

Flux classification DIN EN 61190-1-1: ROM1
 DIN EN 29454: 1.1.2.

Flux content 2.2 % (standard), 1.4% (optional)

ELTIN 3064 BF is the version for lead-free solders.

■ Description

ELTIN 3064/3064 BF cored wires excel by virtue of their high activity and – at the same time –very low risk of corrosion. These two factors together make for a wide process window. The activation has been designed such that will show its best performance at the adequate soldering temperature. ELTIN 3064/3064BF cored wires can be used with low flux content, resulting in low residues and a high safety against corrosion. The special composition of the activator guarantees excellent spreading of the solder even with low flux content percentages and yields consistent reproducible soldering results both for manual and automatic soldering

Flux residues can in most cases remain on the solder joint. ELTIN 3064/3064BF cored wires do not show splashing or unpleasant odours during processing. The requirements of DIN EN 61190-1-1 and DIN EN 29454 regarding corrosion are fulfilled

■ Areas of Application

ELTIN 3064/3064BF is well suited for all conventional soldering processes in the electrical and electronic industry. Alloy tolerances, if not stated otherwise, for elements > 5 %: ± 0.5 % for elements ≤ 5 %: ± 0.2 %. Impurities meet requirements of EN61190-1-3 / ISO 9454 and ELSOLD house norms.

SnPb-based ELSOLD Standard Alloys:

Alloy	Sn %	Pb %	Ag %	Cu %	Density g/cm ³	Melting Point / Range °C
Sn60Pb40	60	Rem.			8.5	183-190
Sn60Pb39Cu1	60	Rem.		1.2 - 1.6	8.5	183-190
Sn62Pb36Ag2	62	Rem.	2		8.4	178-180
Sn60Pb36Ag4	60	Rem.	4		8.5	178-180
Sn63Pb37	63	Rem.			8.4	183

Lead-free ELSOLD Standard Alloys:

Trade Name	Sn %	Ag %	Cu %	Density g/cm ³	Melting Point / Range °C
ELSOLD SC07	99.3		0.7	7.32	227
ELSOLD SA35	96.5	3.5		7.35	221
ELSOLD SAC0307	99.0	0.3	0.7	7.33	217 - 227
ELSOLD SAC305	96.5	2.8 – 3.0	0.5	7.37	217 – 219
ELSOLD SAC3507	95.8	3.5	0.7	7.40	217 – 219

Special ELSOLD® Alloys

Trade Name	Sn %	Ag %	In %	Sb %	Density g/cm ³	Melting Point / Range °C
Sn95Sb5	95.0			5.0	7.25	232 - 240
ELSOLD W2	95.0	4.88	0.12		7.3	220 - 235

ELSOLD solder wire type 3064BF is also available with ELSOLD® micro-alloyed Solders SN100(Ag) MA and SN100(Ag) MA-S.

■ Core Versions available

The standard wires have 1 core. Multi-core versions are available upon request.

■ Diameters and Tolerances

Diameter [mm]	Tolerances [mm]
0.30	± 0.03
0.50	± 0.05
0.75	± 0.05
1.00	± 0.05
1.20	± 0.05
1.50	± 0.05
2.00	± 0.05

■ Packaging Units

Spools of 250 g – 500 g – 1000 g

Colour coding of spools:	SnPb solders:	teal
	Lead-free solders:	neon yellow

■ Spool dimensions [mm]

	250 - 500 g Spool	1000 g Spool
Flange diameter	69.5	70
Barrel diameter	33.5	33
Bore diameter	30	30
Total width	41.5	78
Traverse	38	68

■ Shelf-life

We guarantee a minimum shelf live of 12 months if the material is properly stored in a clean environment. Most likely, ELSOLD cored wires can be used without problems long beyond this period. However, the user should find this out by making appropriate test before using the solder

■ Safety and Health

For safety and health information please refer to the relevant material safety data sheet.

Important information: The above information was put together based on the data available to the producer at the time of print. The technical data contained herein are consistent with the properties of the material but should not be used for the preparation of specifications as it is intended for reference only.