GLUDITEC
Glue & Dispensing Technology

Technical Data Sheet

SnCu07-1216HF

Halogen-free Lead-free Solder Wire

SnCu07-1216HF halogen-free lead-free solder wire is made of high-quality and high-purity tin ingots as the main raw material, supplemented by high-quality and high-purity copper. It adopts the latest it is refined with the latest professional lead-free solder equipment and excellent technology through special processes. This lead-free tin wire flux is made of high-quality modified resin, Formulated with organic activators and various additives, it is an environmentally friendly lead-free alloy solder wire with superior welding performance in the lead-free process.

FEATURES

- The coiled wire is neat, smooth, smooth, evenly wound, and will not get tangled during routing.
- The flux within the line is evenly distributed, has good continuity, and has no core breakage.
- It has excellent electrical conductivity and thermal conductivity, fast tin application and strong wetting power.
- There is no irritating smell, less smoke and little splash during welding.
- There is less residue after welding, it spreads evenly and dries quickly.
- After welding, the surface insulation resistance is high and the electrical performance is stable and reliable.
- It is a green and environmentally friendly product that complies with RoHS and other environmental protection requirements.

APPLICATION

- SnCu07-1216HF halogen-free lead-free solder wire is widely used in communication equipment, instrumentation equipment, audio and video multimedia equipment, automotive industry
- Mounting and repair operations of industrial equipment, household electronic and electrical equipment and components, and manual welding and automatic welding of other high-reliability electronic products
- Mechanical welding.

PHYSICAL PROPERTIES

Items	Technical prameters	Standards
Product number	SnCu07-1216HF	/
alloy composition	Sn99.3Cu0.7	/
Exterior	Silver white, smooth and clean surface, no cracks	Visual
Diameter (mm)	0.15;0.2;0.3;0.4 ;0.5;0.6;0.8;1.0; 1.2;1.5;2.0;3.0	Corporate standards
shelf life	2 years	From the date of production
Packing	1kg/roll, 0.5kg/roll, 10kg/box	/

TECHNICAL SPECIFICATIONS

Items	skills requirement	Standards
Density (g/cm^3)	7.31	/
Flux content (wt%)	2.0±0.5 2.5±0.5 3.0±0.5	IPC-TM-650 2.3.31
Melting point(℃)	227	/
Copper mirror corrosiveness	No penetrating corrosion	IPC-TM-650 2.3.32
RoHS	qualified	RoHS Directive
Flux distribution network continuity, discontinuity	Uniform and continuous, no gaps	/
Copper plate corrosiveness	No obvious corrosion	IPC-TM-650 2.6.15
Halogen content	L0	IPC-TM-650 2.3.33
Expansion rate (%)	≥75%	JIS-Z-3197 8.3.1.1
Residue dryness	The surface of the flux residue should be free of stickiness sex, chalky on the surface should be easily removed	IPC-TM-650 2.4.47

ALLOY COMPOSITION

No.	Items	CAS No.	Content (%)
Main alloy composition and content			
1	Tin (Sn)	7440-31-5	Surplus quantity
2	Copper (Cu)	7440-50-8	0.7±0.1
Impurity composition and content			
3	Silver (Ag)	7440-22-4	≤0.10
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	Antimony (Sb)	7440-36-0	≤0.10
8	Indium(In)	7440-74-6	≤0.10
9	Zinc (Zn)	7440-66-6	≤0.001
10	Gold (Au)	7440-57-5	≤0.05
11	Aluminum (Al)	7429-90-5	≤0.001
12	Cadmium (Cd)	7440-43-9	≤0.002
13	Arsenic (As)	7440-38-2	≤0.03

DIRECTION OF USE

- Based on actual welding needs, select a ferrochrome head suitable for large and small apertures.
- It is recommended that the temperature of the soldering iron tip be set at 380±20℃, so that the temperature reaches the optimal melting state of the tin wire and reduces the occurrence of tin splashing.
- During the welding process, since the surface attachment of the soldering iron tip contains a large amount of tin oxide and flux residue, it is easy to cause undesirable effects on the welding.
- It is recommended to clean the soldering iron tip after using it for a period of time.
- By keeping the welding atmosphere in a low-oxygen state, it can inhibit the oxidation of the base metal and tin wire, thereby improving the quality of tin welding. It is recommended that
- Use nitrogen working atmosphere for welding when conditions permit.
- Personal protective equipment must meet work area safety regulations, and protective clothing and shields must be worn to protect against welding in the form of splashing solutions.
- Materials may cause burns. For more safety protection information, see the MSDS of this product.