

Technical Product Information

Micro-alloyed Solder Wires SN100 MA and SN100 MA-S Type 3064

Flux Classification DIN EN 61190-1-1: ROM1
DIN EN ISO 9454-1: 1123

Flux Content 1.4 % | 2.2 %

Description

ELTIN 3064/3064 BF cored wires excel by virtue of their high activity and – at the same time – very low risk of corrosion. These two factors together make for a wide process window. The activation has been designed such that will show its best performance at the adequate soldering temperature. ELTIN 3064/3064BF cored wires can be used with low flux content, resulting in low residues and a high safety against corrosion. The special composition of the activator guarantees excellent spreading of the solder even with low flux content percentages and yields consistent reproducible soldering results both for manual and automatic soldering.

Flux residues can in most cases remain on the solder joint. ELTIN 3064/3064BF cored wires do not show splashing or unpleasant odours during processing. The requirements of DIN EN 61190-1-1 and DIN EN 29454 regarding corrosion are fulfilled.

ELSOLD SN100 MA und SN100 MA-S are special alloys of high purity, very low oxide content, and highly resistant against oxidation. Abrasion of soldering iron tips is considerably reduced and copper dissolution remarkably reduced. Solder joints appear smooth and bright.

Area of application

ELSOLD cored wires of type ELTIN 3064 BF are suitable for any standard soldering process in electric and electronic industries.

Properties of ELSOLD Alloys SN100 MA und SN100 MA-S

Trade Name	Sn [%]	Cu [%]	Ag [%]	Micro-alloyed Elements	Density [g/cm ³]	Melting point /-range [°C]
ELSOLD SN100 MA	99.3	0,7		Co, Ni, Ce	7.32	227
ELSOLD SN100 MA-S	99.3	0.7		Ni, Ge, P	7.32	227
ELSOLD SN100Ag0.3 MA	99.0	0.7	0.3	Co, Ni, Ce	7.33	217 – 227
ELSOLD SN100Ag0.3 MA-S	99.0	0.7	0.3	Ni, Ge, P	7.33	217 – 227
ELSOLD SN100Ag1.0 MA	98.3	0.7	1	Co, Ni, Ce	7.36	217 – 223
ELSOLD SN100Ag1.0 MA-S	98.3	0.7	1	Ni, Ge, P	7.36	217 – 223
ELSOLD SN100Ag3.0 MA	96.5	0.5	3	Co, Ni, Ce	7.38	217 – 219
ELSOLD SN100Ag3.0 MA-S	96.5	0.5	3	Ni, Ge, P	7.38	217 – 219

Tolerances of alloys (if not stated elsewhere): for alloying elements > 5 % ± 0.5 %
for alloying elements ≤ 5 % ± 0.2 %

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Core Versions available

The standard wires have 1 flux core. Multi-core versions are available upon request.

Diameter and Tolerances

Diameter [mm]	Tolerance [mm]
0.30	± 0.03
0.50	± 0.05
0.75	± 0.05
1.00	± 0.05
1.20	± 0.05
1.50	± 0.05

Spool Dimensions [mm]

	250 – 500 g Spool	1000 g Spool
Flange diameter	69.5	70
Barrel diameter	33.5	33
Bore diameter	30	30
Total width	41.5	78
Traverse	38	68

Packaging Units

Spools à 250 g – 500 g – 1000 g

Colour coding of spools: lead-free solders: neon yellow

Shelf Life

We guarantee a minimum shelf life of 36 months if the material is properly stored in a clean environment. Most likely, ELSOLD cored wires can be used without problems long beyond this period. However, the user should find this out by making appropriate test before using the solder.

Safety and Health

For safety and health information please refer to the relevant material safety data sheet.

Important information: The above information was put together based on the data available to the producer at the time of print. The technical data contained herein are consistent with the properties of the material but should not be used for the preparation of specification as it is intended for reference only.