



SOLDER WIRE HF32

Designed for use in electronics application

PRODUCT DESCRIPTION

Solder wire HF32 has been developed to meet industries increasingly stringent quality requirements. It is a flux cored solder wire. The activated, halide-free flux according J-STD-004 type ROL0 standard. The flux residues are solid and dry, and are not corrosive when tested in accordance with DIN 8516.

APPLICATION

HF32 can be used for hand-soldering and automatic wire feed operations. For manual soldering, the soldering iron tips should be temperature-controlled, to prevent excessive heat from being applied to the wire. Flux spatter from the formulation is fairly low. Solder wire HF32 meets the requirements of DIN 8516, with respect to surface insulation resistance and electromigration. The flux residues are not corrosive to non-ferrous metals.

PHYSICAL PROPERTIES AND DATA

GENERAL PROPERTIES	SOLDER WIRE HF32	
Flux type:	ROL0 / J-STD-004B	
Flux content:	standard 3.5 weight % $\pm$ 0.3 %	
Halide content:	None / J-STD-004B	
Corrosion effect:	None / J-STD-004B	
ECM	65°C @ 88,5%rH, 25d	$>10^{09} \Omega$
Surface Insulation Resistance:	40°C @ 90%rH, 7d	$>10^{10} \Omega$
Standard alloys acc. to ISO 9453:2014	Lead-containing:	Lead-free (Ecoloy Serie)
	S-Sn60Pb40	Ecoloy TC (S-Sn99.3Cu0.7)
	S-Sn60Pb39Cu1	Ecoloy TSC (S-Sn95.5Ag3.8Cu0.7)
	S-Sn62Pb36Ag2	Ecoloy TSC305 (S-Sn96.5Ag3.0Cu0.5)
Available diameters:	from 0.3 mm	
Available reel size:	250 g, 500 g, 1 kg	

Other alloys, diameters flux contents or reel sizes are available on request.

CLEANING

If cleaning is required for optical or technical reasons, the residues can be removed using conventional cleaning processes. The Stannol cleaner Flux-Ex Post is recommended for cleaning.

HEALTH AND SAFETY

Before using please read the material safety data sheet carefully and observe the safety precautions described.

DISCLAIMER

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.