

## Leaded Solid Solder Wire

for High Reliability Soldering

### Product Description

For soldering applications that require maximum reliability of solder joints, especially for surface mounted components, through hole and final assembly, only solder of the highest purity is acceptable. Kester does not make any vague claims of understanding solder purity. Only the highest quality metals are used to make Kester Solder Wire. Complete analysis of Kester Solder Wire proves that every batch conforms to the strictest quality controls in the solder industry.

### Maximum Allowed Impurities

Kester Solder Wire meets IPC Specifications J-STD-006C Amendment 1.

Element	Symbol	ANSI/IPC J-STD-006C
Antimony	Sb	0.200
Copper	Cu	0.080
Gold	Au	0.050
Aluminum	Al	0.005
Cadmium	Cd	0.002
Zinc	Zn	0.003
Silver	Ag	0.100
Bismuth	Bi	0.100
Arsenic	As	0.030
Iron	Fe	0.020
Nickel	Ni	0.010
Indium	In	0.100

The component elements in each alloy shall deviate from their nominal mass percentage by not more than 0.020% of the alloy mass when their nominal percentage is <0.10%; by not more than 0.10% of the alloy mass when their nominal percentage is >0.10% to <1.0%; by not more than 0.20% of the alloy mass when their nominal percentage is >1.0% to <5.0% or by not more than 0.50% when their nominal percentage is >5.0%.

Kester solder purchased directly or through stocking distributors will conform to these requirements. Only highest purity virgin metals are used to make Kester wire. DOD-STD-2000-1A (Soldering Technology High Quality/High Reliability) states that it is the responsibility of the manufacturer to select those materials and processes that will produce acceptable high quality/high reliability products.

## RoHS Compliance

Kester does not determine any applicable Restriction of Hazardous Substances (RoHS) exemptions for our lead containing products at the user level.

## Availability

Alloy	Melting Point
Sn63Pb37	183 °C (361 °F)
Sn60Pb40	183 to 190 °C (361 to 374 °F)
Sn50Pb50	183 to 212 °C (361 to 414 °F)
Sn40Pb60	183 to 238 °C (361 to 460 °F)
Sn5Pb93.5Ag1.5	296 to 301 °C (565 to 574 °F)
Sn5Pb95	301 to 314 °C (574 to 597 °F)

Other alloy compositions may be available. Consult your local Kester Sales Representative.

## Recycling Services

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



## Storage, Handling and Shelf Life

Storage must be in a dry, non-corrosive environment between 10 to 40 °C (50 to 104 °F). The surface may lose its shine and appear a dull shade of grey. This is a surface phenomenon and is not detrimental to product functionality. Solid solder wire has a shelf life determined by the alloy used in the wire. For alloys containing more than 70% lead, the shelf life is 2 years from the date of manufacture. Other alloys have a shelf life of 3 years from the date of manufacture.

## Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet and warning label before using this product. Safety Data Sheets are available at this [link](#).

## Contact Information

To confirm this document is the most recent version, please contact [Assembly@MacDermidAlpha.com](mailto:Assembly@MacDermidAlpha.com)

<p><b>North America</b> 109 Corporate Blvd. South Plainfield, NJ 07080, USA 1.800.253.7837</p>	<p><b>Europe</b> Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400</p>	<p><b>Asia Pacific</b> 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p>
--	--	---

Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

DISCLAIMER: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. No statement or recommendation shall constitute a representation unless set forth in an agreement signed by officers of seller and manufacturer. NO WARRANTY OF MERCHANTABILITY, WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY IS MADE. The following warranty is made in lieu of such warranties and all other warranties, express, implied, or statutory. Products are warranted to be free from defects in material and workmanship at the time sold. The sole obligation of seller and manufacturer under this warranty shall be to replace any noncompliant product at the time sold. Under no circumstances shall manufacturer or seller be liable for any loss, damage or expense, direct, indirect, incidental or consequential, arising out of the inability to use the product. Notwithstanding the foregoing, if products are supplied in response to a customer request that specifies operating parameters beyond those stated above, or if products are used under conditions exceeding said parameters, the customer by acceptance or use thereof assumes all risk of product failure and of all direct, indirect, incidental and consequential damages that may result from use of the products under such conditions, and agrees to exonerate, indemnify, defend and hold harmless MacDermid, Incorporated and its affiliates therefrom. No suggestion for product use nor anything contained herein shall be construed as a recommendation to use any product in a manner that infringes any patent or other intellectual property rights, and seller and manufacturer assume no responsibility or liability for any such infringement.

© 2019 MacDermid, Inc. and its group of companies. All rights reserved. "R" and "TM" are registered trademarks of MacDermid, Inc. and its group of companies in the United States and/or other countries.