

# Technical Bulletin

## TSC Leaded Flux Cored Electrical Solder Wire

### DESCRIPTION

TSC Leaded Flux Cored Electrical Solder Wires are ideal for general hand soldering operations. TSC Electrical Solder Wire will work well for all electrical wiring applications, together with some more mechanical assembly work, typically when soldering to clean copper and brass sheet details such as found in most of the engineering models today.

Following soldering, post solder flux residues around the joint will be fairly light and can be safely left on any electrical connection, due to excellent insulative properties of the flux. If removal is required for cosmetic appearances, a range of materials both solvent and aqueous based. Please feel free to contact our technical department where one of the team would be pleased to offer advice regarding a suitable product to suit your application.

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

### FEATURES & BENEFITS

- Very fast wetting → Low Cycle times for component touch-up and manual assembly
- Good spread characteristics → Excellent Solder Joints
- Pleasant pine smell → Operator Friendly
- Clear and safe residue → No-Clean Residues, Useful for all Applications
- Provides good joint appearance → Makes Inspection easy
- ROL1 per IPC J-STD-004-A

### 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)
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### 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. For leaded alloys a temperature of 300° - 400°C is recommended.

### AVAILABILITY

Alloy Designation	Melting or Solidus/ Liquidus Temp °C	Flux Amount
Leaded – 60/40	183 - 238	2.5%

Supplied on 50G Reels. Standard Diameters are 0.75mm & 1.25mm. Other sizes may be available on request.

### CLEANING

TSC Leaded Flux Cored Electrical Solder Wire is a no clean solder wire and therefore residues do not need to be removed. If cleaning is required or for advice on your application contact one of our Sales Offices.

[solderconnection.com](http://solderconnection.com)

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## TECHNICAL DATA

	<b>Specifications</b>
<b>Rosin Grade</b>	WW per Fed Spec. LL-R-626
<b>Rosin Softening Point</b>	71°C (160°F)
<b>Acid Value</b>	170 - 190 mg KOH/g flux (IPC-TM-650-2.3.13)
<b>Halide Content</b>	0.35 - 0.45% weight (IPC-TM-650-2.3.28.1)
<b>Copper Mirror</b>	<50% breakthrough per IPC J-STD-004A
<b>Classification</b>	ROL1
<b>SIR</b>	PASS

## HEALTH & SAFETY

Observe standard precautions for handling and using the solder wire. TSC Leaded Flux Cored Electrical Solder Wire is not considered toxic, however soldering will produce fumes during operation therefore it would be good practice to adequately exhaust / vent the fumes away from the operator.

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.

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