Core Solders

Usable over wider applicable range from hand to robot soldering.
Soldering performance is superior to normal Sn-Pb solder.

SR-34 Super
1. Initial wetting spreadability of the solder is higher with workability similar to conventional soldering.
2. Wetting spreadability can be performed with lower temperature soldering iron, assuring higher performance for heat damageable parts and substrates.
3. Reducing the problem of whitening metal surface in the case of soldering with Pb-free solder, such as Sn-Ag-Cu.
4. Enables quick soldering.

Average dimension of point soldering
[Condition] An automatic soldering machine was used to observe average dimensions of spreaded area at soldered 20 points.
- Solder temperature: 235°C, SMT, 430°C. - After soldering, cure solder diameter 0.08 to 0.2 mm
- Tin wire: 0.2 mm. - Tin wire bending temp. 30 sec. - Tin wire breaking time: 0.5 sec. each.

Dimensions of point solder spreaded area (mm²)

<table>
<thead>
<tr>
<th>Temperature</th>
<th>310°C</th>
<th>340°C</th>
<th>410°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Diameter</td>
<td>6.99</td>
<td>5.84</td>
<td>4.23</td>
</tr>
<tr>
<td>Diameter</td>
<td>9.36</td>
<td>8.32</td>
<td>10.4</td>
</tr>
<tr>
<td>Diameter</td>
<td>9.75</td>
<td>8.74</td>
<td>10.8</td>
</tr>
</tbody>
</table>

SR-34
Maintaining wettability, active stability, and controllability, enabling excellent soldering.
Examples of application: Sn-Ag-Cu/solder, Single-sided and through-hole substrates.

KR-19
Appropriate to use for materials and parts, which are not so easy to solder, such as Ni-Sn alloys.
Examples of application: Sn-Ag-Cu/solder, General parts, terminals, and Hi-containing parts. Rework and adjustment of single-sided substrates.

HR-19M
High reliability which makes it especially useful for point soldering.
Examples of application: Sn-Ag-Cu/solder, Multi-pin parts (QFP & connectors), adjusting substrates, and installing LCDs.

G-14
RMA type flux improved for Pb-free soldering to protect thermal damage. P-4 is a suitable solder for robots.
Examples of application: Sn-Ag-Cu/solder, Multi-pin parts (QFP & connectors), adjusting substrates, and installing LCDs.

GUMMIX-SB RMA
A compatible product with soft-beam soldering. Improved GUMMIX type one.
Examples of application: Sn-Ag-Cu/solder, Pcbuy, relay, and SW.

Core Solder products specification
<table>
<thead>
<tr>
<th>Flux name</th>
<th>Alloy type</th>
<th>Flux content</th>
<th>Soldering temp.</th>
<th>Core solder diameter (mm±5)</th>
</tr>
</thead>
<tbody>
<tr>
<td>SR-34 super</td>
<td>LF-M-48 (Sn-3.5Ag-0.5Cu)</td>
<td>217°C to 220°C</td>
<td>0.1, 0.2, 0.3, 0.4, 0.5, 0.6, 0.8, 1.0, 1.2, 1.4</td>
<td></td>
</tr>
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<td>KR-19</td>
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<td></td>
</tr>
<tr>
<td>GUMMIX-19CH</td>
<td>LF-M-48 (Sn-3.5Ag-0.5Cu)</td>
<td>217°C to 220°C</td>
<td>0.1, 0.2, 0.3, 0.4, 0.5, 0.6, 0.8, 1.0, 1.2, 1.4</td>
<td></td>
</tr>
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</table>

Product name component for Core Solders
(Example) SR-34 super LF-M-48 3.5% 0.30
Flux name: alloy type; flux content; core solder diameter

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