

Solder wire ISO-Core®

“Ultra-Clear“ • “Clear“ • “RA-Clear“



Flux-filled lead-free soft solder wires

Flux residues according to DIN EN 61190-1-1 / IPC J-STD-004

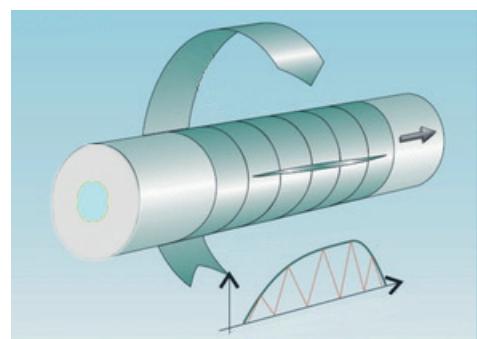
Highly qualified solder wires for manual and automatic soldering in electrical engineering, Electromechanics and electronics. Standard flux ratio 2.2 % / 3.5 %

Thermally stable • splash-free • optimum wetting • crystal-clear residues

ISO-Core	IPC J-STD-004	EN ISO 9454-1	halogen content	resistance test (demanded <8,0 log Ohm)	Type
Ultra-Clear	REL0	1231	0 %	passed - > 11,0 log Ohm	No-clean
Clear	REL1	1222	< 0.15 %	passed - > 11,0 log Ohm	No-clean
RA-Clear	REM1	1223	< 1.2 %	passed - > 10,0 log Ohm	No-clean

Alloy	DIN EN ISO 9453:2014	DIN EN 61190-1-3	Melting range
Sn95,5Ag3,8Cu0,7	Sn95,5Ag3,8Cu0,7	Sn95,5Ag3,8Cu,7	217°C eutectic
Sn96,5Ag3Cu0,5	Sn96,5Ag3Cu0,5	Sn96,5Ag3Cu,5	217 - 219°C
Sn99,3Cu0,7	Sn99,3Cu0,7	Sn99Cu,7	227°C eutectic
Sn100Ni+ / SN100 ⁻⁴⁰³ C	Sn99,25Cu0,7Ni0,05	Sn99,25Cu,7Ni,05	227°C eutectic

100% inline monitoring



Ø in mm 0,25 • 0,50 • 0,75 • 1,00 • 1,50 • 2,00 • 3,00

Spools in kg 0,10 • 0,25 • 0,50 • 1,00 • 5,00 • 10,00

Other alloys, diameters and coil sizes on request.



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High-quality lead-free solder wires for manual and automatic soldering in electrical engineering, electromechanics and electronics. The flux is characterized by **high temperature resistance** and does **not splash** during melting. An **optimal wetting** as well as **values of propagation above the norm** are making these lead-free solder wires to top products among tubular solders.

The new flux formulations „Ultra-Clear“, „Clear“, „RA-Clear“ are based on synthetic resins (free of rosin) and have been perfectly adapted to the new requirements of lead-free soldering technology:

- High wetting speed and spreading on all surfaces commonly used in electronics
- No (painful) flux splashes on the assembly, plant components or hands
- Crystal-clear flux residues to optimize the optical impression
- Minimum outgassing and neutral odour reduce workplace pollution
- Easy removable small residues on soldering tips - these can be removed with conventional means (FELDER Tinner, remove soldering sponge, metal wool)
- **100MΩ-test passed** - can also be used in assembly production
- Service life of the soldering iron tips is noticeably extended

100% inline monitoring • 100% consistent quality

The installation of the new monitoring unit results in outstanding advantages for the product quality:

- Identification of flux interruptions and flux fluctuations
- Optimization of production through continuous inline measurements
- Identification of air inclusions and other wire anomalies
- Continuous monitoring of the wire diameter in 2 axes
- Measuring accuracy is higher by a factor of 10 than the tolerance of the DIN / IPC specifications
- Identification of alloy deviations
- In case of deviations from the standard measured variable, the faulty wire is sorted out

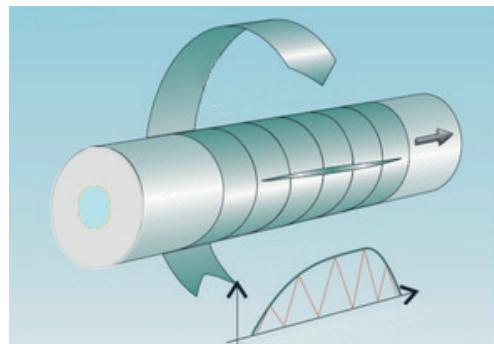
Thus the FELDER-ISO-Core® solder wire is always ready for use:

- Hand and repair soldering
- Automated soldering (robot soldering)

CONCLUSION:

We guarantee product quality without flux interruptions

- **100% flux filled**



 **Made in Germany**

