GLUDITEC
Glue & Dispensing Technology

Technical Data Sheet

SnCu07-1216T

Tin Solder Wire

The SnCu07-1216T solder wire is crafted from premium tin ingots, ensuring top-notch quality and purity. Utilizing cutting-edge lead-free soldering equipment and expert technical knowledge, this wire boasts a high-temperature synthetic flux containing antioxidants and activators. This unique composition minimizes tin slag formation and prevents non-melting tin issues when paired with intelligent automatic tin adding machines during lead-free processes. With outstanding soldering capabilities, this environmentally conscious welding wire sets a new standard in performance.

FEATURE

- The coiled wire is neat, smooth, evenly wound, and will not get tangled during routing;
- Green and environmentally friendly products, complying with RoHS and other environmental protection requirements;
- Low tin slag rate and high oxidation resistance.

APPLICATION

- SnCu07-1216T welding wire is specially used with automatic tin adding machines

PHYSICAL PROPERTIES

Items	Technical parameters	Standards
Product number	SnCu07-1216T	/
Alloy composition	Sn99.0Cu0.7	/
Exterior	Silver white, smooth and clean surface, no cracks	Visual
Diameter (mm)	3.00±0.20	GB/T 20422-2006 5.5
Flux (wt%)	0.3±0.1	IPC-TM-650 2.3.34.1
Melting point (℃)	227	/
shelf life	2 years	From the date of production
Packing	15kg/roll	/

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	7440-74-6	≤0.10
9	Zinc (Zn)	7440-66-6	≤0.001
10	Gold (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)	7440-38-2	≤0.03

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DIRECTION OF USE

- The recommended set temperature of ferrochrome head is 265±5℃, in order to reach the best to molten state temperature of welding wire.
- When adding tin, pay attention to set up the tin machine and tin temperature of the furnace and the liquid level in the furnace to avoid the overflow of tin.
- Regularly to cleaning tin slag in the furnace, tin slag is likely to add interferences with the temperature controller and fluid control probe of tin machine. Wire contains special antioxidant and surfactant; a long time under the environment of high temperature may form carbides in the surface of tin stove. The carbide is helpful to protect the tin surface from oxidation.
- Make welding atmosphere in hypoxic condition, inhibit the oxidation of parent metal and wire will improve welding quality. Recommended in conditions allow the use of nitrogen gas welding work atmosphere.
- 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