



SHENZHEN JUFENG SOLDER CO., LTD

Product Instruction

Sn63Pb37 Lead Solder Wire with Flux ORLO



Technical Data Sheet

Material Safety Data Sheet

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Technical Data Sheet

1. Description

The JF solder wire adopts the latest composite formula flux with high technical content and is produced by advanced equipment. In recent years, in order to adapt to the complexity and precision of electronic industry, we have developed a variety of types of soldering wire products in line with modern electronic process conditions for customers to choose. The type of solder wire is suitable for all manual and machine automatic welding, high welding capability for component installation and repair, and all alloys meet J-STD-006A standard. The solder wire is excellent good wettability , forming spots of high strength and no spatter. Very few flux residues are non-corrosive and pass SIR test to achieve defect-free welding.

2. Features

- 1) . Little impurity, diffusion capacity well
- 2) . Weldability, good fatigue resistance
- 3) . Solder joints, solder surface brightness, good wetting
- 4) . Strong antioxidant, anti-creep
- 5) . Increase production speed, reduce production costs
- 6) . Flux ORL0, IPC standard.

3. Alloy Composition

Sn	Pb	Ag	Bi	As	Zn	Fe	Sb	Al	Cd
63±0.	37±0.	<0.0	<0.05	<0.03	<0.00	<0.02	<0.02	<0.02	<0.00
5	5	05			5				2

4. Technical Specifications

NO.	Item	SPEC	Standard
1	Appearance	Smooth surface, no pollution debris	
2	Alloy	Sn63/Pb37	JIS-Z-3282
3	Melting poing	183°C	
4	Flux content	2.0±0.5	JIS-Z-3283
5	Halogen content	< 0.05%	JIS-Z-3197
6	Specific gravity	8.3	
7	Diameter	0.3-0.6mm±0.05mm; 0.8-3.0mm±0.1mm tolerance	JIS-Z-3283
8	Package	12.5g/50g/100g/250g/500g/1.0kg g/2.0kg/3.0kg/roll	
9	Application	Electrical soldering	JIS-Z-3283
10	Storage	Must be placed in a dry and no	

		corrosion and sun exposure environment, shelf life 2 years	
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5. Solderability Test

NO.	Test Item	Test Results	Test Method
1	Diffusivity	≥85%	JIS-Z-3197
2	Copper Mirror	PASS No Breakthrough	IPC-TM-650 , 2.3.32
3	Corrosion	PASS No Corrosion	JIS-Z-3197,6.6.1
4	SIR	PASS $\geq 1.0 \times 10^{12}$	IPC-TM-650,2.6.3.3
5	ECM	PASS $\geq 1.0 \times 10^{12}$ No clean state	IPC-TM-650,2.6.14.1

6, Package :

1000g/coil, 500g/coil,700g/coil, 250g/coil, 200g/coil, 100g/coil, 50g/coil. 20g/coil.

OEM available.

Material Safety Data Sheet

1. Product and Company Identification

Product Name: Lead solder wire
Product Code
Company name: Shenzhen Jufeng Solder Co., LTD
Tel/Fax:0755-89501348 89501292

2. Composition, Information on Ingredients

Component Chemical Name & Common Names: Lead
CAS No.: 7440-31-5
Concentration (Percentage): Sn/Pb 63/37

3. Hazard Identification

<p>Most Important Health Hazards and Reactions</p>	<p>Health Hazards and Reactions: (acute)Inbibe:Too high temperature when melt solder(about 500°C upward),it will produce metal smoke, inbibe it will cause anemia, insomnia, weak, astriction, sick, bellyache. It will be harm the hematogenous enginery. Eat: Sick up. Eye, skin: Melting etal and high temperature touch skin will cause scald.</p> <p>Environmental Impact: Large amount of dust or fumes may cause environmental pollution.</p> <p>/Physical and Chemical Hazards: Excessive dust or fumes may cause skin and organs of the mechanism of stimulation.</p> <p>Specific Hazards: No</p>
<p>Cardinal Symptoms: qualm, headache, puncture, skin allergic.</p>	
<p>Hazard Classification: No.9,other dangerous</p>	

4. First Aid Measures

<p>First Aid Measures for Different Kinds of Exposures:</p> <ul style="list-style-type: none"> ·Inhalation: Move the sufferer to see doctor if breath difficult. ·Skin Contact: Wash affected part with soap and water,watch the
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doctor when the thrill still remain.

