



Solid Solder Wire for High Reliability Soldering

Product Description

For refill of solder pots that require maximum reliability of solder joints, especially for thru hole and component assembly, only solder of the highest purity is acceptable. Kester does not make any vague claims of understanding solder purity. Only the highest virgin metals are used to make Kester Solder Wire. Complete analyses of Kester Solder Wire prove that every bath conforms to the strictest quality controls in the solder industry.

Maximum Allowed Impurities

Kester Solder Wire meets IPC Specifications J-STD-006C.

Element	Symbol	ANSI/IPC J-STD-006C
Antimony	Sb	¹
Copper	Cu	0.080
Gold	Au	0.050
Aluminum	Al	0.005
Cadmium	Cd	0.002
Zinc	Zn	0.003
Silver	Ag	0.100
Bismuth	Bi	0.100
Arsenic	As	0.030
Iron	Fe	0.020
Nickel	Ni	0.010
Indium	In	0.100

¹ For variation A, B and C alloys, the Sb maximum is 0.50%, 0.20% and 0.05%, respectively per J-STD-006C.

Kester solder purchased directly or through stocking distributors will conform to these requirements. Only highest purity virgin metals are used to make Kester wire. DOD-STD-2000-1A (Soldering Technology High Quality/High Reliability) states that it is the responsibility of the manufacturer to select those materials and processes that will produce acceptable high quality/high reliability products.

RoHS Compliance

Kester does not determine any applicable Restriction of Hazardous Substances (RoHS) exemptions for our lead containing products at the user level.

Availability

Alloy	Melting Point
Sn63Pb37	183° (361°F)
Sn60Pb40	183-190°C (361-374°F)

Other alloy compositions may be available. Consult your local Kester Sales Representative.

Storage and Shelf Life

Kester Solid Solder Wire has no limited shelf life when handled properly. Storage must be in a dry, non-corrosive environment. Over time, the surface of wire may lose its shine and appear a dull shade of gray. This is a surface phenomenon and is not detrimental to product functionality.

The expiration date determined by the date of manufacture printed on the product and Certificate of Analysis will represent the manufacturer's warranty period which is the time frame wherein Kester will replace defective product. Flux-cored solder wires with alloys containing more than 70% lead have a 2 year warranty from the date of manufacture. All other alloys have a 3 year warranty from the date of manufacture.

Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet (SDS) and warning label before using this product.