



Product information

FELDER-ISO-Core[®] "EL" – lead containing

Flux-cored, halide free activated soft solder wire,
Flux according to EN ISO 9454-1:2014, 1131 respectively DIN EN 61190-1-1, ROLO

Art.-Nr.: 20.....

Description

Low residue, halide free, no-clean solder wire, especially adapted to the requirements in the electronic production. The flux characterises itself by its high temperature constancy and does not spatter during the reflow soldering. The bright, solid flux residues are neither corrosive nor electrical conductive and may therefore remain on the soldering joint.

Standard solder alloys

Alloys	DIN EN ISO 9453	DIN EN 61190	Melting range	Articel- No.
Sn60Pb40	S-Sn60Pb40	Sn60Pb40	183 – 190°C	2060....
Sn60Pb38Cu2	S-Sn60Pb38Cu2	Sn60Pb38Cu02	183 – 190°C	2064....
Sn63Pb37	S-Sn63Pb37	Sn63Pb37	183 °C eutectic	2075....
Sn62Pb36Ag2	S-Sn62Pb36Ag2	Sn62Pb36Ag02	179 °C eutectic	2072....
Sn60Pb36Ag4	S-Sn60Pb36Ag4	-	171 – 179°C	2070....

Further lead-free alloys can be delivered on customer's request.

Properties

Flux type	:	No-Clean 1131, (ROLO, F-SW32)
Flux content	:	3,5 % standard
Flux distribution	:	1 – (standard), 3 – and 5 – cored
Halide content	:	halide free
Ø in mm	:	0,25, 0,35, 0,50, 0,75, 1,00, 1,50, 2,00, 3,00, 4,00
Spool sizes in kg	:	0,10, 0,25, 0,50, 1,00, 2,50, 5,00

Cleaning

The flux residues do not evoke corrosion at non-ferrous metals and show highest surface resistance values. Therefore, they may remain on the soldering joint. However, if cleaning is desired, it can be performed with any common cleaning agents.

Surface insulation resistance (SIR) according to IPC-TM-650

after 24 h*	:	5,8E+11 Ω
after 96 h*	:	1,8E+11 Ω
after 504 h*	:	9,8E+10 Ω
Reference sample (24 h*)	:	9,8E+11 Ω

*Storage of sample-pcb's at conditioned atmosphere 40°C/ 93% rel. humidity.
 Measuring voltage = 5V DC

Electrolytic corrosion

After storage for 504 hours (h) of tested PC-board from the SIR-test at testing climate 40°C/ 93% rel. humidity with 5V persistently set-up DC voltage.

after 504 h : no electrolytic-corrosion

Storage

Store dry and dust-free as far as possible. Use best before end of 60 months.

Advices for handling

Please refer to the corresponding MSDS (Material Safety Data Sheet).

Further advices

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