

## Sn63Pb37-3237

Rev: 06.3

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Language	EN
SDS	950208



## SUMMARY

The ORH1 classified, halide containing, washable solder wire LF3237 is suitable for all soldering applications with lead-containing solders where halide activators are permitted.

Solder Wire	Sn63Pb37-3237
<b>PROCESS</b>	
No-Clean process	1
Post-solder cleaning	10
Water soluble	10

INDUSTRY APPLICATION	
Standard electronics	6
Industrial electronics	7
Hi-Rel electronics (automotive)	10

PROCESS CAPABILITY	
Manual soldering	9
Robot soldering	4
Laser soldering	4
Wetting properties	10
Wetting time	9
Solderball formation	9
Flux spattering	8
Smoke formation	8
Tip lifetime	4
Shiny joint appearance	10
Cosmetic cleanliness	10
ICCT compatible	10
Conformal coating	10

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	2123
IPC-J-STD-004-A: 2004	ORH1

## PROPERTIES

Flux code	3237	
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	White powder	

## TEST REPORTS

Certificate of Compliance			Website
RoHS Compliant			Available
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		H
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		N/A
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