

## Sn63Pb37-3135NC

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Language	EN
SDS	950203



## SUMMARY

The REM1 classified, halide-containing, no-clean 3135NC solder wire is suitable for all soldering tasks with lead-containing solders, if halide-containing activators are approved.

Solder Wire	Sn63Pb37-3135NC
<b>PROCESS</b>	
No-Clean process	9
Post-solder cleaning	8
Water soluble	1

INDUSTRY APPLICATION	
Standard electronics	9
Industrial electronics	9
Hi-Rel electronics (automotive)	7

PROCESS CAPABILITY	
Manual soldering	9
Robot soldering	9
Laser soldering	8
Wetting properties	9
Wetting time	9
Solderball formation	9
Flux spattering	9
Smoke formation	9
Tip lifetime	9
Shiny joint appearance	9
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.

Product contains SVHC substance Lead with more than 0,1 Mass%.

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## CLASSIFICATION

DIN-EN-ISO-9454-1: 2016	1223
IPC-J-STD-004-A: 2004	REM1

## PROPERTIES

Flux code	2220	
Alloy code	Sn63Pb37	
Alloy composition	Sn63Pb37	
Liquidus	[°C]	183
Solidus	[°C]	183
Recommended soldering temp.	[°C]	280 - 330
Acid number	[mg KOH/g]	220
Flux content	[% w/w]	2.2
Residues	Colorless	

## TEST REPORTS

Certificate of Compliance			Website
RoHS Compliant			No
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		M
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Fail
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		N/A

## 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