

**SOLDER (HQ) 1MM 250GR TECHNICAL DOCUMENTS**

1. Product Code : TIN 250GR。
2. Shape & Size : A coil of wire, 1.0 mm  $\pm$  0.1 mm。
3. Appearance : Metal coiling。
4. Packaging :250 gram roll, 50 rolls in boxes。
5. Features : The solder joint surface is smooth and excellent wetting ability。
6. Purpose : It is suitable for soldering for assembly of electronic and electrical appliance products with manual or automatic operation。
7. Standard : It is conform to JIS-Z-3282 and JIS-Z-3283 standards。

8. Alloy composition:

(1) Main composition (wt%)

Sn	Pb
60.0 $\pm$ 0.5	remainder

(2) Impurities (wt%)

Sb	Cu	Bi	Zn	Fe	Al	As	Cd
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Date of issue : Oct. 01 2013  
Date of revision : Oct. 01 2013

0.12	0.05	0.05	0.002	0.02	0.002	0.03	0.002
Max.	Max.	Max.	Max.	Max.	Max.	Max.	Max.

9. Physical Properties:

Main Composition	Melting Point (°C)		Gravity
Pb containing	Solidus temperature	Liquidus temperature	Approx. 8.5
Sn60/Pb remainder	183	190	

10. Characteristics of Flux:

Test Item	Characteristics
Dryness	Chalk powder is easily removed
Chlorine Content (wt%)	0.10 ~ 0.50
Copper plate corrosion test	Remarkable corrosion is not observed
Copper mirror corrosion test	Remarkable corrosion is not observed
Water solution resistance (Ω.m)	2 5 × 10 Min.
Insulation resistance (Ω)	10 5 × 10 Min.
Flux Content (wt%)	2 ± 0.5

Spreading (%)	80% Min.
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11. Operating temperature: 280 °C ~ 400°C。

12. Guarantee Period : This product is expired 24 months after production date。

13. Storage condition : This product shall be stored in a dry place。

14. Product photos :



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