



ELSOLD® Cored Solder Wires – general information

Cored solder wire – the oldest solder medium – has been used for many years in the electronic industry. Cored solder wire permits the simultaneous application of solder and flux to the soldering point. Despite development of solder paste which serves the same purpose, cored solder wire has defended its position. It is still preferred for applications such as manual and repair soldering processes and automatic soldering (robot process). ELSOLD® cored solder wire is available in many types and

is unchallenged because of its variety.

Besides the purity of the base metals, the particular innovation is the constant adaptation of solder paste composition to production parameter and process. Rosin and activator must be adapted to higher or changed process temperatures.

ELSOLD® produces top quality Cored Solder wires by choosing suitable flux constituents along with strictly monitored production conditions.

ELSOLD® Cored Solder Wired – Flux types

Flux type	Application
A3	For applications requiring active flux effective on brass, nickel, bronze
C3	Halide free flux for all electronic applications
E1	Extremely temperature stable and splatter-free
3064 3064 BF	For difficult soldering processes, also effective on brass, nickel, bronze
H	Based on carbamide, very effective flux without resin, e.g. for manufacture of transformers and capacitors
T	For heavily oxidised surfaces, resin-free, halogen-activated. Used in the electric bulb industry
FS-28	Strongly activated, halide-free flux for demanding solder work, reduced resin content and low residue
105-19	Resin-free, halogenated, very active, low residue

The list above shows a selection of our most sought-after products.

Of course you can order your alloy with the flux you require.

For custom-made orders, the flux fraction can be selected from 0.5% to 4.5% in steps of 0.5%.

Special dimensions available on request

- Standard coil sizes: 0.10 kg / 0.25 kg / 0.50 kg / 1.00 kg
- Special coil sizes (e.g. 2.5 kg up to 20 kg) available on request
- All cored solder wires are available with a diameter of 0.3 mm upwards
- Diameters are subject to standard tolerances as per DIN 12224-1
- Single or multi-core possible





ELSOLD® Cored Solder Wires

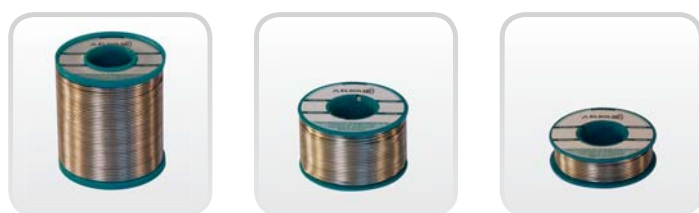
ELSOLD® is one of the leading manufacturers of high quality solder products for all noted processes, including solar technology. ELSOLD® cored solder wires are available in a variety of alloys combined with highly efficient fluxes. The special combination of proven activators and first-class

wetting properties guarantee the very best soldering quality in automatic and manual soldering processes. This also applies to soldering processes in solar technology.

• ELSOLD® Cored Solder Wires with lead

Alloy	Melting Range [°C]	Ø [mm]	Spool sizes [kg]	Flux		DIN EN		Halide content [%]	No Clean	Order number
				-content [%]	-type	29454	61190-1-1			
Sn60Pb39Cu1	183-190	1.00	1	3.5	A3	1.1.2	ROH1	0.75	-	EL01 1421
Sn60Pb39Cu1	183-190	1.00	1	3.5	C3	1.1.3	ROLO	0	✓	EL01 0913
Sn60Pb39Cu1	183-190	2.00	1	3.5	H	2.1.3	ORM0	0	✓	EL01 1742
Sn60Pb39Cu1	183-190	1.50	1	2.2	3064	1.1.2	ROM1	1	✓	EL01 5103
Sn60Pb39Cu1	183-190	1.00	0.50	2.2	3064	1.1.2	ROM1	1	✓	EL01 5122
Sn60Pb40	183-190	0.75	1	2.2	3064	1.1.2	ROM1	1	✓	EL01 5101
Sn60Pb40	183-190	0.75	1	3.5	C3	1.1.3	ROLO	0	✓	EL01 2139
Sn60Pb40	183-190	0.50	1	3.5	A3	1.1.2	ROH1	0.75	-	EL01 2275
Sn63Pb37	183	1.00	1	3.5	C3	1.1.3	ROLO	0	✓	EL01 2483
Sn63Pb37	183	1.00	1	2.2	3064	1.1.2	ROM1	1	✓	EL01 5158
Sn62Pb36Ag2	179	0.75	0.50	2.2	3064	1.1.2	ROM1	1	✓	EL01 5224
Sn60Pb36Ag4	178-180	1.00	1	3.5	C3	1.1.3	ROLO	0	✓	EL01 3425
Pb91Sn8Sb1	280-305	0.80	1	2.5	C2	1.1.3	ROLO	0	✓	EL01 2606
Pb91Sn8Sb1	280-305	1.00	1	1.0	FS-28	1.1.3	RELO	0	✓	EL01 4757

