

## IMPETOL B CORED SOLDER WIRE

### FEATURES

**IMPETOL B** cored solder wire is produced in many different lead-bearing alloys and also in the main lead-free alloys; it contains three cores of activated rosin, that allow a fast soldering even in presence of difficult surfaces. The alloys 60Sn40Pb and 50Sn50Pb contain a percentage of copper that prevents the corrosion of solder tips.

We use a hydrogenated rosin (higher purity than WW grade) in a quantity ranging 2,2 +/- 0,2%.

Different flux % content are available upon request.

**IMPETOL B** cored solder wire complies to **ISO 9453:2014 (E) (alloys)** and **DIN EN 29454.1, 1.1.2.B (F-SW26) (flux activation)**.

**Flux classification according IPC J STD -004B: R0M1**

### VARIATIONS

**IMPETOL B SF-** Formulated to pursue fast joints and a higher activation is required. Conforms to **DIN EN 29454.1,1.1.2B (F-SW26)**. Classification according IPC STD-004 : **ROM1 (Halide content 1,2%)**

### APPLICATIONS

**IMPETOL B** cored solder wire is used in electromechanics and elettrotechnics and generally where fast and reliable joints are required. It is particularly indicated when using lead-free alloys.

**STANDARD FLUX CONTENT : 2,2 +/- 0,2.** Different flux content available upon request (**1,4%** as main alternative)

### AVAILABLE ALLOYS according ISO 9453:2014 (E)

**In green rows lead free alloys**

Nr alloy	Nomenclature	Melting point ° 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
161	Sn60Pb39Cu1	183-190	59,5-60,5	Resto	0,20	0,10	0,002	1,2-1,6	0,10	0,10	0,001	0,03	0,02	0,001	0,01
162	Sn50Pb49Cu1	183-215	49,5-50,5	Resto	0,20	0,10	0,002	1,2-1,6	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
171	Sn62Pb36Ag2	179	61,5-62,5	Resto	0,20	0,10	0,002	0,08	0,05	1,8-2,2	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