

TECHNICAL DATA SHEET

Alloy designation in accordance with ISO 9453:2014	Sn60Pb40
Other known alloy markings	S-Sn60Pb40
Product type	Cored solder wire (with flux)
Flux	SW26

1. General characteristics

The solder was produced in the first smelt of tin and lead. The composition of the solder complies with the ISO 9453:2014 standard. SW26 solid flux is based on rosin and halide formulations. It is leaded alloy for manual and automatic processes where meeting the requirements of the RoHS2 Directive is not required. The product is intended for professional use.

2. Chemical characteristics

- 2.1. Tin content: 60,0 ± 0,5%
- 2.2. Lead content: rest
- 2.3. Composition and permissible impurities according to ISO 9453:2014:

Sn	Pb	Sb	Bi	Cu	Au	In	Ag	Al	As	Cd	Fe	Ni	Zn	others
59,5 – 60,5	rest	0,20	0,10	0,08	0,05	0,10	0,10	0,001	0,03	0,002	0,02	0,01	0,001	

3. Physical characteristics

- 3.1. Melting point: (solidus/liquidus): 183/190 °C
- 3.2. Density: 8,50 g/cm³
- 3.3. Electrical conductivity: 0,153 μΩm
- 3.4. Thermal conductivity: 49 W/m K
- 3.5. Tensile strength: 535 kgf/cm²
- 3.6. Elongation at break: 40%
- 3.7. Hardness: 16 HB
- 3.8. Suggested operating temperatures (values that can be the starting point for process settings):
 - Soldering tip temperature: 340 - 420 °C.

4. SW26 flux

SW26 flux assures good solderability in popular basic soldering applications in all branches of industry. Cored solder wire works on most metal surfaces excluding aluminum, its alloys and stainless steel. If it necessary, use alcohol-based solvents to wash the residue.

- 4.1. Flux type:
 - 1.1.2B (acc. to EN ISO 9454)
 - ROL1 (acc. to IPC-J-STD-004B)
 - SW-26 (acc. to DIN 8511)
- 4.2. Flux content: 2,5 ± 0,2%; 3 cores of flux (1 core of other flux content on request)
- 4.3. Halide content: < 0,5 %
- 4.4. Acid Value: 215 ± 10 mg KOH/g
- 4.5. SIR test (PN-EN ISO 9455-17): no data available

5. Product description

- 5.1. Available diameters: • 0,25 • 0,38 • 0,50 • 0,56 • 0,70 • 0,80 • 0,90 • 1,00 • 1,20 • 1,50 • 1,60 • 2,00 • 2,50 • 3,00 • 4,00 mm (other on request)
- 5.2. Packed: • 120 pcs / 6 kg (50 g reels) • 60 pcs / 6 kg (100 g reels) • 5 kg (250 g and 500 g reels) • 10 kg (1 kg reels) cartons
• vial Ø1,00 mm (10g, 16g) – cartons 600 pcs (other on request)
- 5.3. Reels and cartons marked with alloy type, flux type, diameter, net weight and batch number.

6. Storage

- 6.1. In original packaging at 5-20°C.
- 6.2. The recommended humidity level is 20-60%.
- 6.3. Keep away from strong oxidizing agents, acids, alkaline agents and beyond the reach of children
Expiration date - three years from the end of the year of production
for example: batch 61112233 = date of production 2016, date of expiry 2019