



Sn63Pb37-3135

Rev: 08.2

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Release	08.2
Language	English
SDS	950218



SUMMARY

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

Solder Wire	Sn63Pb37-3135	
PROCESS		
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%.

Disclaimer:

This information is intended as advice to the best of our knowledge. The provided data is based on our own measurements, they do not provide any guaranteed properties nor are these delivery specifications. Due to the versatility of materials, applications and taking in consideration the industrial property rights of third parties, Balver Zinn GmbH cannot take any liability.

CLASSIFICATION

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

PROPERTIES

Flux code	3135	
Alloy code	Sn63Pb37	
Alloy composition	Sn63Pb37	
Liquidus	[°C]	183
Solidus	[°C]	183
Recommended soldering temp.	[°C]	280 - 330
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)			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	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