

PERSEDA

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TECHNICAL SHEET

PRODUCT: SOLID SOLDER WIRES **"LEAD FREE ALLOY"**

DESCRIPTION: made in "ecological" alloys, free from Lead, have been formulated as a good alternative to the traditional Tin/Lead alloys for soft solder. Composed from raw materials having high grade of purity, corresponding to EN 29453 Norm.

USE: these wires, **that require a suitable external flux**, find typical use in mechanical and electromechanical fields, for manual or automatic soldering application. Their characteristics of wetting force and capillarity are similar to the Sn/Pb alloys, with greater tensile and creep strength, especially at warm temperature. Because of melting range a little higher than the traditional Sn/Pb alloys, check and eventual new setting machine is recommended.

Alloy: SN96 AG4	Alloy: SN96,5 AG3 CU0,5	Alloy: SN97 CU3
Melting Range: 221 °C.	Melting Range: 230 °C.	Melting Range 230/250 ° C.
Typical assay (%):		
Silver (Ag) from 3,5 to 4	from 2,85 to 3,15	0,05 max
Tin (Sn) rem.	rem.	rem.
Lead (Pb) 0,10 max	0,10 max	0,10 max
Antimony (Sb) 0,10 max	0,10 max.	0,05 max
Bismuth (Bi) 0,10 max	0,10 max.	0,10 max
Cadmium (Cd) 0,002 max	0,002 max	0,002 max
Copper (Cu) 0,05 max	from 0,3 to 0,5	from 2,5 to 3,5
Indium (In) 0,05 max	0,05 max	0,05 max
Aluminium (Al) 0,001 max	0,001 max	0,001 max
Arsenic (As) 0,03 max	0,03 max	0,03 max
Iron (Fe) 0,02 max	0,02 max	0,02 max
Zinc (Zn) 0,001 max	0,001 max	0,001 max

SIZES and PACKING : wire from 3,0 to 1,0 mm. on spools from 20 Kg. to 0,5 Kg in carton-box

For any further information and warnings on the use, handling, toxicity, etc, see the relative Safety Cards