

***LEAD-FREE SOLDERS
for WAVE SOLDERING
Compared to Leaded Alloys***

<u>Alloy</u>	<u>Melting Point</u>	<u>Wetting Time(Sec)</u>	<u>Max. Wetting Force (uN/mm)</u>	<u>Suggested Solder Pot Temp. Range</u>
<i>63Sn/37Pb</i>	<i>361F</i>	<i>1.76</i>	<i>184</i>	<i>450-520F</i>
96.5Sn/3.5Ag	430F	0.69	312	500-530F
99.3Sn/0.7Cu	441F	0.96	299	510-530F
95.5Sn/4.0Ag/0.5Cu	419-424F	0.75	317	520-530F
10Sn/90Pb	514-576F	N/A	N/A	650-750F
95Sn/5Sb	450-464F	N/A	N/A	520-550F

Lowest/fastest wetting time is desired; data is based on 15 replicates of clean copper coupons and RF800 Flux. Higher maximum wetting force is desired.