



## High activation, water soluble solder wire

### Description:

Interflux<sup>®</sup> **Aquasol 4018** for SnPb alloys is a solder wire with water soluble flux residue.

It is highly activated for increased wetting on surfaces that are difficult to solder or degraded and oxidised surfaces.

Aquasol 4018 residue must be cleaned. Cleaning is easily done with demi water of 35— 45°C (95°F— 114°F) with or without the aid of a saponifier.

Aquasol 4018 can be used in both hand soldering and automated soldering processes.

Aquasol 4018 solder wire contains halogens and is classified as OR H1 according to IPC and EN-standards.



Products pictured may differ from the product delivered

## Key properties

- Water soluble flux residue
- High wetting power on surfaces that are difficult to solder.
- Suitable for automated soldering

## Availability

Flux type: IF 4018  
Flux content: 2,5% w/w

		diameters (mm)					
alloy	melting point	0,35	0,50	0,70	1,00	1,50	2,00
Sn63Pb37	~ 183°C	•	•	•	•	•	•

Note: other alloys and 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!

Post solder residue needs to be cleaned. This can be done with demi water of 35— 45°C (95°F— 114°F) with or without the aid of a saponifier.

## 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.

## Packaging

The standard packaging is spool of 500g

Other spool sizes upon request



## Test results

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

Property	Result	Method
<b>Chemical</b>		
flux designator	<b>OR H1</b>	J-STD-004A
	<b>F-SW 25</b>	DIN 8511
	<b>2.1.2</b>	ISO 9454
% halide content	<b>&gt;2%</b>	J-STD-004A IPC-TM-650 2.3.35
<b>Environmental</b>		
SIR test	<b>pass (cleaned)</b>	J-STD-004 IPC-TM-650 2.6.3.3
qualitative corrosion, flux	<b>pass (cleaned)</b>	J-STD-004A IPC-TM-650 2.6.15
electro chemical migration	<b>pass (cleaned)</b>	J-STD-004A IPC-TM-650 2.6.14.1

Trade name: Aquasol 4018 Leaded, Water Soluble Wire

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