

Product Information

FELDER ISO-Tin® - SN100-403C4

Lead free soft solder alloy for dip soldering processes over 500° C

Lead-Free FELDER-ISO-Tin® electronic solders do not contain any substances which are subject to restrictions according to directive 2011/65/EG („RoHS“).

Item-No.: 561261....

All information about our products are the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

Application

Lead-free solder for the tinning of copper braids in dip and lift dip soldering units and the dip soldering of lacquered copper braids at spool housings e.g. in transformer construction at high soldering temperatures even over 500° C.

Properties

Due to the Ni-percentage and the increased copper content of our lead-free high temperature solders the de-alloying of copper during the soldering process is significantly reduced in comparison to nickel-free standard solders. This has been explicitly proven by extensive analyses. This also significantly minimises the reduction of the wire cross-section during the soldering process. Copper contents of more than 2.0 % in the solder are not recommended for use in selective soldering systems with mini wave(s), as precipitated copper crystals can block the pump system.

Alloy	Sn100 ⁻⁴⁰³ C4 (Sn96Cu4NiGe)
Melting temperature in °C	227 - 340
Soldering temperature in °C	380 - 540
Density in g/cm ³	7.3

Analysis/Tolerances

Element Content (%)	Sn	Cu	Ag	Ni	Ge	Pb	Au
	Rest	3.5 – 4.5	max. 0.05	0.04 – 0.06	0.005 – 0.007	max. 0.05	max. 0.03

Element Content (%)	Al	As	Bi	Cd	Fe	Sb	Zn
	max. 0.001	max. 0.03	max. 0.03	max. 0.002	max. 0.02	max. 0.05	max. 0.001

Delivery Forms

approx. 400 g – rods, 330 x 20 x 10 mm

approx. 1.0 kg – rods, 330 x 20 x 20 mm

3.5 kg – blocks with hanging hole, 545 x 47 x 20 mm

Deliverable also as solid wire on spools and pellets for first filling.

Storage

Stored at constant indoor climate durable for an unlimited period!