



Product Information

Aluminium Soft Solder Paste Sn97Cu3

Soft solder paste for soldering of aluminium and aluminium alloys
Flux according EN ISO 9454-1 - 2124,
Metal powder content according EN ISO 9453 - Sn97Cu3

Art.-Nr.: 221075..

FELDER Aluminium Soft Solder Paste doesn't contain any substances for which exist restrictions in the directive 2011/65/EU "RoHS II" (lead, cadmium, mercury, hexavalent chromium, PBB resp. PBDE).

Description

FELDER Aluminium Soft Solder Paste is a special soldering paste for soft soldering of pure aluminium and many aluminium alloys (the alloy components should not exceed a total of 1%). Also suitable for soldering aluminium to copper and copper alloys. The paste has an easily dispensable viscosity but is also suitable for other application methods. Good wetting properties and easily removable flux residues. This paste is used in air conditioning and aluminium car body construction.

Characteristics

Alloy according EN ISO 9453	Flux according DIN EN 9454-1	Melting range	Soldering temp.
Sn97Cu3	2124	227 - 310 °C	250 - 300°C

Metall powder content : 75,0 % standard
 Grain size : < 63µ

To ensure a steady quality, the handling temperature should be between 18 and 25 °C.

Application and Washing

Apply the solder paste to the parts to be soldered or tinned and heat gently until the solder powder melts. If necessary, solid solder Sn97Cu3 can be added to reinforce the soldering point or to compensate for unevenness. The flux residues are corrosive and therefore they must be removed completely (100 % water soluble).

Attention: if the paste is overheated, the flux cracks and turns black. A soldered connection is then no longer possible, and the area must be thoroughly cleaned.

Storage Instructions and Shelf Life

Store dry and frost-free. Protect from sun exposure.
 Recommended constant storage temperature : 5-15°C.

Under recommended storage conditions in original packaging 24 months durable.

Package

Deliverable in cartridges, jars or tin buckets.

Please also pay attention to our special solder wire **ISO-Core® "AL" – Lead free!**