'Eye Contact: Wash eyes quitely, and watch the doctor when the thrill still remain.

'Ingestion: Queasy by nurse at once in demand, shouldn' t ahoy anything to the person when he is out of the count.

Most Important Symptoms and Hazard Reactions: Sense of stimulate from skin and apparatus

5. Fire Fighting Measures:

Suitable Extinguishing Media:dolomite ,sodium oxide

Special Hazards in Fire: Forbiding use water,Halid-alkyl fire extinguisher orA,B,or C fire extinguisher.

Special Fire-Fighting Procedures:No

Required Special Protective Equipment for Fire-Fighters: Firemen should wear exposure suit and air tank.

6. Accidental Release Measures

Personal Precautions:Move out all flaring resource,Splashing area airiness plenty,Wearing defend furnishment.

Environmental Precautions: Prevent the power dirt dispel with air and dispel with water,splashing matter put in airtight case.

Methods for Cleaning:Use the tools that can' t cause light and equip

clear up splashing down that prevent the power dirt dispelling in air.

7. Handling and Storage

Handling: Unable recycling material ,Should check the product and scrap up, Handling carefully the empty case that possible remain power dirt or solding and will be dangerous, the person should read all the aphorism and defend measure on the case.

Storage: Keep in airtight case, deposited in cool, dry and airiness area, Prevent physics damage, Away from heat and flaring resource.

8. Exposure Controls, Personal Protection

Engineering Measures: No

Control Parameters:

· Average admit chroma in eight hours every day(TWA)/Average admit chroma in short time(STEL)/High test admit chroma(CEILING): $2\text{mg}/\text{m}^3$

· B EIs: No

Personal Protection Equipment:

· Respiration: Hemihedral prevent power dirt veil (10-50 times exposition) .

· Hand: Wearing all-sided observe press shield when in urgency.

· Eye: Wearing chemical goggle, there are washing eyes in working

area.

·Skin & Body defend: Wearing defend gloves and cleaning long clothing's.

Hygiene Measures: No smoking in working area ,bite and sup. Must washing hands after work and before bit and sup.

9. Physical and Chemical Properties

State of Substance: Metal linear	Appearance: Linear
Color: Silver-gray metal solid	Odor: Monotony
PH Value: Not fit for	Boiling Point: Not fit for
Decomposing Temperature: Not fit for	Flashpoint: Not fit for °F Not fit for °C
for	Test: Not fit for
	Test Methods: Open Slot Closed Slot
Self-Igniting Temperature: Not fit for	Explosion Limits: Not fit for
Vapor Pressure:(21.1°C):0	Vapor Density: No information
Density:7.4/cm ³	Dissolution: Not dissolve in water

10. Stability and Reactivity

Stability: Compose

Possible Hazard Reaction Under Special Conditions:

Conditions to Avoid: Heat, blaze, phogiston and incompatibility matter

Materials to Avoid: Halogen and trioxid, copper nitrate, Peroxide-Na and Kalium, Sulfur and some acid

Hazardous Decomposition Products: No

11. Toxicological Information

Acute Toxicity: No

Local Reactions: No

Sensitivity: No

Chronic or Long Term Toxicity: No

Special Reactions: No information to check

12. Ecological information

Possible Environmental Impact/Environmental Run-offs:

Water poisoning: No

Moving, biology pile: No

13. Disposal considerations

Disposal Methods: Not fit for

No use or remain gas: Not fit for

Urgency status: Not fit for

14. Transport information

International Transportation Regulations: No
UN Reference No.: Not fit for
Domestic Transportation Regulations: Preclusive according operation and notice proceeding about storage, you should read the correlative hint carefully
Special Transportation Methods and Precautions: No

15. Regulatory information

Applicable Regulation: Preclusive according operation and notice proceeding about storage, you should read the correlative hint carefully

16. Other information

Ref. Document	AIR PRODUCTS MSDS, INTERNATIONAL MARITIME DANGEROUS GOODS CODE	
Made By	Title:Director of Quality Department	Name(Signature): Deng Zhenlu
Date Prepared	May 19 th ,2009	Edit Date: Aug 10 th , 2023 Version:5