



## Technical Bulletin

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### TSC Lead-Free Flux Cored Electrical Wire

#### DESCRIPTION

TSC Leaded Flux Cored Electrical Wire is specifically designed for working on electronic printed circuit boards, which need to be fully compliant with legislation, regarding the control of lead.

These flux cored solder wires show excellent solderability and capillary performance, requiring no additional flux whilst offering bright shiny solder joints and light post solder residues. The wire has a pleasant odour and gives off little fumes.

This latest no clean flux technology is safe to leave on your circuit board as it meets the very latest IPC electronic soldering specifications. Please do not hesitate to contact one of our technical team should you need to discuss any specific application you may have.

This wire is supplied on 50g reels as standard but may be available in larger quantities on request.

#### FEATURES AND BENEFITS

- Fast Wetting
- Minimal/Clear Residue
- Extends Solder Tip Life
- ROL0 per IPC J-STD-004
- REACH and RoHS Compliant\*
- Low Odor / Fumes
- Halogen Free per EN14582
- Ideal for hand Soldering Applications

\*Lead-Free Alloys

#### APPLICATION

It is important to match the geometry of the solder tip to the size of lead or component pad you are working on. As a guide line for lead free solders a tip temperature of between 370° - 425°C is ideally suited.

#### HANDLING & STORAGE

All cored solder wires should be stored in clean dry areas away from moisture and direct sunlight. Do not freeze.

**Shelf life:**

7 years	< 85°F (< 29°C)
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#### CLEANING

TSC Leaded Flux Cored Electrical Wire is a no clean solder wire and therefore residues do not need to be removed. If cleaning is required, This wire can be cleaned with commercially available flux removers. IPA is not recommended. For further advice on your application contact one of our Sales Offices.



# SOLDER CONNECTION

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## SAFETY

Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

## TECHNICAL DATA

	Specifications	Test Method
<b>Flux Classification</b>	ROLO ROL1	JSTD-004 JSTD-004B 3.3.1
<b>Copper Mirror</b>	Low	J-STD-004B 3.4.1
<b>Corrosion</b>	Pass	IPC-TM-650 2.3.32 J-STD-004B 3.4.1
<b>Quantitative Halides</b>	0.09% (Typical)	IPC-TM-650 2.6.15 J-STD-004B 3.4.1 IPC-TM-650 2.3.28.1
<b>Qualitative Halides:</b>		
Silver Chromate:	Pass	J-STD-004B 3.5.1 IPC-TM-650 2.3.33
Fluoride Spot:	No Fluoride	J-STD-004B 3.5.1 IPC-TM-650 2.3.35.1
<b>SIR</b>	Pass	J-STD-004B 3.4.1 IPC-TM-650 2.6.3.7

## AVAILABILITY

Alloy Designation	Melting or Solidus / Liquidus Temp °C	Flux Amount
SAC 0307	217 / 228	P2

Supplied on 50G Reels. Standard Diameters are 0.8mm & 1.2mm. Other sizes may be available on request.

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