



# SOLDER WIRE HF34

flux cored solder wire

## DESCRIPTION

Stannol HF34 flux cored solder wire has been formulated to comply with the high demands of conventional and reflow soldering processes. It is also applicable to repair and rework operations.

Stannol HF34 is a halide-free activated flux on the basis of organic acids. It combines high activity and good flow properties with negligible bright, hardly visible, solid residues.

## CHARACTERISTICS

Compared with conventional no clean solder wires Stannol HF34 offers the following advantages:

- **low flux content** (low residues)
- **reduced rosin content** (no thermal degradation of rosin at the hot soldering tip, favourable optical impression)
- **high organic acid content** (good activity - appropriate to SMT applications)
- **halid-free** (electrically safe)
- **negligible residues** (evaporation at soldering temperatures)
- **less vapour formation** (low dissolution and evaporation of rosins, reduced occupational hazard, low contamination around the solder joint)

## APPLICATION

Stannol solder wire HF-34 can be used for hand and machine soldering applications in the electro-technics and electronic industry where low residues are required and flux residues must stay on the solder joints. If PCBs are climatically stressed or if circuits are used as highly resistive devices, we recommend to test whether cleaning is required.

If cleaning is necessary for optical or technical reasons, we recommend the use of the cleaner Stannol Flux-Ex 200B or Stannol Flux-Ex 500.

## PHYSICAL PROPERTIES AND DATA

GENERAL PROPERTIES	SOLDER WIRE HF34	
Flux type:	ORM0 / J-STD-004	
Flux content:	standard 1.6 weight % ± 0.3 %	
Halide content:	none	
Corrosion effect:	None / J-STD-004	
Standard alloys acc. to ISO 9453:2014 (Flowtin = with micro additives <0,05%)	<b>Lead-containing:</b>	<b>Lead-free (Flowtin Series):</b>
	S-Sn60Pb40	Flowtin TSC305 (Sn96Ag3Cu0,5)
		Flowtin TSC0307 (Sn99Cu0,7Ag0,3)
Available diameters:	from 0.5 mm	
Available reel size:	250 g, 500 g, 1 kg	

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

## **HEALTH AND SAFETY**

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Read the Material Safety Data Sheet carefully and observe the safety instructions before use.

## **NOTICE**

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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.