



STANNOL®

Wenn's ums Löten geht
When it's about soldering
Quand il s'agit du soudage

Technical Data Sheet

STANNOL® Solder Wire HF-32

STANNOL® Solder Wire HF-32 has been developed to meet industry's increasingly stringent quality requirements. It is designed for use in electronics application. **STANNOL® Solder Wire HF-32** is a flux cored solder wire. The activated, halide-free flux meets DIN EN 29454 Typ 1.1.3 (DIN 8511 F-SW32) standard. The flux residues are transparent, dry, and hard, and are not corrosive when tested in accordance with DIN 8516.

Application

STANNOL® Solder Wire HF-32 can be used for hand-soldering and automatic wire feed operations. For manual soldering, the soldering iron tips should be temperature-controlled, to prevent excessive heat from being applied to the wire. Flux spatter from the formulation is minimal.

STANNOL® Solder Wire HF-32 meets the requirements of DIN 8516, with respect to surface insulation resistance and electromigration.

Cleaning

The flux residues are not corrosive to non-ferrous metals. If cleaning is required the residues can easily removed by means of **STANNOL® FLUX-Ex200/B** (CFC-free) or most conventional organic solvents.

Physical Properties of the Flux

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|--------------------------------|---|
| Flux Type: | DIN EN 29454 Typ 1.1.3 (F-SW32 DIN 8511) |
| Flux Content per DIN 8516: | 3.5% by weight (Standard) |
| Spread Area: | 130 mm ² per DIN 8516 |
| Corrosive Effects: | None, per DIN 8516 |
| Surface Insulation Resistance: | No reduction, per DIN 8516 |
| Standard Alloys: | S-Sn60Pb40 (183-190°C) S-Sn60SnPb38Cu2 (183-190°C) S-Sn63SnPb37 (183°C) |
| Diameters Supplied: | from 0.5 mm (.020" or 25 swg) |
| Standard Reels: | 250 grs, 500 grs, 1 kilo |

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