

Attn:

Customer Name:

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PRODUCT SPECIFICATION

Of

Lead Free Solder Wire Sn-5.0Sb(U5203) A125

1. Product Description

Product Type: LEAD FREE FLUX CORE SOLDER WIRE

Alloy Type: Sn-5.0Sb Class A

Flux Type: A125

Product Code: Lead Free Solder Wire Sn-5.0Sb(U5203) A125

2. Specification of solder

Compositions	Specification, % wt
Tin (Sn)	BALANCE
Lead (Pb)	0.05 max.
Antimony (Sb)	5.0 $\pm$ 0.5
Copper (Cu)	0.05 max.
Bismuth (Bi)	0.10 max.
Zinc (Zn)	0.002 max.
Iron (Fe)	0.02 max.
Aluminium (Al)	0.002 max.
Arsenic (As)	0.03 max.
Silver (Ag)	-
Cadmium (Cd)	0.002 max.

Remark: 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. 235
Liquidus Temperature, °C:	Approx. 240
Specific gravity, g/cm ³ :	Approx. 7.3 (For solder)

4. Specification of Core-flux

Item	Specification	Testing Method
4.1 Flux Type	A	JIS Z 3283-2001
4.2 Flux Content, wt %	1.0-3.0	JIS Z 3197
4.3 Halide content, wt%	Over 0.1 up to and incl.0.5	JIS Z 3197
4.4 Spread Factor, %	80 min.	JIS Z 3197
4.5 Dryness	Test pieces shall be that powdered talc can be easily removed by brushing	JIS Z 3197
4.6 IR, OHM	1 x 10 ¹⁰ min	JIS Z 3197 (at 40 °C, 90%RH, 168 Hr)

5. Specification of Diameter and Standard Weight

Outside diameter, mm	Tolerance, mm	Standard Weight, kg*
0.3 to 0.4	±0.03	0.5
0.5 to 0.7	±0.05	0.5
0.8 to 3.0	±0.10	1.0, 2.5, 5.0 etc.

Remark: *This standard is ultracore 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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REVISION

Name of product : Lead Free Solder Wire Sn-5.0Sb(U5203) A125		Specification No. : SPSDW016/Rev.02	
Revision date	Revision point	Reason of revision	Remark
10-Nov-05	New issued	-	
24-May-06	1. Revision specification of core-flux	JIS Z 3283-1986 revised to JIS Z 3283-2001	
01/02/2007	Change format	-	



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