Electronic
Technical Data Sheet
BALVER ZINN SOLDER WIRE LF3237

Lead-free cored solder wire, water soluble, ORH1

General Information

BALVER ZINN SOLDER WIRE LF3237 is a high-activated water soluble flux formulation for special applications. **BALVER ZINN SOLDER WIRE LF3237** shows fast and excellent wetting properties also on difficult surfaces. Because of the high halide content of 1.2% **LF3237** performs very well on all available PCB finishes. The residues must be removed after soldering. **BALVER ZINN LF3237** is available in diameters from 0.2 to 3.5 and a standard flux content of 2.2%. Standard lead free alloys are **SN100C, SN97C and SN96C**. Lead containing and special alloys are available on request.

*__BALVER ZINN SOLDER WIRE LF3237__ does not contain hazardous substances beyond the limits prescribed by EU Directive 2011/65/EU ("RoHS II")

Further information is available in the **BALVER ZINN information „5 golden rules for hand soldering".** Technical information and Data Sheets can be found on our website (www.BALVERZINN.com). You can also obtain all information and documents directly from **BALVER ZINN**.

BALVER ZINN Production Programme

The **BALVER ZINN** production programme also includes solder bars, solder pastes and flux. In addition to the **SN100C** product family, **BALVER ZINN** offers additional unpatented and patented solder alloys for wave soldering, reflow and rework.

Product Properties

- Flux classified according to J-STD-004 as: **ORH1**
- Solder classified according to EN 61190-1-3 as: **ORH1**
- Metal classified according to EN 61190-1-3
- RoHS* compliant with lead-free alloys
- Easy removable residues with water
- Excellent soldering results

Physical and Chemical Properties of flux LF3237

Acid value: J-STD-004; IPC-TM-650, Method 2.3.13; 06/04 A	35.5mg KOH/g ± 5%
Copper mirror test: J-STD-004; IPC-TM-650, Method 2.3.32; 06/04 D	H
Silver chromate test: J-STD-004; IPC-TM-650, Method 2.3.33; 06/04 D	positive
Solid content, flux: J-STD-004; IPC-TM-650, Method 2.3.34; 06/04 C	n. d.
Bromide und Chloride Test: J-STD-004; IPC-TM-650, Method 2.3.35; 06/04 C	1.2% ± 0.2
Fluoride after spot test: J-STD-004; IPC-TM-650, Method 2.3.35.1; 06/04 A	passed
Insulation resistance: J-STD-004; IPC-TM-650, Method 2.6.3.3; 06/04 B	n. d.
Corrosion test: J-STD-004; IPC-TM-650, Method 2.6.15; 06/04 C	low

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Cleaning

The residues of **BALVER ZINN CORE WIRE LF3237** are conductive and may cause corrosion. The residues are easily and complete removable with water. Additives like neutralizers, saponifiers or detergent are not necessary to solubilise completely the flux residues. Softened water or deionized water is recommended for high reliability. Tests showed that PCB boards left up for 48 hours before cleaning, in a simulated production environment showed no visible corrosion by the flux residues.

Reels

Weight	0.25 / 0.4 kg	0.5 / 1.0 kg	0.4 / 0.8 kg
Marking	63/37	BZ	K80
Height	63 mm	80 mm	80 mm
Outside diameter	63 mm	76 mm	80 mm
Inside diameter	11 mm	30 mm	16 mm
Reels./carton)	10	10	10

Physical Properties of lead-free Alloys

LF3237 is available with the following, lead-free alloys:

Alloy	Composition	Melting point (°C)
SN100C	SnCu0.7Ni	227
SN96C	SnAg3.8Cu0.7	217
SN97C	SnAg3.0Cu0.5	217 – 218

Delivery Sizes

Parameter	Standard
Wire diameter (mm)	0.3 /0.5 / 0.8 / 1.0 / 1.5 / 2.0 / 2.5 / 3.0 / 3.5
Flux content (weight-%)	2.2

*Other diameters, flux contents and features available on request.

Storage Conditions / Durability

Dry at room temperature / minimum 2 years shelf life.

Safety Advice

Before use please refer to the appropriate Safety Data Sheet.

OUR GLOBAL DISTRIBUTION NETWORK

Balver Zinn Josef Jost GmbH & Co. KG
Balve; Germany
☎: +49 2375 915 0
✉: cia@balverzinn.com
✓: www.balverzinn.com

Cobar Europe BV
Breda; The Netherlands
☎: +31 76 544 55 66
✉: info@cobar.com
✓: www.cobar.com

Cobar Solder Products Inc.
Little River; USA
☎: +1 (843) 734 1491
✉: info.usa@cobar.com
✓: www.cobar.com