

**Product** 94-SEL  
**Date** 2018.07.04  
**Release** 15.1  
**Language** English

## General Selective soldering flux

### Summary

General SEL flux, high reliability, automotive qualifications

FLUX CODE	94-SEL
<b>PROCESS</b>	
No-Clean process	5
Post-solder cleaning	3
<b>INDUSTRY APPLICATION</b>	
Consumer electronics	3
Standard industrial electronics	5
Hi-Rel electronics (automotive)	5
<b>PROCESS CAPABILITY</b>	
Dip Soldering	4
Drag soldering	5
Dropjet fluxing	5
High Pre-heat compatible	5
High soldering temp compatible	5
Long contact time compatible	4
Reduces spreading of flux	4
Reduces solderballing	4
Reduces bridging	4
Improves TH filling	4
Brilliant joint appearance	5
Cosmetic Cleanliness	4
ICCT compatible	5
Conformal coating compatible	5

CLASSIFICATION	
DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	RELO

PROPERTIES			
Density		@20°C [kg/dm³]	0.848
Acid number	IPC-TM-650 2.3.13	[mg KOH/g]	13.9
Solid content	IPC-TM-650 2.3.34	[% w/w]	2.6
Water content		[% w/w]	21
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			Mild alcoholic
Thinners			308-00

TEST REPORTS			
Certificate of Compliance			website
Application Note			english
Copper Mirror	IPC-TM-650 2.3.32		L
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	N/A
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		N/A
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		Pass

PACKAGING AND STORAGE		
Packaging bottle (HDPE) [liter]	(HDPE) [liter]	1
Packaging can (HDPE) [liter]	(HDPE) [liter]	5 / 10
<b>Shelf-life in months</b>		
Storage temperature	20-25 °C	9

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

Legend	
<i>Epecially made for this purpose</i>	5
<i>Generally qualified for this purpose</i>	4
<i>Generally usable, but not the best choice</i>	3
<i>Generally not usable for this purpose</i>	2
<i>Wrong choice</i>	1

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