

**1 GENERAL CHARACTERISTICS**

This binary soldering alloy is produced from virgin tin and conforms to standard: EN29453:1994 Alloy 23.

**2 CHEMICAL CHARACTERISTICS**

2.1 Sn99.3 / Cu0.7

2.2 Tin from virgin stock minimum purity. 99.93%.

2.3 Chart of typical impurities:

Pb	Cd	Sb	Bi	Fe	Zn	Al	As	Others
0.05	0.001%	0.02%	0.01%	0.01%	<0.001%	<0.001%	<0.01%	0.05%

2.4 Incorporated: **Colophony Free, Halide Free Flux: S45V** conforming to HSE Laboratory specification.

2.5 Amount of flux incorporated: BS441 Grades 1, 2 or 3  
Grade 1 is standard unless stated on spool label.

BS441 Flux Grade	----- Mass of flux -----		
	Minimum	Nominal	Maximum
1	1.0 %	1.3 %	1.5 %
2	1.7 %	2.0 %	2.6 %
3	2.7 %	3.0 %	3.4 %

**3 PHYSICAL CHARACTERISTICS :****\*ALLOY**

3.1 Sn99.3Cu0.7 - Eutectic 227 C

3.2 Wire dimensions: Diameters from 0.5 mm to 3 mm

3.3 Soldering iron temperature: 370 to 420 °C

**\*FLUX S45V**

Synthetic resin base

Halide: 0 %

Acidity index: 220

Non corrosive

Solderability: Good on copper substrates and excellent onto surfaces of tin and lead.

Complies with copper mirror test

Low spattering

**4 PACKAGING :**

4.1 Supplied on Din Reels :250g, 500g, 1kg, 3kgs, 20kgs.

4.2 Packed in cartons of :10 - 20 x 250g. 20 x 500g and others.

4.3 Boxes and spools carry product information labels.

4.4 Quality assurance: Certificates of Conformity can be issued for each shipment batch if requested at the time of ordering.

4.5 Shelf life 12 months at 20°C.