

## FELDER-ISO-*Core*<sup>®</sup> "EL" – LEAD-CONTAINING

Flux-filled, halide-free activated soft solder wire,  
flux according DIN EN 29454.1, 1.1.3.B  
respectively DIN EN 61190-1-3, ROL0

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Art.-Nr.: 20.....

### Description

Low residue, halide-free No-clean-solder wire. Especially adapted to the requirements in the electronic production. The flux characterises itself by its high temperature constancy and does not spatter during the reflow soldering. The bright, solid flux residues are neither corrosive nor electrical conductive and may therefore remain on the soldering joint.

### Standard – solder alloys

Alloy	DIN EN 29453	DIN EN 61190	Melting range	Article-no.
Sn60Pb40	S-Sn60Pb40	Sn60Pb40	183 – 190°C	2060....
Sn60Pb38Cu2	S-Sn60Pb38Cu2	Sn60Pb38Cu02	183 – 190°C	2064....
Sn63Pb37	S-Sn63Pb37	Sn63Pb37	183 °C eutectic	2075....
Sn62Pb36Ag2	S-Sn62Pb36Ag2	Sn62Pb36Ag02	179 °C eutectic	2072....
Sn60Pb36Ag4	S-Sn60Pb36Ag4	-	171 – 179°C	2070....

Further lead-free alloys can be delivered on customer's request.

### Properties

Flux type	:	No-Clean 1.1.3.B, (ROL0, F-SW32)
Flux content	:	3,0 % standard
Flux spreading	:	1 – (standard), 3 – und 5 – cored
Halide content	:	halide-free
Ø in mm	:	0,25, 0,35, 0,50, 0,75, 1,00, 1,50, 2,00, 3,00, 4,00
Spool sizes in kg	:	0,10, 0,25, 0,50, 1,00, 2,50, 5,00

### Washing

The flux residues do not evoke corrosion at non-ferrous metals and show highest surface resistance values. Therefore, they may remain on the soldering joint.

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### **Insulation resistance test (SIR) according IPC-TM-650**

after 24 h*	:	5,8E+11
after 96 h*	:	1,8E+11
after 504 h*	:	9,8E+10
reference test (24 h*)	:	9,8E+11

\*Storage of the test PCB in conditioned atmosphere 40°C/ 93% rel. humidity.  
Meter voltage = 5V DC

### **Electrolytic corrosion effect**

After a storage of 504 hours (h) of the test PCB from the SIR-Test in conditioned atmosphere 40°C/ 93% r.F. with 5V constantly applied direct-current voltage (DC)

after 504 h : no E-corrosion

### **Storage**

Store dry and dust-free as far as possible. Best before end of 24 months.

### **Advices for Handling**

Please refer to the corresponding EU-safety data sheet.

### **Further Advices**

We are delighted to produce all solder wires according to your company standard.

All information about our products are the result of our long standing experience, which we would like to pass on to our customers. Since we do not have any influence on the application with our products, please see the warranty claims in our conditions of sale because our liability is limited.