

## Technical Bulletin

Issue 1 - 20/07/23

### TSC Acid Core Solder Wire

#### DESCRIPTION

TSC Acid Core Solder Wire is designed for metal fabrication applications across a wide range of ferrous and nonferrous materials including as brass, bronze & copper. TSC Acid Core is an efficient and highly active flux cored solder wire. The high activation level readily removes tarnish and oxide, promoting excellent solderability and superior capillary action across many applications.

#### FEATURES AND BENEFITS

- Superior Flux Activity.
- Suitable for a wide range of ferrous and nonferrous metals.
- Post solder residues are fully soluble in hot water.
- Leaded and lead-free alloys available.
- Low fume odour during soldering
- Excellent solderability and capillary action.
- Excellent high temperature thermal stability.

#### APPLICATION

TSC Acid Core Solder Wire offers excellent thermal stability at prolonged temperatures during a range of heating methods including flame and torch methods. is designed for metal fabrication applications across a wide range of ferrous and nonferrous materials such as brass, bronze, copper, mild and galvanised steels, iron, lead, zinc plating , nickel plated finishes tin plate and most stainless steels (using 96S).

This fluxed solder wire is not suitable for aluminium applications, nor should it be used on printed circuit boards.

#### HANDLING & STORAGE

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

**Shelf life:**

3 years

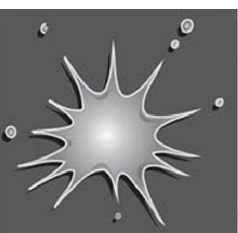
< 85°F (< 29°C)

#### CLEANING

TSC Acid Core Solder Wire's post soldering residue must be removed. For residue removal we recommend using hot water, ideally de-ionised if available. In most cases you will not need any additional surfactant chemistry, but care should be taken at elevated soldering temperatures to avoid excessive temperature and prolonged exposure as carbonisation of the residues may take place

#### 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.



# SOLDER CONNECTION

UK: +44(0)1291 624 400

solderconnection.com

Ire: +353 (1) 842 1172

## TECHNICAL DATA

Specifications	
<b>IPC Flux Classification</b>	INH1
<b>Flux Content</b>	6%
<b>Flux Type Residues</b>	Water Soluble
<b>Working Temperature</b>	350-400°C

## AVAILABILITY

Alloy Designation	Melting or Solidus / Liquidus Temp °C
Leaded - Sn60 Pb40	183 / 189
Lead-Free - Sn96 Ag4	221

Supplied on 500g Reels.

Standard Diameters in Leaded Alloy: 0.7mm, 1.2mm & 1.6mm

Standard Diameters in Lead-Free Alloy: 0.5mm, 1.6mm & 3.2mm

Other Alloys and Diameters may be available on request

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