

TECHNI-PRO

Product Data Sheet

Techni-Pro Rosin Cored Wire

Part Number 10322836

Product Information

Techni-Pro Rosin Cored Wire is formulated for use in flux-cored solder wire. The high quality rosin and activators in the flux allow for outstanding performance with instant action and wetting characteristics, while still conforming to the highest reliability standards. The high mobility and fast wetting action results in more reliable circuits in production line soldering and touch-up soldering, and the moderate activity of the flux provides excellent fluxing ability across a variety of alloys, purposed, and degrees of oxidation. This cored flux meets the specifications of the joint industry standard J-STD-004 as a ROM1 type flux.

Techni-Pro Rosin Cored Wire is designed for general use in electronics and industrial applications when use of a moderately active flux is required to achieve optimal solderability. In some cases, cleaning may not be required, but generally cleaning is recommended. If cleaning is performed, such as when soldering critical components, cleaning will yield high surface insulation resistance (SIR) values.

Key Benefits

- Classified as ROM1 per J-STD-004
- Excellent solderability with a wide variety of alloys and surfaces
- Compatible with lead and lead-free solders
- Cleans to high SIR values

Process Recommendations

It is recommended that the soldering tip temperature should be between 500-700 °F (260-370 °C) when soldering with leaded alloys such as Sn/Pb 63/37 and Sn/Pb/Ag 62/36/2 alloys. Soldering tip temperature should be maintained at 600-750 °F (315-400 °C) when soldering with lead-free alloys.

For the best soldering results, heat both the land area and the component lead to be soldered with the iron before adding the Techni-Pro Rosin Cored Wire. To prevent excessive spattering and other solder defects, the wire should be supplied from the component side, not the soldering tip.

Physical Properties

Brand	Techni-Pro
Class (J-STD-004)	ROM1
Appearance	Translucent residue
Color	Amber
Acid Value (mg KOH)	175.0 ± 5.0
Area of Spread (Copper)	355 mm ²

Test Data / Reliability

Copper Mirror	"M"
Fluoride Test	Pass
SIR, cleaned	2.2 x 10 ¹⁰

Rev. MAR26

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Cleaning

In most cases, the residues left behind by the Techni-Pro Rosin Cored Wire will require cleaning. If not cleaning, such as when soldering non-critical component, the residues left behind are non-hygroscopic, and the residue acts as a conformal coating which protects the assembly from moisture.

Availability

Techni-Pro Rosin Cored Wire is available in a wide variety of alloys, wire diameters, and flux percentages. The standard wire diameter for most applications is 0.031 inches (1.00mm). Wire diameters are available from 0.020 – 0.250 inches. The amount of flux in the cored wire dictates the ease of soldering for an application. Flux percentages are available from 1-3.3%, with 2 or 2.2% being typical. Amerway cored solder can be packaged on a variety of spool sizes and weights to accommodate a wide variety of purposes and applications.

Storage and Handling

Storage must be in a dry, non-corrosive environment. The shelf life of the cored wire is five years from the date of manufacture when stored in an appropriate, controlled environment. Over time, the surface of the solder may appear to appear a dull shade of gray and lose its luster. This surface phenomenon is not detrimental to the functionality of the product and does not in any way indicate the condition of the product.

Safety

When in use, this product has the potential to be hazardous to human health and the environment. Read all Safety Data Sheet information before use, and never use this product for any purpose other than its intended application.

Disclaimer: The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills, at their own discretion and risk. Since conditions of use are outside of Techni-Pro's control, we cannot assume liability for results obtained or damages incurred through the application or data presented, nor can we assume customers of liability.

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