



Low residue, lead-free, no-clean and halide free solder wire

**Description:**

Interflux<sup>®</sup> **IF 14-16** is a low residue, no-clean, lead-free, solder wire that contains absolutely no rosin nor halides.

Conventional solder wires tend to carbonise, leaving excessive visible residue. 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 14-16 is recommended when soldering in class 3 (IPC-A-610).

IF 14-16 is classified as RE LO according IPC and EN standards.



Products pictured may differ from the product delivered



**Availability**

Flux type: IF 14  
Flux content: 1,6% w/w (same volume as 1,4% w/w when using Sn63Pb37)

alloy	melting point	diameters (mm)						
		0,20	0,35	0,50	0,70	1,00	1,50	2,00
Sn96,5Ag3Cu0,5	~217°C	●	●	●	●	●	●	●
Sn96,5Ag3,5	~221°C		●	●	●	●	●	●
Sn95,5Ag3,8Cu0,7	~217°C		●	●	●	●	●	●
Sn99Ag0,3Cu0,7	~217°C-227°C		●	●	●	●	●	●
Sn99,3Cu0,7	~227°C		●	●	●	●	●	●
Sn99Q <sup>C</sup> (*)	~232°C			●	●	●	●	●

Note: other alloys and diameters upon request      ● = available   ● = upon request

(\*) Sn99Q<sup>C</sup> is an alloy designated for reworking LMPA<sup>™</sup>-Q solder joints

**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





## Work Instructions

### **Manual soldering**

The advised working temperature is between 320°C and 390°C. For more dense metals like Nickel, the temperature may be elevated to 420°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) and IPC J-STD-004(A)

Property	Result	Method
<b>Chemical</b>		
flux designator	<b>RE LO</b>	J-STD-004
	<b>F-SW 33</b>	DIN 8511
	<b>1.2.3</b>	ISO 9454
qualitative copper mirror	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.32
qualitative halide		
silver chromate (Cl, Br)	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.33
spot test (F)	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.35.1
quantitative halide	<b>0,00%</b>	J-STD-004 IPC-TM-650 2.3.35
<b>Environmental</b>		
SIR test	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.3.3
	<b>pass</b>	TA-NWT-000078 13.1.4
qualitative corrosion, flux	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.15
electro chemical migration	<b>pass</b>	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 : IF14-16 Lead-Free, Halide Free, No-Clean Solder Wire

### Disclaimer

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