Picture: Cored Solder Wires with lead delivery forms

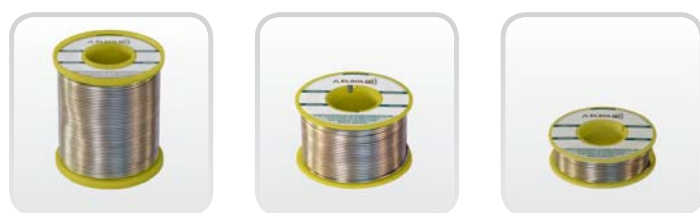


1000 g

500 g

250 g

Picture: Cored Solder Wires lead free delivery forms



1000 g

500 g

250 g





Highlight



Lead-free Solder wire "E1" containing flux

- splatter-free
- longer holding time of soldering tip
- reduction of copper de-alloying
- for all soldering applications
- non-corrosive flux residues
- thermally stable flux
- excellent soldering properties
- fulfils all global standards



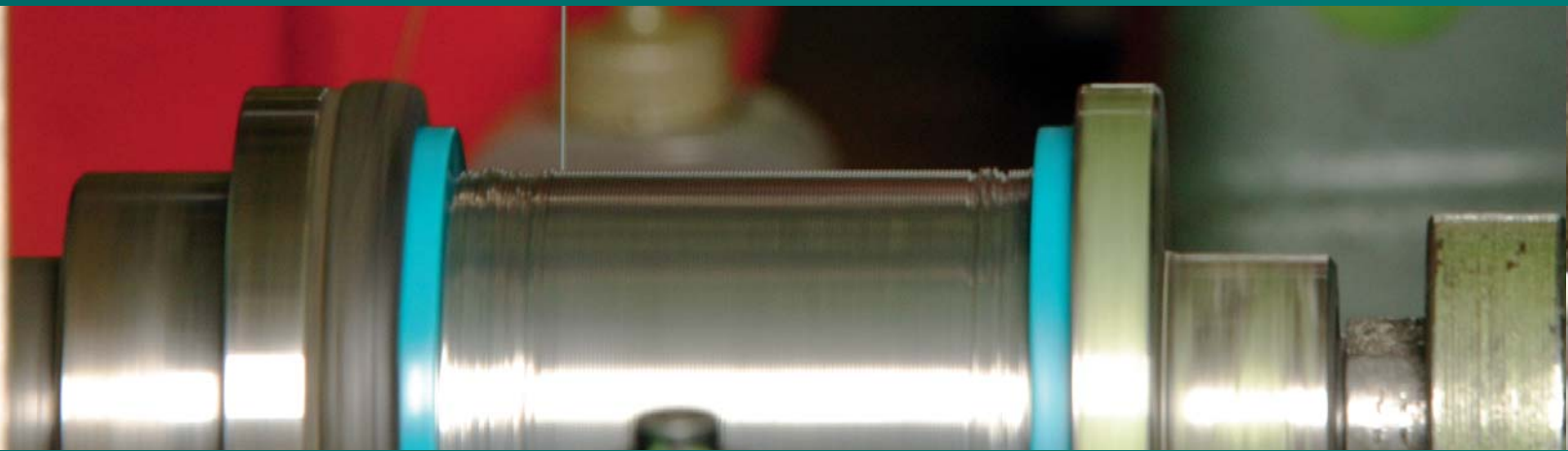
• ELSOLD® Cored Solder Wires, lead-free

Alloy	Melting Range [°C]	Ø [mm]	Spool sizes [kg]	Flux		DIN EN		Halide content [%]	No Clean	Order number
				- content [%]	- type	29454	61190-1-1			
Sn99.3Cu0.7	227	1.00	1.00	2.2	3064BF	1.1.2	ROM1	1	✓	EL02 5283
Sn99.3Cu0.7	227	0.75	1.00	2.5	C3	1.1.3	ROM0	0	✓	EL02 5416
Sn99.3Cu0.7	227	0.75	1.00	3.5	A3	1.1.2	ROH1	0.75	-	EL02 0014
Sn99.3Cu0.7	227	0.60	0.50	1.5	105-19	2.2.2	ORM1	< 2.00	-	EL02 5399
Sn99.3Cu0.7MA	227	0.75	0.50	2.5	E1	1.1.3	REL0	0	✓	EL02 0008
Sn99.3Cu0.7MA	227	0.50	1.00	2.5	E1	1.1.3	REL0	0	✓	EL02 6102
Sn97Cu3	230-250	2.00	3.50	2.0	T	2.2.2	ORM1	< 2.00		EL02 6011
Sn95Sb5	230-240	1.00	1.00	3.5	C3	1.1.3	ROL0	0	✓	EL02 3466
Sn97Ag3	221-230	1.00	1.00	2.2	3064BF	1.1.2	ROM1	1	✓	EL02 0010
Sn96.5Ag3Cu0.5	217-219	1.00	1.00	2.2	3064BF	1.1.2	ROM1	1	✓	EL02 5444
Sn96.5Ag3Cu0.5	217-219	1.00	1.00	2.5	C3	1.1.3	ROL0	0	✓	EL02 5545
