

TECHNICAL DATA SHEET



Autosol Cored Solder Wire

Manual and Automated Soldering

Description

Autosol is a unique flux core contained in Warton's High Purity Solder Wire. It is a precision manufactured solder wire dedicated for manual (hand soldering), automated and high-speed soldering applications. Autosol is available in four formulations (RMA, RA, SRA and RM10) and offers efficient soldering of Copper, Brass, Nickel and Zinc. Applications include lamp and Component technology and sensitive electronic assembly.

Benefits

- Clear Residues
- High Speed Soldering
- 4 Formulations: RMA, RA, SRA and RM10
- Excellent for Copper, Brass, Nickel and Zinc

Classification

Flux	J-STD-004A	J-STD-004B	J-STD-004B (Amendment 1)
Autosol RMA	ROL0	ROL1	ROM1
Autosol RA	ROL1	ROM1	ROM1
Autosol SRA	ROM1	ROM1	ROM1
Autosol RM10	ROL1	ROM1	ROM1

Properties

Surface Insulation Resistance (J-STD-004B) (IPC-TM-650 2.6.3)	Pass
Electro Migration (Bellcore GR-78) (IPC-TM-650 2.6.14)	Pass
Copper Mirror Test (J-STD-004A/B) (IPC-TM-650 2.3.32)	Pass
Copper Corrosion Test (J-STD-004A/B) (IPC-TM-650 2.6.15)	Pass

Availability

Product	Flux Content	Standard Packaging
Autosol RMA	1%, 2% and 3%	0.25Kg, 0.5Kg, 2.5Kg, 3Kg, 5Kg, 10Kg, 15Kg and 25Kg reels
Autosol RA	1%, 2% and 3%	0.25Kg, 0.5Kg, 2.5Kg, 3Kg, 5Kg, 10Kg, 15Kg and 25Kg reels
Autosol SRA	1%, 2% and 3%	0.25Kg, 0.5Kg, 2.5Kg, 3Kg, 5Kg, 10Kg, 15Kg and 25Kg reels
Autosol RM10	1%, 2% and 3%	0.25Kg, 0.5Kg, 2.5Kg, 3Kg, 5Kg, 10Kg, 15Kg and 25Kg reels

Other packaging options available. For more information on alternate packaging options please contact our sales team.

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High Purity Solder Alloy

Standardization is important to reduce variety and to promote the quality of products by defining features and characteristics governing their fitness for purpose. The standards promote clear unambiguous communication between purchasers and suppliers for quotation ordering and supply purposes.

In 1994 a single European standard, EN 29453 (ISO 9453), superseded all other European national standards including: BS 219, DIN 1707, NFC 90-550. Other equivalent international standards include J-STD-006, ASTM B32 and JIS-Z-3382.

Warton High Purity Solder Alloys are manufactured using only the 'Highest Purity Virgin Materials' this being part of Warton's simple philosophy that the best raw materials lead to the best finished products.

Below shows a typical batch analysis of the High Purity Tin/Lead used in manufacturing High Purity 63/37.

Typical batch analysis: Tin

Sn	Sb	Pb	Cu	Zn
99.95	0.009	0.002	0.0002	0.0001
Fe	As	Ag	Bi	In
0.002	0.002	0.0001	0.0001	0.0003

Typical batch analysis: Lead

Sn	Sb	Pb	Cu	Zn
0.001	0.002	99.99	0.003	0.0001
Fe	As	Ag	Bi	In
0.002	0.0005	0.002	0.005	0.0003

Typical batch analysis: Warton High Purity 63/37

Sn	Sb	Pb	Cu	Zn	Fe	As	Ag	Bi	In
63.0	0.0095	remainder	0.0007	0.0002	0.002	0.001	0.0005	0.0003	0.0003

These consistent high standards apply not only to all of Warton's high purity solder alloys, but to its entire range of products, inclusive of flux cored and solid solders, liquid fluxes, cleaners and solder paste.

Lead Free Solder Alloys

In accordance with REACH legislation and increasing environmental awareness Warton Metals offer a complete range of 'lead free' alloys to suit all applications.

Warton's range of lead free solder alloys includes:

Alloy Name	Alloy Breakdown	Melting Temperature °C
Tin	Sn100	232
96S	Sn96.5/Ag3.5	221
96/4	Sn96/Ag4	221
98S	Sn98/Ag2	221-226
TSC	Sn95.8/Ag3.5/Cu0.7	217-218
SAC405	Sn95.5/Ag4/Cu0.5	217-219
Sc100e	Cu0.5-0.7/Sn Remainer	217-219
LM10A	Sn87/Ag10/Cu3	214-275
SACXP0307	Sn/Cu0.7/Ag0.3	217-227
SAC305	Sn96.5/Ag3/Cu0.5	217-220
SAC300	Sn97/Ag3	221-224
SAC3	Sn96.7/Ag2.8/Cu0.5	217-220
SAC2	Sn97.5/Ag2/Cu0.5	217-220
SAC1	Sn99.2/Ag0.3/Cu0.5	217-220
97C	Sn97/Cu3	227-310
99C	Sn99.3/Cu0.7	227
95A	Sb4.5-5.5/Sn Remainder	235-240

Key: Sn-Tin, Ag-Silver, Cu-Copper

Other alloys available

Leaded Solder Alloys

Warton are able to offer a comprehensive range of leaded solder alloys to 'Professional Users' which will be marked as **For Professional Use Only** in accordance with REACH regulations.

Warton's range of leaded solder alloys includes:

Alloy Name	Alloy Breakdown	Melting Temperature °C
60/40	Sn60/Pb40	183-190
63/37	Sn63/Pb37	183
50/50	Sn50/Pb50	183-215
45/55	Sn45/Pb55	183-226
40/60	Sn40/Pb60	183-238
35/65	Sn35/Pb65	183-245
30/70	Sn30/Pb70	183-255
20/80	Sn20/Pb80	183-280
Alloy 296 HMP	Sn5/Pb92/Ag3	296-301
15/85	Sn15/Pb85	226-290
LMP 62S	Sn62/Pb36/Ag2	179
TLS/5	Sn5/Pb94/Ag1	296-301
HMP 5S	Sn5/Pb93.5/Ag1.5	296-301
Sn10Pb88Ag2	Sn10/Pb88/Ag2	268-290
Alloy No1	Sn50/Pb48.6/Cu1.4	183-215
Alloy No2	Sn60/Pb38.2/Cu1.8	183-190
1/99	Sn1/Pb99	300
60/40 Ant	Sn60/Sb0.2-0.5/Pb Rem	183-188

Key: Sn-Tin, Pb-Lead, Ag-Silver, Cu-Copper, Sb-Antimony

Other alloys available

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Wire gauge (Diameter)

The wire gauge (diameter) for Warton solid and flux cored solder wires is represented as SWG (Standard Wire Gauge). The equivalent imperial and metric values are shown below.

SWG	mm	Inch
10	3.25	0.128
11	2.95	0.116
12	2.64	0.104
13	2.34	0.092
14	2.03	0.080
16	1.63	0.064
18	1.22	0.04
20	0.914	0.036
21	0.813	0.032
22	0.711	0.028
24	0.599	0.022
26	0.457	0.018
28	0.375	0.014
30	0.315	0.012
32	0.274	0.010

Other wire diameters available



The information supplied in this technical data sheet is designed only as guidance for the safe use and handling of the product. This information is correct to the best of our knowledge and belief at the date of publication however no guarantee is made to its accuracy. This information related only to the specific material designated and may not be valid for such material used in combination with any other materials or in any other process.