

SAC305-StarCore234-E

Rev: 19.10

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 Language English  
 SDS 950226



SUMMARY

The ROLO classified, no-clean solder wire StarCore234-E has been specially developed for lead-free repair and rework soldering.

Solder Wire	SAC305-StarCore234-E	
<b>PROCESS</b>		
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.

CLASSIFICATION	
DIN-EN-ISO-9454-1: 2016	1122
IPC-J-STD-004-A: 2004	ROLO

PROPERTIES		
Flux code	234-E	
Alloy code	SAC305	
Alloy composition	SnAg3Cu0.5	
Liquidus	[°C]	220
Solidus	[°C]	217
Recommended soldering temp.	[°C]	320 - 370
Acid number	[mg KOH/g]	195
Flux content	[% w/w]	2.2
Residues	Colorless	

TEST REPORTS			
Certificate of Compliance		Website	
Declaration of Conformity 2011/65/EU (RoHS)		Website	
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	K63	BZ
Weight [kg]	0.4	0.25 / 0.5 / 1.0
Height [mm]	63	80
External diameter [mm]	63	76
Internal diameter [mm]	11	30
Reels per carton	10	10
Standard wire diameter [mm]	∅	0.3 - 3.5
Minimum shelf-life in months	20-25 °C	60

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