

**DIXTRA GEL CORED WIRE**

**LEAD FREE ALLOYS**

**FEATURES**

**DIXTRA GEL** lead free cored wire is available in the main lead free alloys; it contains three cores of alkaline flux, that was specifically formulated in order to combine with the surface oxides on the joints to perform a very good and fast joint

The flux is mainly made of (90%) a polyglycol, water soluble excipient and of a mixture of inorganic ureic substances (10%) containing small percentages of inorganic chlorides.

. During the operation process the flux is thermally decomposed thus releasing its activator in a non toxic way.

Standard flux percentage is 2,5% +/-0,2 and complies **DIN EN 29454.1, 3.1.1.C, F-SW21**. The alloys comply **ISO 9453 : 2014 (E)**

**USES**

**DIXTRA GEL** cored wire is mainly used in the electromechanic—plumbing-copper tubes, jewels etc. for joints over copper, brass, bronze and iron. It is effective on zinc-plated capacitor heads. In Electronic it can be used as water soluble wire, but in this case the removal of the residues is strongly recommended.

**WORKING TEMPERATURE**

Lead free alloys have higher melting points if compared to the traditional lead bearing alloys. We recommend to keep iron temperature between 400-450°C. Above 400° C, irons tend to oxidize when non active. It is very important to reduce temperature set when not operating.

Main available alloys for **DIXTRA GEL** wire.

Nr lega	Denominazione	punto / intervallo di fusione °C	Sn	Pb	Sb	Bi	Cd	Cu	In	Ag	Al	As	Fe	Zn	Ni
401	Sn99,3Cu0,7	227	Resto	0,07	0,10	0,10	0,002	0,5-0,9	0,10	0,10	0,001	0,03	0,02	0,001	0,01
402	S-Sn97Cu3	227-310	Resto	0,07	0,10	0,10	0,002	2,5-3,5	0,10	0,10	0,001	0,03	0,02	0,001	0,01
702	Sn97Ag3	221-224	Resto	0,07	0,10	0,10	0,002	0,05	0,10	2,8-3,2	0,001	0,03	0,02	0,001	0,01
501	Sn99Cu0,7Ag0,3	217-227	Resto	0,07	0,1	0,06	0,002	0,5-0,9	0,10	0,2-0,4	0,001	0,03	0,02	0,001	0,01
711	Sn96,5Ag3Cu0,5	217-220	Resto	0,07	0,1	0,1	0,002	0,3-0,7	0,1	2,8-3,2	0,001	0,03	0,02	0,001	0,01