

# Product Information

## **FELDER- ISO-Tin<sup>®</sup> – Sn96.2Ag3.8 (SN96Ce)**

Lead-free solder refill for dip-soldering and wave soldering units according to DIN EN ISO 9453:2014

Art.-No.: 1289004..

Art.-No.: 1289004.1PF (phosphorus-free material for selective soldering systems with wettable nozzles)

Lead-free FELDER ISO-Tin<sup>®</sup> soft solder alloys contains no materials, for which exists restrictions in the rules of 2011/65/EU ("RoHS II").

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

This product information does not constitute warranted properties.

## Application

For the alloy Sn95.5Ag3.8Cu0.7 we recommend the copper-free refill solder Sn96.2Ag3.8 for the refilling process. In the solder pot this solder mixes with the existing solder and Cu enrichments to form the alloy SAC387. From this point on it has the properties of the solder Sn95.5Ag3.8Cu0.7

## Properties

Metallic composition	:	96.2 % Sn, 3.8 % Ag
Melting range/point	:	221 °C (reduced to 217 °C when mixed with SAC387)
Electrical conductivity	:	7.5 m/Ωmm <sup>2</sup>
Specific weight	:	7.5 g/cm <sup>3</sup>

## Impurities /tolerances according to DIN EN ISO 9453:2014

<u>Ag</u>	<u>Al</u>	<u>As</u>	<u>Bi</u>	<u>Cd</u>	<u>Cu</u>	<u>Fe</u>	<u>Pb</u>
3.8 ± 0.2	0.001	0.03	0.1	0.002	0.05	0.02	0.05*
<u>Sb</u>	<u>Sn</u>	<u>Zn</u>	<u>Ni</u>	<u>Ti</u>			
0.1	Rest	0.001	0.01	0.01			

\*The maximum lead content in FELDER electronic solders is 0.05 % (standard requirement 0.07 %).

Each delivery is provided with a batch number. If requested an analysis certificate will be furnished. The analysis values are ascertained by the means of an emission spectrometer.

## Delivery form

400 g rod, 330x20x10 mm  
 1,0 kg rod, 330x20x20 mm  
 3,4 kg block with hanging hole 545 x47x 20 mm  
 cones 25 x 20 mm  
 Also available as massive wire on spools for automatic feeding (Item no.: 1489.../PF)

## Advices

Unlimited shelf life when stored dry and clean at room temperature