

# PERSENDA

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## TECHNICAL SHEET

### PRODOTTO: SOLDER BARS *SR1/SR0n*

**DESCRIPTION:** made in ecological alloy, free from lead, have been developed as one of the best alternatives to traditional Tin/Lead soldering alloys; the specific high grade of raw materials and the particular process adopted in their production, guarantee a very high qualitative level of the final product, free from oxides and dross.

**USE:** *SR1* alloy, expressly formulated in Tin/Copper eutectic composition, is typically recommended in HAL process and in the wave soldering of printed circuit boards, allowing very good soldering with bright, smooth and regular surface.

Using *SR0n* maintenance alloy, it is easy to keep under control the percentage of Copper dissolved in the solder bath during the process, reducing also the dross production.

Specific alloy composition, containing Nickel traces, increase the flowing at low temperature, reducing also the risk of corrosion of the solder pot by lead free alloys..

Several test on the alloy have shown excellent results for strength, wetting force and flowing.

*SR1/SR0n* alloys are easy to use, offering a good compatibility with the present technology and they are full suitable for lead free assembly; due higher processing temperature needed with lead free alloys, the check and possible new setting machine is recommended.

#### Chemical/Physical specifications:

##### Typical assay %

Element	SR1 alloy	SR0n alloy
Sn	Rem	Rem.
Cu	0,7 ± 0,1	0,05 max.
Ni	0,05 ± 0,01	0,15 ± 0,01
Pb	0,06 max.	0,06 max.
Sb	0,05 max.	0,05 max.
Bi	0,05 max.	0,05 max.
Cd	0,002 max.	0,002 max.
Ag	0,05 max.	0,05 max.
Al	0,001 max.	0,001 max.
As	0,03 max.	0,03 max.
Fe	0,02 max.	0,02 max.
Zn	0,001 max.	0,001 max.

Melting temp.: **227 °C.** Processing temp.: **270°C ca.**

Density: **7,4** Tensile strength: **32 N/mm<sup>2</sup>**

Hardness HB: **9**

**NOTE: further information and use warnings are available on specific Safety Data Sheet.**