

SPECIFICATION

NAME : BT-19 LFM-48-S 3,5% Cored Solder Wire

Lot No.	Type
	BT-19 LFM-48-S 3.5% Flux Content 3.5% Dia(mm): 0.2, 0.3, 0.38, 0.5, 0.65, 0.8, 1.0, 1.2, 1.6, 2.0, 2.7

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1. Product Name : BT-19 LFM-48-S 3.5%

2. Scope : This spec. is specified for Almit BT-19 LFM-48-S 3.5% delivered by Nihon Almit Co., Ltd. to Company _____ .

3. Chemical Composition (%) :

Composition	Principal Component			Impurities				
	Sn	Ag	Cu	Pb	Sb	Bi	Zn	Fe
Standard	Remainder	3.0 ±0.2	0.5 ±0.2	≤0.05	≤0.10	≤0.05	≤0.001	≤0.04
Composition	Impurities							
	Al	As	Cd	Co	Ni			
Standard	≤0.001	≤0.03	≤0.002	≤0.02	≤0.02			

4. Physical Properties :

Solidus	Liquidus	Specific Gravity
217°C	221°C	7.4

5. Characteristics :

	Characteristics	Test Methods
Solids Content, Flux (%)	3.5 (3.0 - 4.0)	IPC-TM-650:2.3.34
Copper Mirror Test	Pass	IPC-TM-650:2.3.32
Silver Chromate	Pass	IPC-TM-650:2.3.33
Corrosion Test	Pass	IPC-TM-650:2.6.15
SIR (85°C,85%,168hr, measured out of Chamber) (Ω)	≥ 1×10 ⁹	IPC-TM-650:2.6.3.3
Quantitative Halide	L1<0.5%	IPC-TM-650:2.3.35
Flux materials composition	RE	J-STD-004:1.2

6. Diameter, Net Weight and Allowance:

Diameter (mm)											Net Weight of one Reel (kg)		
0.2	0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	2.0	2.7	0.5	0.8	1.0
±0.05											+0.01 -0		

0.2 mm =0.1 Kg reel

0.3mm – 2.0 mm =0.5 Kg reel

2.7 mm = 1.0 kg reel

7. Lot Size : 500 kgs (amount of single melting)

8. Packing :

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8, 1.0 kg	Plastic Bag	5, 8, 10 kg	Cardboard

9. Identification :

Spool		Cardboard	
Name	BT-19 LFM-48-S 3.5%	Name	BT-19 LFM-48-S 3.5%
Flux Content	3.5%	Flux Content	3.5%
Diameter	mm	Diameter	Ø
Net Weight	Ex. 500 g	Net Weight	Ex. 5 kg
Lot No.	Ex. 04.5.-1	Lot No.	Ex. 04.5.-1
Maker	Nihon Almit Co., Ltd.	Maker	Nihon Almit Co., Ltd.

10. Maker Address :

Nihon Almit Co., Ltd. Productive Engineering Center
8154-227, Uenohara, Kitatsuru-gun, Yamanashi, 409-0112 Japan

11. In case of changing this spec., it must be accepted by _____ .

12. This product is manufactured, using all guaranteed materials according to the "LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES".

13. Shelf Life :

Up to two (2) years from the manufactured date (lot number).