

SPECIFICATION

NAME : SR-34 LFM-22 3,5% Cored Solder Wire

Lot No.	Kind
	SR-34 LFM-22 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 : SR-34 LFM-22 3,5%

2. Scope : This spec. is specified for Almit SR-34 LFM-22 3.5% delivered by Nihon Almit Co., Ltd. to Company _____ .

3. Diameter, Net Weight and Allowance:

Dia (mm)											Net Weight (kg)		
0.2	0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	2.0	2.7	0.1	0.5	0.8
±0.05											+0.01 -0		

0.2mm = 0.1 Kg spool
0.3mm – 2.0 mm = 0.5 Kg spool
2.7mm = 1.0 Kg spool

4. Physical Properties :

Solidus	Liquidus	Specific Gravity
227°C	227°C	7.3

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
Dryness	Pass	JIS Z 3197:1999
Corrosion Test	Pass	IPC-TM-650:2.6.15
SIR (85°C,85%,168hr, measured out of Chamber) (Ω)	≥ 1×10 ⁸	IPC-TM-650:2.6.3.3
Quantitative Halide	M1 <0.5%	IPC-TM-650:2.3.35
Flux materials composition	RE	J-STD-004:1.2

6. Chemical Composition (%) :

Composition	Principal Component		Impurities				
	Sn	Cu	Pb	Sb	Bi	Zn	Fe
Standard	Remainder	0.7 ±0.2	≤0.09	≤0.12	≤0.10	≤0.002	≤0.02
Composition	Impurities						
	Al	As	Cd				
Standard	≤0.002	≤0.03	≤0.002				

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

8. Packing :

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.1, 0.5, 0.8, 1.0 kg	Plastic Bag	1, 5, 8, 10 kg	Cardboard

9. Identification :

Spool		Cardboard	
Name	SR 34 LFM-22 3.5%	Name	SR 34 LFM-22 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).