



# Leaded solder wire

## IF 14-10

INTERFLUX®  
ELECTRONICS N.V.



Technical data IF 14-10

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## Leaded, halide free, no-clean solder wire

### Description:

**IF 14-10** is a leaded, no-clean solder wire that contains no rosin, no halides and is recommended when soldering in **class 3** (IPC-A-610). Since the body of the IF 14 flux carrier can evaporate by heat (rather than carbonising), residues can easily be cleaned.



### More information:

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### Availability

Flux type: IF 14  
Flux content: 1,0 % w/w

alloy	melting point	diameters					
		0,35	0,50	0,70	1,00	1,50	2,00
Sn60Pb40	183°C–191°C	●	●	●	●	●	●
Sn63Pb37	183°C	●	●	●	●	●	●
Sn62Pb36Ag2	179°C	●	●	●	●	●	●
Sn5Pb94Ag1*	296-301°C	●	●	●	●	●	●

● = available

● = upon request

\*Sn5Pb93,5Ag1,5

### Key advantages:

- Reduced contamination of tools, equipment, due to the low flux content
- No colophony fumes
- Classification to IPC and EN: **RE LO**
- Absolutely halogen free
- Long tip-life
- Long product history
- Very good wetting on Cu, Ag, Sn ...



## Work instructions

### **Manual soldering**

The working temperature is between 320°C and 360°C. For more dense metals like Nickel, the temperature may be elevated to 400°C.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact surface with the component and

solder pad.

The use of a good soldering station is important in order to always have the correct temperature on the soldering joint. Use a soldering station with a response time as short as possible.

Heat up the surfaces of both component and island simultaneously. Slightly touch with the solder wire,

the point where component lead, soldering island and soldering tip meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. It is important that no solder wire is making contact with

the soldering tip during soldering to avoid flux spitting and premature flux consumption!

## Handling

### **Storage**

Store the solder wire in a clean environment at ambient temperature.

### **Handling**

To avoid spool and wire damage, handle package with care.



## Test results

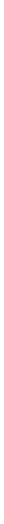
conform EN 61190-1-3(2007) and IPC J-STD-004(A)

Property	Result	Method
<b>Chemical</b>		
flux designator	<b>RE / LO</b>	J-STD-004A
	<b>F-SW 33</b>	DIN 8511
	<b>1.2.3</b>	ISO 9454
qualitative copper mirror	<b>pass</b>	J-STD-004A IPC-TM-650 2.3.32
qualitative halide		
silver chromate (Cl, Br)	<b>pass</b>	J-STD-004A IPC-TM-650 2.3.33
	<b>pass</b>	TR-TSY-000078 13.1.4
spot test (F)	<b>pass</b>	J-STD-004A IPC-TM-650 2.3.35.1
	<b>pass</b>	TR-TSY-000078 13.1.5
quantitative halide	<b>0,00%</b>	J-STD-004A IPC-TM-650 2.3.35
<b>Environmental</b>		
SIR test	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.3.3
	<b>pass</b>	TA-NWT-000078 13.1.4
qualitative corrosion, flux	<b>pass</b>	J-STD-004A IPC-TM-650 2.6.15
electro chemical migration	<b>pass</b>	TA-NWT-000078 13.1.5



## Packaging

Spools of 100g, 500g and 1000g



Trade name: IF 14-10 Leaded, Halide Free, No-Clean Solder Wire

D i s c l a i m e r

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