



Kester Solder Wire For High Reliability Soldering

Product Description

For soldering applications that require maximum reliability of solder joints, especially for surface mounted components, only solder of the highest purity is acceptable. Kester Solder does not make any vague claims of outstanding solder purity. Only the highest virgin metals are used to make Kester Solder Wire. Complete analyses of Kester Solder Wire prove that every batch conforms to the strictest quality control standards in the solder industry.

Maximum Allowed Impurities

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

Element	Symbol	ANSI/IPC J-STD-006A
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-006A.

Kester Solder purchased directly or through stocking distributors will conform to these requirements. Only highest purity virgin metals are used to make Kester Solder 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.

Available Alloys

Alloy	Melting Point
Sn63Pb37	183°C (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. The solder surface may lose its shine and appear a dull shape of gray. This is a surface phenomenon and is not detrimental to product functionality. Flux cored solder wire has a limited shelf life determined by the alloy used in the wire. For alloys containing >70% lead, the shelf life is 2 years from the date of manufacture. Other alloys have a shelf life of 3 years from the date of manufacture.

Health & Safety:

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

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