



Water Soluble Cored Wire Solder Product Bulletin

High Purity Wire Solder

Metallic Resources high purity Water Soluble organic acid Sn63 Cored Wire Solder is manufactured with a void-free flux core, and employs a halide activated system neutralized with an amine. Standard flux percentage is 2% by weight (1% and 3% flux percentages are available upon special request). Standard packaging is on one pound spools, packed 12 spools per case, in .020", .032", and .062" thickness. Other diameters and spool sizes are available upon special order.

Solid wire solder is also available in .125" diameter in 300 pound payoff packages upon special order.

A Wide Range of Uses

Water Soluble Cored Wire Solder is ideally suited for a wide range of manual soldering of electronic assemblies and repair work where water cleaning is allowed.

Reduces Cleaning Costs

The aminehydrohalide provides a high activation level that is less corrosive than acid based fluxes to produce excellent tarnish and oxide removal; it will produce bright, shiny solder joints. Maximum capillary action leads to faster wetting to attain higher soldering speeds for greater efficiency, and reduces the



chance of thermal degradation of board materials. The post-process flux residue is readily soluble in hot water to drastically reduce cleaning costs. Since Water Soluble Cored Wire Solder has no noticeable odor, operators prefer it over other types of solders.

Engineered for Ease of Use

Solder iron tip temperatures should be in a range of 650° F to 850° F for best results. The solder iron should be held at a 45° to 60° angle to the work surface. The iron should contact both the PCB pad surface and the component lead. The solder and flux should flow onto both the lead and pad (or barrel) to achieve the best flux activity for the joint being worked.

Post process residues should be removed within two to three hours after application. Adequate cleaning may be accomplished by simply using normal hot tap water within a temperature range of 100° F to 150° F.



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De-ionized water is recommended for the final rinse. An inline or other pressurized spray cleaning system is recommended, but is not required.

The product shelf life is indefinite when stored in a clean, dry area (72° F ± 10° F) away from moisture and sunlight. Do not allow this product to freeze.

Standards Met

Metallic Resources' water soluble cored wire solder meets MIL SPEC and IPC post-cleaning requirements. The Flux classification to J-STD-004 is ORH1.

Superior Quality

Metallic Resources unique solders outshine all others to provide greater cost effectiveness, higher finished goods quality, and superior production line performance.



Recommendations made by this company and its representatives are based upon test data, experiments, and experience believed to be reliable. No guarantee of accuracy is made, however. All products are sold upon the condition that the buyer will make his own tests and assume the responsibility for the suitability of the product under his application and service conditions. Statements made herein will vary according to the nature of the surfaces to which the product is applied, application technique, and service condition. We in no event assume liability beyond the purchase price of our products involved and make as a condition of sale that we will refund the purchase price or replace materials proven to be defective and reported in a timely fashion, but no later than six (6) months after shipment. No representative of the manufacturer and/or seller has the authority to alter or extend these conditions.