



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

PRODUCT SPECIFICATION

**TITLE: UREA BASED
SUPER DELUXE QUALITY
SOLDER WIRE.**

Ref No. :PDS/908

ISSUE NO. : 1

REV. NO. : 0

DATE : 19.07.2016

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1. SCOPE: This specification covers the requirement of 'Khosla' Super Deluxe Quality Urea Cored Solder Wire of all the composition of Solder Wire.

2. GENERAL: Urea cored solder wire will be manufactured from virgin quality non-ferrous metal alloys. urea will be of C.P. grade type. the application of this solder wire is used in vast industries like various types capacitor manufacturers. The specialty of urea flux is that it does not contaminate oil of capacitors and does not affect its electrical parameters.

3. CHEMICAL COMPOSITION:

The chemical composition of solder alloy will be as below: As per IS 1921:2005, SI 193, BS EN 29453 & J-std 006A

Sr. No.	Alloy/Composition	% of Tin	% of Lead	Melting Range (°c)
1	50/50 (Sn/Pb)	50 ± 0.5%	Remainder	183-212
2	60/40 (Sn/Pb)	60 ± 0.5%	Remainder	183-188
3	63/37 (Sn/Pb)	63 ± 0.5%	Remainder	183

4. IMPURITIES :

The maximum impurity levels will be as below : As per IS 1921:2005, SI 193, BS EN 29453 & J-std 006A

Element	% of Element
Antimony	0.2%
Copper	0.1%
Arsenic	0.05%
Bismuth	0.10%
Iron	0.02%
Aluminum	0.001%
Zinc	0.005%
Cadmium	0.005%
Others	0.08%

5. FLUX PERCENTAGE: The mass of urea flux in the core solder wire commonly termed as flux percentage shall be 1 to 4 percent of total mass of flux solder wire. If the percentage specified by the customer, it will be maintained with ± 0.2% tolerance. Also the flux is corrosive and activated in nature.



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6. CORE: Core of this Solder Wire shall be single, three or five core.



Single core



Three core



Five core

7. FLUX: The flux residue shall be white / transparent in color.

8. ACCEPTANCE CRITERIA:

- Flux % : Customer required/Specified $\pm 0.2\%$.
- Surface Finish (Shine) : No burr, marking or cracks as per approved sample.

9. CLEANING: For applications other than oil filled capacitors, cleaning with water/ solvent is required.

10. HANDLING AND STORAGE:

- This urea core solder wire is wound on spools of 50 gm, 500 gm, and 3 kg or as per customer requirement and further labeled prior to be storage.
This Solder Wire to be stored in finish good stored.

11. SHELF LIFE: This solder wire has infinite shelf life.

Prepared By :
HOD Q.A.

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Approved By :
Vice President (Ops.)

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