

TECHNICAL DATASHEET



Product Name :

Kurtel Solder Wire

Manufactured By :

Kurtel Lehim Teli Sanayi ve Ticaret LTD.ŞTİ.

Description :

Solder Wire is available in 5 cored type with high purity metals. Multicore 362 RA type flux is injected into the wire in three flux percentages; 1% , 2 % , 3%.

These three flux percentages helps to control the level of residue and flow rate. Solder Wire will solder Copper , Brass , Nickel and Zinc.

Solder Alloy :

For a successful soldering the purity of the raw materials is as important as the type of solid flux inside the wire. The purity degree of the used solder alloy should be in the range of international standards for the high quality soldering.

Solder Wire with Multicore 362 RA type meets these international standards such as B.S. , QQS , EN and DIN.

The following table shows the equivalent Kurtel Wire in relationship to the international standards.

Kurtel Part No	QQS 571E	BS219 DIN 1707	EN 29453
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63/37	Sn63Pb37	AP	1a
60/40	Sn60Pb40	KP	2a
40/60	Sn40Pb60	G	5
35/65	Sn35Pb65	H	6
HMP 5S	-	5S	34

LMP 62S	Sn62Pb36Ag2	62S	30
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96S	Sn96Ag4	96s	28
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Typical Batch Analysis (high purity tin)

Sn	99.96	Fe	0.0017
Pb	0.016	Cu	0.00035
Bi	0.0041	Al	0.00076
Sb	0.0077	Zn	0.00038
As	0.00066	Cd	0.00031

Typical batch analysis (high purity lead)

Pb	99.985	As	0.0005
Ag	0.001	Sn	0.0005
Cu	0.001	Sb	0.001
Zn	0.001	Fe	0.001
Bi	0.006		

Typical batch analysis (Kurtel 63/37)

Sn	63.0	Fe	0.0018
Pb	Rem	Cu	0.0008
Bi	0.00031	Al	0.0005
Sb	0.0085	Zn	0.00025
As	0.0015	Cd	0.00019

Halide (Max %) : 0.5

Kurtel improves lead free alloy to prevent the environmental pollution and to meet customers needs. Kurtel Solder Wire is made up of tin and silver alloy with three variations of flux percentage in it. These flux percentage is between 3% and 1% offers greater flexibility and improved level of control.

The following table shows the amounts of raw materials in lead free solder alloy ;

Kurtel Part no	Sn% Tin	Cu% Copper	Ag % Silver	Sb% Antimony
96S	Rem	-	3.5-4.0	-

For a high quality soldering , the purity of solder alloy and the correct flux are the essential parts. Besides these properties , the working temperatures and the ultimate strength of the soldered joint are also important in soldering process.

The table below shows the working temperatures and the tensile strength;

Kurtel Part No	Melting Temp. (°C)	Min Junction Temp(°C)	N/mm ²
63/37	183	245	67
60/40	183-188	248	48
40/60	183-234	294	47
35/65	183-244	304	-
HMP 5S	296-301	361	36
LMP 62S	179	239	92
96S	221	281	54

Flux Type :

Kurtel Solder Wire flux leaves clear residue with the help of the flux type; Multicore 362 RA.

Flux Name : Multicore 362 RA
Flux Type : RA

Flux Percentage :

Kurtel Solder Wire contains Multicore 362 RA type flux in three variations of percentages.

These different percentages offer greater flexibility and controlling the level of residue .

362 RA is available in 3 flux percentages;

3% ◇ Fast Flow

2% ◇ Fast Flow

1% ◇ Low Residue.

The diameters of Kurtel Solder Wire are between 0.75mm and 3mm.

Kurtel Solder Wire supplied on 200gr, 500 gr, 2.5 kg , 3 kg , 5 kg packages.