



RMA Cored Wire Solder Product Bulletin

High Purity Wire Solder

Metallic Resources' high purity Sn63 RMA (rosin mildly activated) Cored Wire Solder is manufactured with a void-free flux core. It is a very good general purpose solder. 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 upon special order.



properties to facilitate better 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

RMA Cored Wire Solder is primarily used for manual soldering and touch up of electronic assemblies and in applications not exhibiting heavily tarnished or oxidized work. 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.

Removes Tarnish and Oxide

RMA Cored Wire Solder is strong enough for light tarnish and oxide removal; it will produce bright, shiny solder joints. RMA Cored Wire Solder stays active at soldering temperatures, which produces good wetting

Post process cleaning is recommended. 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 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.



METALLIC RESOURCES, INC.

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 RMA Cored Wire Solder meets QQS-571-E specification requirements, IPC Standards J-STD-004 and J-STD-006, and MIL SPEC cleanliness requirements without 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.