



Low residue SnPb(Ag), halide free, no-clean solder wire

Description:

Interflux[®] IF 14-06, 14-09 and 14-14 are low residue SnPb(Ag), no-clean solder wires in different flux contents that contain absolutely no rosin nor halides.

The body of the IF 14 flux can almost fully evaporate during soldering, leaving a minimal residue that can easily be removed by hand (brush). This results in extremely clean solder joints that are very hard to distinguish from wave or reflow soldered solder joints. Furthermore this substantially increases compatibility with conformal coatings compared to conventional solder wires.

IF 14-09 with 0,9% of flux content is a general use solder wire that is suitable for most applications. IF 14-06 is mainly used for soldering SMD components and if extremely low residue

formation is required. IF 14-14 is mainly used for soldering through hole components (with heavy thermal mass) or for faster soldering.

The solder wires are recommended when soldering in **class 3** (IPC-A-610).

The solder wires are classified as RE LO according IPC and EN standards.



Products pictured may differ from the product delivered



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Key properties

- Low non sticky residue, easily removable by hand
- Reduced contamination of tools, equipment, PCBs,...
- No colophony fumes
- Increased compatibility with conformal coatings
- Absolutely halogen free
- Long tip-life
- Long product history

Availability

Flux type: IF 14
Flux content: 0,6—0,9—1,4 % w/w

alloy	melting point	Diameters (mm)						
		0,2	0,35	0,50	0,70	1,00	1,50	2,00
Sn60Pb40	~183°C—191°C		•	•	•	•	•	•
Sn63Pb37	~183°C	•	•	•	•	•	•	•
Sn62Pb36Ag2	~179°C		•	•	•	•	•	•
Sn60Pb38Cu2	~183°C-191°C	•	•	•	•	•	•	•

Note: other diameters upon request

• = available • = upon request





Work Instructions

Manual soldering

The advised working temperature is between 320°C and 360°C. For more dense metals like Nickel, the temperature may be elevated to 400°C. The use of a good soldering station is important. Use a soldering station with a short response time and with enough power for your application. Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact area with the surfaces to be soldered. Heat up both the surfaces simultaneously. Slightly touch with the solder wire, the point where soldering tip and the surfaces to be soldered meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. This will reduce the risk on flux spitting and premature flux consumption!

Handling

Storage

Store the solder wire in a clean environment at ambient temperature.

Handling

To avoid spool and wire damage, handle package with care.

Safety

Please always consult the safety datasheet of the product.



Test results

Conform EN 61190-1-3(2007), IPC J-STD-004(A) and Bellcore

Property	Result	Method
Chemical		
flux designator	RE L0	J-STD-004
	F-SW 33	DIN 8511
	1.2.3	ISO 9454
qualitative copper mirror	pass	J-STD-004 IPC-TM-650 2.3.32
	pass	TR-TSY-000078 13.1.6
qualitative halide		
silver chromate (Cl, Br)	pass	J-STD-004 IPC-TM-650 2.3.33
	pass	TR-TSY-000078 13.1.4
spot test (F)	pass	J-STD-004 IPC-TM-650 2.3.35.1
	pass	TR-TSY-000078 13.1.5
quantitative halide	0,00%	J-STD-004 IPC-TM-650 2.3.35
Environmental		
SIR test	pass	J-STD-004 IPC-TM-650 2.6.3.3
	pass	TA-NWT-000078 13.1.4
qualitative corrosion, flux	pass	J-STD-004 IPC-TM-650 2.6.15
electro chemical migration	pass	TA-NWT-000078 13.1.5



Packaging

The standard packaging is as follows:

For 0,2mm : spool of 10g

For 0,35mm: spool of 100g

For all other diameters: spool of 500g

Other spool sizes upon request

Trade name: IF 14-06 Leaded, Halide Free, No-Clean Solder Wire
IF 14-09 Leaded, Halide Free, No-Clean Solder Wire
IF 14-14 Leaded, Halide Free, No-Clean Solder Wire

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