



**KHOSLA ENGG.  
PVT. LTD., PUNE.**

## PRODUCT SPECIFICATION

**TITLE: KHOSLA MILDLY  
ACTIVATED AND NON  
CORROSIVE ROSIN FLUX CORE  
LEAD FREE SOLDER WIRE**

Ref No. : PDS/927  
ISSUE NO. : 01  
REV. NO. : 0  
DATE : 19.07.2016  
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**1. SCOPE:** This solders covers the Khosla Mildly Activated And Non Corrosive Rosin Flux Core Lead Free Solder Wire to avoid environmental hazardous lead.

**2. GENERAL:** Rosin core lead free solder wire is manufactured from virgin quality to non-ferrous metal. Rosin will be of water white grade. Also the flux will be non-corrosive and mildly activated in nature, making the cleaning operation after soldering redundant other than for aesthetic purposes. The application of this solder wire is vast in industries like PCB Assembly, Electronic.

**3. CHEMICAL COMPOSITION:**

ALLOY	% Sn	% Ag	% Cu	MELTING POINTS/RANGE °C
Sn 99.3 Cu0.7	99.3 ±0.2 %	--	0.7 ±0.2 %	227°C - 228°C
Sn 96.5 Ag3 Cu 0.5	96.5 ±0.2 %	3±0.2 %	0.5 ±0.2 %	217°C - 218°C

The specified tin percent is maintained within 0.5%. Also total max. impurities are controlled within 0.25%.

**4. IMPURITIES :**

The maximum impurity levels will be as below : As per J-STD-006c

Element	% of Element
Antimony	0.200%
Arsenic	0.030%
Iron	0.020%
Bismuth	0.01%
Aluminum	0.005%
Zinc	0.003%
Cadmium	0.002%
Lead	0.080%
Others	0.050%

**5. FLUX :**

The core flux will be of mildly activated and non-corrosive type. Water White grade rosin shall contain an activating agent evenly distributed there in. The activator shall not contain more than 0.5 % by mass of halogen, calculated as chlorine. The activating agents will be of organic type. The flux shall be homogenous and uniformly distributed throughout the tudinal axis of wire. The activated and non activated types of rosin flux core wires are also available but only on customer request.

**6. FLUX PERCENTAGE:**

The mass of rosin flux in the core of Solder Wire, commonly termed as flux percentage shall be 1.9 to 3 percent of total mass flux core Solder Wire. If flux percent specified by customer it will be maintained within ± 0.2% tolerance.



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**7.CORE:** The core of Solder wire shall of single, three or five core.



**Single core**



**Three core**



**Five core**

**8.SIZE :** Lead Free Flux Core Solder Wires supplied in 10swg to 22swg.

**9. HANDLING AND STORAGE :** 500gm spools or as per customer specification and further labeled prior to be storage.

**10. SHELF-LIFE:** This Solder wire has infinite shelf life.

**11. SPECIAL INSTRUCTION:** Correct Alloy should be selected depending on the application.

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**Approved By :**  
Vice President (Ops.)

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