Technical Product Information

Flux-Cored Solder Wire Type 3064

Flux classification: **DIN EN 61190-1-1: ROM1**
DIN EN ISO 9454-1: 1123
Flux content versions available: 1.4 % - 2.3 %

Description

ELTIN 3064/3064 BF cored wires excel by virtue of their high activity and – at the same time – very low risk of corrosion. These two factors together make for a wide process window. The activation has been designed such that will show its best performance at the adequate soldering temperature. ELTIN 3064/3064BF cored wires can be used with low flux content, resulting in low residues and a high safety against corrosion. The special composition of the activator guarantees excellent spreading of the solder even with low flux content percentages and yields consistent reproducible soldering results both for manual and automatic soldering. Flux residues can in most cases remain on the solder joint. ELTIN 3064/3064BF cored wires do not show splashing or unpleasant odours during processing. The requirements of DIN EN 61190-1-1 and DIN EN 29454 regarding corrosion are fulfilled. TAMURA ELSOLD cored wires of type ELTIN 3064 BF are suitable for any standard soldering process in electric and electronic industries.
TAMURA ELSOLD SN100 MA und SN100 MA-S are special alloys of high purity, very low oxide content, and highly resistant against oxidation. Abrasion of soldering iron tips is considerably reduced and copper dissolution remarkably reduced. Solder joints appear smooth and bright.

Alloy tolerances, if not stated otherwise, for elements up to 5 % ± 0.2 %, over 5 % ± 0.5 %.
Impurities per EN 61190-1-3 / ISO 9453 and TAMURA ELSOLD house norms.

Standard ELSOLD SnPb Alloys

Alloy	Sn [%]	Pb [%]	Ag [%]	Cu [%]	Density [g/cm³]	Melting Point / Range [°C]
Sn60Pb40	60	Rest			8.5	183 – 190
Sn60Pb39Cu1	60	Rest		1.2-1.6	8.5	183 – 190
Sn62Pb36Ag2	62	Rest	2		8.4	178 – 180
Sn60Pb36Ag4	60	Rest	4		8.5	178 – 180
Sn63Pb37	63	Rest			8.4	183

Standard ELSOLD Lead-free Alloys

Trade Name	Sn [%]	Ag [%]	Cu [%]	Density [g/cm³]	Melting Point / Range [°C]
ELSOLD SC07	99.3	-	0.7	7.32	227
ELSOLD SA35	96.5	3.5	-	7.35	221
ELSOLD SAC305	96.5	3.0	0.5	7.37	217 – 219
ELSOLD SAC3507	95.8	3.5	0.7	7.40	217 – 219
ELSOLD SAC0307	99.0	0.3	0.7	7.33	217 – 227
ELSOLD SAC3807	95.5	3.8	0.7	7.40	217

Other alloys available on request. ELSOLD solder wire 3064 is also available with ELSOLD micro-alloyed Solders SN100(Ag) MA and SN100(Ag) MA-S.

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		ELSOLD SN100 MA-S	ELSOLD SN100Ag0.3 MA-S	ELSOLD SN100Ag1 MA-S	ELSOLD SN100Ag3 MA-S
Composition [Wt.-%]	Sn	99.3	99.0	98.3	96,5
	Ag		0.3 ± 0.2	1.0 ± 0.2	3.0 ± 0,2
	Cu		0.7 ± 0.2		0.5 ± 0.2
	Ni		0.03 - 0.06		
	Ge		0.003 - 0.007		
	P		0.001 - 0.005		
Melting Range [°C]		227 – 230	217 – 227	217 – 223	217
Density [g/cm³]		7.32	7.33	7.36	7.38

Diameter and Tolerances

Diameter [mm]	Tolerance [mm]
0.30	± 0.03
0.50	± 0.05
0.75	± 0.05
1.00	± 0.05
1.20	± 0.05
1.50	± 0.05

Spool Dimensions [mm]

	500 g spool	1000 g spool
Flange diameter	69.5	70
Barrel diameter	33.5	33
Bore diameter	30	30
Total width	41.5	78
Traverse	38	68

The standard wire type has 1 flux core.

Packaging Units

Spools of 500 g – 1000 g
Colour coding: SnPb alloys: teal Lead-free alloys: neon yellow
Other spool types are available on special request.

Shelf Life

We guarantee a minimum shelf life of 36 months if the products are stored with due care in a clean environment. Most likely the flux-cored solder wires can still be used beyond that period. However, we recommend the user to make relevant tests before using the material at his own risk in production.

Health and Safety

Please refer to the relevant information in the respective material safety data sheet.

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