sn-37Pb	183-193	8.5	32	100~150

5.2 Our Company Lab using Germany Testing Machine(SPECTRO MAXx) to test the Alloy, here are the INFO.

Item	Chemical Component, %							
	Element	Sn	Ag	Cu	Al	As	Cd	Fe
Solder Wire Sn-37Pb	%	All the Rest	0.0025	0.05	<0.0001	<0.0025	<0.0002	0.0005
	Element	Pb	P	Bi	S	Sb	Zn	
	%	37.00	<0.0015	0.012	<0.0015	0.0068	<0.0002	

5.3 Flux Characteristics

Items	Standard	Testing Way
Dryness	Surface no adhesive force, Easy to clean out	JIS Z 3197-86
Copper Corrosion	No Corrosion	JIS Z 3197-86
Aqueous Resistance Ω·cm	> 10 ⁵ Ω·cm	JIS Z 3197-86
Surface Insulation Resistance	> 1.0×10 ⁸ Ω	JIS Z 3197-86
Rate of Spread, %	> 80%	JIS Z 3197-86

6、Packing Way

6.1 Roller Mark, White Special for Tin lead product

6.1.1 Front Mark,,Company Logo.

6.1.2 Back Mark,,None

6.2 Inside Package,, 6.2.1 Can Pack as customer's requirement

6.2.2 Front Mark Company logo

6.2.2 Each Roll will mark wire diameter and flux details.



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6.3 Out-side Package, Special Box, with mark customers' order item number.

6.3.1 Left Side, Sn-Pb40 (RA flux CF10)

6.3.2 Tight Standard Mark to show the Product Weight, Chemical Quantity, Chemical Component, Model, Raw Materials Serials, Production Serials, etc

6.4 Weight Constitute.

	kg/Roll						kg/box (Net Weight)						Deviation, g	
10 Roller	0.75	0.80	0.85	0.90	1.00		7.50	8.00	8.50	9.00	10.0		Each Roll	±30 g
													Each Box	±100 g

7、Preservation Way and Time

7.1 Preservation Condition,,Room TEMP. 25°C±2°C, relative humidity ≤50%RHo

7.2 Preservation Way,,Avoid to keep in floor directly.

7.3 Preservation Time,,Suggest to use within 180 after production.

7.4 Attention for Preservation,,Sealed container package, storage in dry place. Touch with acid medium or high humidity will make the Alloy lost the metal luster

7.5 Product Manage,,While heating need to avoid in draft metal steam. While Cutting and polishing, need to avoid in draft dust. Do not touch with Eye, Close and make sure the using place has good ventilation environment

8、Quality Insurance

8.1 Quality Insurance Procedures,,

Raw Materials testing→melt the Tin Component Testing 3→injection molding Testing Out-look Testing 3→oil pressure Checking→draw bench Checking→wire wrapping Checking→Package Checking →finished product Checking→Spot Checking

8.2 Customer Complaint Process Mode,,

Complaint→Seller→Quality Inspection Dep.→Solution→Seller→Customer

8.3 Quality Certificate,,

8.3.1 MSDS Report

8.3.2 TDS Declare

8.4 Quality Promise,,Seller and Buyer will signed contract

9、Regulation Documents

9.1 Our company declare that our product fit EU RoHS instructions and China's Environment protecting laws with lead free products only.

9.2 If product documents have changed, our company will inform our customer immediately.

10、 Product Characteristics and Security

10.1 Product Feature,,

10.1.1 Environment Product, non-pollution:Good fluidity, Solder Point Full, shiny and bright.

10.1.2 Fast Tin Soldering, Suitable for Complicated Printed Circuit Board.

10.1.3 Improve Production efficiency, lower production cost.

10.2 Security Solder Wire normally were used with Flux, it will make some smog. This smog should be pump out and suggest worker to wear protective tools

10.3 Residue Process: Whether to clean the Solder Point, it based on the Solder Flux using condition and suggest to use with cleaner

11 .Statements

In this document, except some data with allowed tolerance range, other data swill conform to Industry allowed tolerance range.