



## Technical Data Sheet

# STANNOL® solder wire ARAX

## ACID CORED SOLDER WIRE FOR METAL FABRICATION

- Assists automatic soldering processes.
- Reduces labour costs.
- Correct proportion of extra fast acting flux applied to each joint.
- Safe, fast and easy to use.
- Replaces tinmans and blowpipe solders, fluid and paste fluxes and killed spirits.

### Description

**STANNOL® ARAX** solder wire shows faster wetting than using solid solder with a separate flux, since only one operation is required which produces a better uniform spread of the solder. The flux is automatically applied at the right time, in the right amount and at the right place. The flux is faster, yet less acidic than zinc chloride or similar liquid fluxes and spitting is reduced.

### Application

**STANNOL® ARAX** solder wire is suitable for soldering to the following materials:

- brass
- bronze
- copper
- iron
- lead
- silver
- mild steel
- spring steel
- galvanised ware
- zinc and zinc plating
- tin plate
- cadmium plating
- nickel and nickel plating
- resistance wires (most types - **flux residues should be removed**)
- most stainless steels

Pre-cleaning is normally not necessary. The high activity of the flux ensures that the solder will flow between laps by capillary force, giving maximum strength with the minimum amount of solder.

### Flux Residues

The residues of the **STANNOL® ARAX** flux would, under dry conditions, be non-corrosive, however as the work is usually exposed to humidity, the residues after soldering would, over a long period of time, absorb moisture, becoming mildly corrosive. The residues should therefore be removed with water (preferably warm), but where flame heating is employed the flux will be extensively volatilised by the soldering operation. In addition, it will not contaminate plating baths. This flux residue, if not removed, is considerably less corrosive than most separate liquid or pasty fluxes. Consequently, if **STANNOL® ARAX** cored solder wire is being used in place of stick solder and a liquid flux and the flux residue was not previously removed, there should be no need to do so when using **ARAX** cored solder wire.

### Properties und Data

General properties	STANNOL® solder wire ARAX	
Flux type:	ORH1 (IEC 61190-1-3) / 2.1.2.B (DIN EN 29454-1) / F-SW25	
Flux content:	2.7 weight % ± 0.3 %	
Flux cores:	single cored	
Standard alloy acc. to ISO 9453:2006	lead-containing:	lead-free (ECOLOY® Series):
	S-Sn60Pb40*	ECOLOY® TS (S-Sn96Ag4)
Available diameters:	from 0.5 mm	
Available reel sizes:	500 kg	

\* This alloy is subject to a minimum order quantity!

Other alloys, diameters flux contents or reel sizes are available on request.

### Health and Safety

Before using please read the material safety data sheet carefully and observe the safety precautions described.

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.