

SN97C-LF2220NC

Rev: 04.9

| | |
|----------|------------|
| Date | 2021.11.15 |
| Language | EN |
| SDS | 950202 |



SUMMARY

The RELO classified, halide-free, no-clean solder wire LF2220NC has been specially developed for lead-free repair and rework soldering.

| Solder Wire | SN97C-LF2220NC |
|----------------------|----------------|
| PROCESS | |
| No-Clean process | 9 |
| Post-solder cleaning | 8 |
| Water soluble | 1 |

| INDUSTRY APPLICATION | |
|---------------------------------|---|
| Standard electronics | 6 |
| Industrial electronics | 8 |
| Hi-Rel electronics (automotive) | 9 |

| PROCESS CAPABILITY | |
|------------------------|---|
| Manual soldering | 9 |
| Robot soldering | 9 |
| Laser soldering | 7 |
| Wetting properties | 9 |
| Wetting time | 9 |
| Solderball formation | 7 |
| Flux spattering | 7 |
| Smoke formation | 8 |
| Tip lifetime | 8 |
| Shiny joint appearance | 7 |
| Cosmetic cleanliness | 9 |
| ICCT compatible | 9 |
| Conformal coating | 7 |

| 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 |

Check material compatibility with every process change!

Industrial chemical product.

Read MSDS before use.

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CLASSIFICATION

| | |
|-------------------------|------|
| DIN-EN-ISO-9454-1: 2016 | 1222 |
| IPC-J-STD-004-A: 2004 | RELO |

PROPERTIES

| | | |
|-----------------------------|------------|-----------|
| Flux code | 2220 | |
| Alloy code | SN97C | |
| Alloy composition | SnAg3Cu0.5 | |
| Liquidus | [°C] | 217 |
| Solidus | [°C] | 220 |
| Recommended soldering temp. | [°C] | 320 - 370 |
| Acid number | [mg KOH/g] | 220 |
| Flux content | [% w/w] | 2.2 |
| Residues | Colorless | |

TEST REPORTS

| | | | |
|---------------------------|---------------------|--------------------|-----------|
| Certificate of Compliance | | | Website |
| RoHS Compliant | | | Available |
| Application Note | | | EN/DE |
| 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 | | Pass |
| SIR | IPC-TM-650 2.6.3.3 | | Pass |
| ECM | IPC-TM-650 2.6.14.1 | | Pass |

PACKAGING AND STORAGE

| Reels | | | |
|------------------------------|------------|-----------|-----------|
| Label | 63/37 | BZ | K80 |
| Weight [kg] | 0.25 / 0.4 | 0.5 / 1.0 | 0.4 / 0.8 |
| Height [mm] | 63 | 80 | 80 |
| External diameter [mm] | 63 | 76 | 80 |
| Internal diameter [mm] | 11 | 30 | 16 |
| Reels per carton | 10 | 10 | 10 |
| Standard wire diameter [mm] | | | 0.3 - 3.5 |
| Minimum shelf-life in months | 4-10 °C | | 60 |