

SAC0307-1215W

Lead-free Solder Wire

SAC0307-1215W solder wire is mainly made of high-purity tin, refined by using the most advanced professional equipment of lead-free solder and excellent technology through special process. Flux is synthesis of antioxidants and surfactant by high-temperature. It can effectively reduce the production of tin slag and reduce the lack of molten tin due to the tin slag. It is specialized to use with intelligent automatic solder machine in the lead-free process. It is an environmentally friendly lead - free solder wire with excellent welding performance.

FEATURE

- The packaged solder wire is flat, smooth, uniform.
- Comply with RoHS requirement.
- Low rate of tin slag, high anti-oxidation.

APPLICATION

SAC0307-1215W welding wire is specially matched with the automatic tin adding machine.

TYPICAL PROPERTIES

Items	Technical	Standards
Part number	SAC0307-1215W	/
Metal Alloy	Sn98.70/Ag0.3/Cu0.7	/
Appearance	Silvery white, smooth and clean surface. No crack	Visual Inspection
Diameter (mm)	3.0±0.2	GB/T 20422-2006 5.5
Flux (wt %)	0.3±0.1	IPC-TM-650 2.3.34.1
Shelf Life	2 years	From the MGF Date
Packaging	15kg/ Reel	

ALLOY COMPOSITION

No.	Items	CAS. No.	Content(%)
Key Metal Alloy			
1	Tin (Sn)	7440-31-5	98.7±0.5
2	Silver(Ag)	7440-22-4	0.3±0.1
3	Copper (Cu)	7440-50-8	0.7±0.1

Impurity Limit

4	Lead(Pb)	7439-92-1	≤0.10
5	Iron (Fe)	7439-89-6	≤0.02
6	Bismuth(Bi)	7440-69-9	≤0.10
7	Stibium (Sb)	7440-36-0	≤0.10
8	Indium (In)	7704-74-6	≤0.10
9	Zincum (In)	7440-66-6	≤0.001
10	Aurum (Au)	7440-57-5	≤0.05
11	Nickel (Ni)	7440-02-0	≤0.01
12	Aluminum (Al)	7429-90-5	≤0.001
13	Cadmium (Cd)	7440-43-9	≤0.002
14	Arsenic (As)	7740-38-2	≤0.03

DIRECTION OF USE

- Select ferrochrome head with appropriate aperture according to actual welding needs.
- The recommended set temperature of ferrochrome head is $350 \pm 20^{\circ}\text{C}$, in order to reduce the occurrence of splashing tin phenomenon.
- It is recommended to clean ferrochrome head after using for some time during welding, because a large number of tin oxide and flux residues in ferrochrome head surface attachments are easy to have adverse effects on the welding.
- It is recommended to weld at nitrogen atmosphere under conditions permitting, in order to inhibit the oxidation of base metal and solder wire and improve the welding results.
- Personal protective equipment must meet the working range safety norms; wear protective clothing and mask, so as not to scald by splashing liquated solder.
- Please refer to product MSDS for more safety information

The data contained in this bulletin is provided only as a guide for evaluation/consideration. These material characteristics are typical properties that are based on a limited number of samples tested in the laboratory. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any product or method. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide.