



# RA Cored Wire Solder Product Bulletin

## High Purity Wire Solder

Metallic Resources' high purity fully activated Sn63 RA (rosin activated) Cored Wire Solder is an excellent general purpose solder exhibiting a void-free flux core. Standard flux percentage is 3% by weight (1% and 2% flux percentages are available through special order). Standard packaging is on one pound spools, packed 12 spools per case, in .020", .032", and .062" thickness. Other spool sizes are available upon special order.

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



active at soldering temperatures for excellent wetting properties which results in superior flow. The wire solder is glycol-free, and exhibits good thermal transfer. Copper oxide is easily dissolved when the solder is molten. It is solvent soluble and exhibits low fuming and smoke characteristics.

## The Choice for Touch-Up

RA Cored Wire Solder is primarily used for manual soldering and touch up of electronic assemblies and in applications where mildly activated fluxes are too weak. The product will often leave slight to moderate residue that may be left on non-critical applications, but must be removed for critical applications. Payoff packages (300 lb. per pack) are for charging wave solder machines with automatic wire feeders.

## 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.

## Highly Active/Excellent Wetting

RA Cored Wire Solder's flux is strong enough for excellent tarnish and oxide removal; it will produce bright, shiny solder joints. RA Cored Wire Solder stays highly

Post process cleaning is recommended, and cleaning should take place within two hours of application. Adequate cleaning may be accomplished by simply using a saponifier in a dip or in-line cleaning application. A



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temperature range of 100° F to 150° F will be sufficient to remove any residue. 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 (50° F to 80° F) away from moisture and sunlight.

## Standards Met

Metallic Resources RA Cored Wire Solder meets QQS-571-E specification requirements, IPC Standards J-STD-004 and J-STD-006, and MIL-SPEC cleanliness requirements post-cleaning. The Flux classification to J-STD-004 is ROL1.

## 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.