



Product Information

FELDER-ISO-Core® “EWL” - LEAD-FREE

Flux cored, halide containing activated soft solder wire
Flux according to DIN EN 29454.1, 2.1.2.B, resp. DIN EN 61190-1-3, ORM1
RoHS-conforming according to 2011/65/EU*

Item-no.: (55) 45.....

All information about our products is the result of our long standing experience which we would like to pass on to our customers as application support. 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.

This product information does not constitute warranted properties.

Description

The solder wire ISO-Core® "EWL" – LEAD-FREE, whose water soluble flux residues are easily to remove, has been developed for the special requirements of the electronics producing sector. The flux is on a basis of organic halide compounds.

The alloy Sn100Ni+ significantly improves the soldering and physical properties of the solder. The tool life of the soldering iron tip is markedly prolonged. The soldering joints show the gloss known from the lead containing soldering.

*** LEAD-FREE FELDER- ISO- Core® "EWL"-solder wires contain no substances for which exist restrictions in the directive 2011/65/EU („RoHS“).**

Application

Suitable for hand soldering and machine soldering in the electronics production with succeeding cleaning process.

Lead-free Standard Solder Alloys

Alloy	DIN EN ISO 9453	DIN EN 61190	Melting point	Item-No.
Sn100Ni+ (Sn99,3Cu0,7AgNiGe)	S-Sn99Cu1 (AgNiGe)	Sn99Cu.7	227°C	554594....
Sn95,5Ag3,8Cu0,7	S-Sn95Ag4Cu1	Sn96Ag04Cu0,7	217°C	4584....

Further lead-free alloys are available on customer's request.

Properties

Flux type:	2.1.2. (ORM1, F-SW25)
Flux content:	2,5 %
Halide content:	<1,9 %
Diameter in mm:	0,25, 0,35, 0,5, 0,7, 1,0, 1,5, 2,0, 3,0, 4,0
Spool sizes in kg:	0,10, 0,25, 0,50, 1,00, 2,50, 5,00

Impurities / Tolerances according to DIN EN ISO 9453:2014

e.g.: SAC 387

Element	Ag	Al	As	Bi	Cd	Cu	Fe
Content (%)	3,8± 0,2	0,001	0,03	0,1	0,002	0,7± 0,2	0,02
Element	Pb*	Sb	Sn	Zn			
Content (%)	0,07	0,1	Rest	0,001			

e.g.: Sn100Ni+ (according to Fuji-Pat. No. DE19816671C2)

Element	Ag	Al	As	Bi	Cd	Cu	Fe
Content (%)	0,06	0,001	0,03	0,05	0,002	0,7± 0,2	0,02
Element	Ge	Ni	Pb*	Sb	Sn	Zn	
Content (%)	0,01± 0,02	0,07± 0,02	0,07	0,05	Rest	0,001	

*The max. lead content in FELDER-Electronic solder wires is 0,05 % (standard requirement 0,07 %).

Cleaning

The water soluble flux residues are corrosive and have to be removed after the soldering.
The residues of ISO-Core® "EWL" – LEAD-FREE can be easily removed with distilled water.

Storage

Store dry and as far as possible dust-free. Durable for at least 24 months after delivery.

Handling Advice

Please refer to the correspondent EU Material Safety Data Sheet.

Further Advice

We are pleased to produce all solder wires according to your factory standards.