

SOLDER WIRE WS2413

Solder wire with water soluble flux core for copper and brass

DESCRIPTION

Stannol flux cored solder wire WS2413 was developed to show a good activity on brass and copper surfaces, regardless of the oxidation. The second important property is the ease of cleaning of the low amounts of flux residues. The flux is halide-activated with good wetting properties on nearly all metal surfaces. This flux cored solder wires leaves minor amounts of a transparent to white residue, which are good soluble in water based cleaning processes. As residues can be corrosive, we highly recommend removal of the residues.

Stannol wire flux WS2413 conforms to J-STD-004 type ORH1 and DIN EN 29454-1 type 2.1.2.A.

APPLICATION

The solder wire WS2413 has been tested to give good wetting properties on many different kinds of brass, as well as on various oxidized copper surfaces and other metallisation, except stainless steel and aluminium. All known methods of heat transfer might be used, including soldering iron, induction, micro flame, flame, laser and more. We recommend highly removing the low amounts of flux residues in an appropriate cleaning process.

PHYSICAL PROPERTIES AND DATA

GENERAL PROPERTIES	SOLDER WIRE WS2413 2.4%	
Flux type:	ORH1 (J-STD-004) / 2.1.2.A (DIN EN 29454-1)	
Flux content:	2.4% ± 0.3 %	
Halide content:	1.3%	
Acid value:	50mg KOH/g flux	
Standard alloys acc. to ISO 9453:2014:	Lead-containing:	
	available on request*	Ecoloy TC (S-Sn99,3Cu0,7)*
	available on request*	
Available diameters:	1.0 mm*	
Available reel sizes:	1 kg*	

Other alloys, diameters, flux contents or reel sizes are available on request. Variations can lead to a minimum order quantity.

HEALTH AND SAFETY

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

NOTICE

The mentioned values are typical and represent no form of specification. The technical 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.