



kester®

Technical Data Sheet

Acid Cored Wire for Lead-free and Lead Alloy



Product Description

Kester Acid Cored Wire is a highly active inorganic acid type flux developed for general purpose soldering applications where a flux-cored solder wire is desirable. Rapid soldering can be accomplished on all common metals except aluminum and manganese. Acid flux is particularly useful for soldering excessively oxidized metals. Acid Core possesses excellent thermal stability to function under prolonged high temperature conditions as with torch or flame soldering. It is not recommended for electrical or electronic soldering applications due to the corrosive nature of the residue. Under IPC J-STD-004, Acid Cored Wire is classified as INH1.

Performance Characteristics:

- Highest activity available
- Compatible with high temperature alloys
- Easy to clean
- Classified as INH1 per J-STD-004



RoHS Compliance

This product meets the requirements of the RoHS (Restriction of Hazardous Substances) Directive, 2002/95/EC Article 4 for the stated banned substances. (Applies only if this core flux is combined with a lead-free alloy)



Availability

Acid Cored Wire is available in a wide variety of alloys, wire diameters, flux percentages, and roll sizes in both leaded and lead-free alloys. The most common alloys are Sn63Pb37 and Sn60Pb40. Please refer to www.kester.com for more information.

Note: Core size 50, 58 and 66 = 1.1%, 2.2% and 3.3% flux core, respectively.



Process Considerations

Solder iron tip temperatures are most commonly between 315-343°C (600-650°F) for leaded alloys and 371-400°C (700-750°F) for lead-free alloys. Heat both the land area and component lead to be soldered with the iron tip prior to applying the solder wire to land area or component lead. Do not apply the wire directly to the soldering iron tip; doing so will shorten the life of the soldering tip.

Additional liquid flux should only be used as a last resort. Any flux applied to the solder location should be kept to the area of the connection being reworked. If needed, Kester 817 may be used as a compatible liquid flux to aid in reworking soldered joints.



Cleaning

The flux residue after soldering is hygroscopic and corrosive. The work should be allowed to cool undisturbed until the solder solidifies. The flux residue is then removed with a hot water rinse. For more meticulous cleaning requirements, rinse with at 2-10% solution of Kester 5760 Neutralizer followed by a thorough hot water rinse. Please contact Kester Technical Support for further information.



Storage and Warranty Period

Storage must be in a dry, non-corrosive environment between 10-40°C (50-104°F). The surface may lose its shine and appear a dull shade of grey. This is a surface phenomenon and is not detrimental to product functionality. Flux-cored solder wire has a limited warranty period determined by the alloy used in the wire. For alloys containing more than 70% lead, the warranty period is 2 years from the date of manufacture. Other alloys have a warranty period of 3 years 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.