

## 94-SEL

Rev: 15.1

Date	2021.08.17
Language	English
SDS	950406



## Summary

94-SEL is a RELO classified, partially water based flux for selective soldering. It is based on synthetic resins and is suitable for high reliability applications.

Flux code	94-SEL
<b>PROCESS</b>	
No-Clean process	9
Post-solder cleaning	7

INDUSTRY APPLICATION	
Consumer electronics	6
Standard industrial electronics	9
Hi-Rel electronics (automotive)	9

PROCESS CAPABILITY	
Dip Soldering	8
Drag soldering	9
Dropjet fluxing	9
High Pre-heat compatible	9
High soldering temp compatible	9
Long contact time compatible	8
Reduces spreading of flux	8
Reduces solderballing	9
Reduces bridging	8
Improves TH filling	8
Brilliant joint appearance	9
Cosmetic Cleanliness	8
ICCT compatible	9
Conformal coating compatible	9

Legend	
<i>Especially made for this purpose</i>	9 - 10
<i>Generally qualified for this purpose</i>	7 - 8
<i>Generally usable, but not the best choice</i>	5 - 6
<i>Generally not usable for this purpose</i>	3 - 4
<i>Wrong choice</i>	1 - 2

CLASSIFICATION	
DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	RELO

PROPERTIES		
Density	@20°C [kg/dm³]	0.848
Acid number	[mg KOH/g]	13.9
Solid content	[% w/w]	2.6
Water content	[% w/w]	21
VOC content	[% w/w]	Remainder
Filmformer(s)		Resin
Color		Colorless
Odor		Mild alcoholic
Flashpoint COC	[°C]	16.5
Thinners		308-00

TEST REPORTS			
Certificate of Compliance			website
Application Note			english
Copper Mirror	IPC-TM-650 2.3.32		Pass
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		N/A
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		Pass

PACKAGING AND STORAGE		
Packaging bottle (HDPE) [liter]	(HDPE) [liter]	1
Packaging can (HDPE) [liter]	(HDPE) [liter]	5 / 10
Recommended shelf-life in Months		
Storage temperature	20-25 °C	9

Check material compatibility with every process change!

Industrial chemical product.

Read MSDS before use.

## Disclaimer:

The information given in this publication has been worked up to the best of the knowledge of Cobar as well as taking into consideration the applicable laws and regulations. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and buyers and users assume all responsibility and liability for loss or damage arising from the handling and use of our products, whether used alone or in combination with other products.