

Product Information

FELDER- ISO-Core® "AL" – lead-free

Flux-filled soft solder wire for the soldering of aluminium and aluminium alloys,
flux according DIN EN ISO 9454.1, 2124
RoHS-conformity according to 2011/65/EU*

Item-No.: 4997....

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.

Description

Special solder wire for the soft soldering of aluminium and aluminium alloys. The flux distinguishes itself through its high temperature resistance. An optimal wetting makes this lead-free aluminium-soft solder wire to a top-quality product among the cored solders.

Properties

Alloy	DIN EN ISO 9453	DIN EN 61190	Melting range	Article No.
Sn97Cu3	Sn97Cu3	-	230° - 310 °C	4797....
Further lead-free alloys are deliverable on request.				

Flux content : 4.0 % standard

Flux spacing : single cored

Application

The contained flux is very sensitive to temperature and must not be overheated. The maximum workpiece temperature is 300 °C! The recommended soldering iron temperature should not exceed 350 °C. We recommend indirect heating of the solder wire over the workpiece or the processing by soldering iron. For voluminous workpieces, we recommend preheating the parts to be soldered up to 250 °C.

Cleaning Advices

The water soluble flux residues are corrosive and have to be removed thoroughly immediately after soldering.

Delivery forms

Ø in mm : 1.00, 1.50, 2.00, 3.00, 4.00

Spool size in kg : 0.10, 0.25, 0.50, 1.00

Other diameters and spool sizes are available on request.

*FELDER ISO-Core® "AL" - lead-free solder wire doesn't contain any substances that are subject to restrictions by directive 2011/65/EU ("RoHS").