

Attn:

Customer Name:

# ULTRACORE

## PRODUCT SPECIFICATION

Of

Solder Wire 60/40 Sn/Pb 425

### 1. Product Description

Product Type: FLUX CORED SOLDER WIRE with B-TYPE

Alloy Type: 60/40 Sn/Pb Class A

Flux Type: B425

Product Code: Solder Wire 60/40 Sn/Pb B425

### 2. Specification of solder

| Compositions   | Specification, %wt |
|----------------|--------------------|
| Tin (Sn)       | 60 ± 0.5           |
| Lead (Pb)      | BALANCE            |
| Antimony (Sb)  | 0.20 max.          |
| Copper (Cu)    | 0.08 max.          |
| Bismuth (Bi)   | 0.10 max.          |
| Zinc (Zn)      | 0.001 max.         |
| Iron (Fe)      | 0.02 max.          |
| Aluminium (Al) | 0.001 max.         |
| Arsenic (As)   | 0.03 max.          |
| Silver (Ag)    | 0.10 max.          |
| Cadmium (Cd)   | 0.002 max.         |
| Nickel (Ni)    | 0.01 max.          |
| Gold (Au)      | 0.05 max.          |
| In (Indium)    | 0.10 max           |

Remark: 1. This standard refer to JIS Z 3282:2006

2. Some of specification value in this table may be changed depend on establishment of environmental or quality agreement such as RoHS, JIS standard etc.



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### 3. Physical Properties of Solder

|                                       |                          |
|---------------------------------------|--------------------------|
| Solidus Temperature, °C:              | Approx. 183              |
| Liquidus Temperature, °C:             | Approx. 190              |
| Specific gravity, g/cm <sup>3</sup> : | Approx. 8.5 (For solder) |

### 4. Specification of Core-Flux

| Item                    | Specification   | Testing Method   |
|-------------------------|---|------------------|
| 4.1 Flux Type           | B   | JIS Z 3283-1986. |
| 4.2 Flux Content, wt %  | 1.0-3.0   | JIS Z 3197       |
| 4.3 Halide content, wt% | Over 0.5 up to 1.0  | JIS Z 3197       |
| 4.4 Spread Factor       | More than 80  | JIS Z 3197       |
| 4.5 Dryness             | Test pieces shall be that powdered talc can be easily removed by brushing | JIS Z 3197       |
| 4.6 SIR, OHM            | 1 x 10 <sup>09</sup> min  | JIS Z 3197       |

### 5. Specification of Diameter and Standard Weight

| Outside diameter, mm | Tolerance, mm | Standard Weight, kg* |
|----------------------|---------------|----------------------|
| 0.3 to 0.4           | ±0.03         | 0.2, 0.5             |
| 0.5 to 0.7           | ±0.05         | 0.5,1.0, 2.5, 5 etc  |
| 0.8 to 3.0           | ±0.10         | 0.5,1.0, 2.5, 5 etc  |

Remark: \*This standard is ultracore's standard but this standard can change if customer request.

### 6. Storage Condition

Store the solder wire in a cool, dry environment. Wrap up the solder wire when not in use to reduce exposure to environment.

### 7. Health and Hazard Information

Wear a chemical mask if the operators are allergic to the fumes released during soldering.  
For more information, please refer to Material Safety Data Sheet.



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