Sn96.5Ag3Cu0.5	217-219	0.30	0.25	2.5	C3	1.1.3	ROL0	0	✓	EL02 6046
Sn95.8Ag3.5Cu0.7	217	1.00	1.00	3.5	C3	1.1.3	ROL0	0	✓	EL02 5508
Sn95.8Ag3.5Cu0.7	217	0.75	1.00	2.2	3064	1.1.2	ROM1	1	✓	EL02 5370

All lead-free alloys are available as ELSOLD® MA® (micro-alloyed)

- Your advantages:**
- fine-grained structure facilitates visual inspection
 - low de-alloying of copper allows lead-free tinning of thin wires and circuit paths, multiple joints and repairs
 - Significant cost saving though low chemical attack on material soldering tips and equipment





Highlight



“No-clean” Halide-free Flux Cored Solder wire “C3 Plus” Lead Free

- quick wetting
- low elastic residues
- non-corrosive flux residues
- short soldering time
- reduced copper erosion
- thermal stable flux
- fulfil all global standards
- for all soldering applications
- excellent solderability
- shiny solder joints

Alloy	Melting Range [°C]	Flux		DIN EN		No Clean
		-content [%]	-type	29454	61190-1-1	
Sn99.3Cu0.7	227	**	C3+	1.1.3	ROLO	✓
Sn97Cu3	230-250	**	C3+	1.1.3	ROLO	✓
Sn95Sb5	230-240	**	C3+	1.1.3	ROLO	✓
Sn97Ag3	221-230	**	C3+	1.1.3	ROLO	✓
Sn96.5Ag3Cu0.5	217-219	**	C3+	1.1.3	ROLO	✓
Sn95.8Ag3.5Cu0.7	217	**	C3+	1.1.3	ROLO	✓

- Standard coil sizes:
0.10 kg / 0.25 kg
0.50 kg / 1.00 kg

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(e.g. 2.5 kg up to 20 kg)
available on request

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