

## Specifications for Asahi Sn63Pb37 (HF532) Core Wire

|  |                               |                                 |
|--|-------------------------------|---------------------------------|
| <b>1) Alloy Composition:</b>               | <b>Sn63Pb37</b>               |                                 |
| <b>Standard</b>                            | <b>JIS Z 3282: 2006 (Wt%)</b> |                                 |
| Sn   | 63 +/- 0.5                    |                                 |
| Pb   | Remainder                     |                                 |
| Sb   | 0.20 max                      |                                 |
| Bi   | 0.10 max                      |                                 |
| Cd   | 0.002 max                     |                                 |
| Cu   | 0.08 max                      |                                 |
| Au   | 0.05 max                      |                                 |
| In   | 0.10 max                      |                                 |
| Ag   | 0.10 max                      |                                 |
| Al   | 0.001 max                     |                                 |
| As   | 0.03 max                      |                                 |
| Fe   | 0.02 max                      |                                 |
| Ni   | 0.01 max                      |                                 |
| Zn   | 0.001 max                     |                                 |
| <b>2) Physical Characteristics:</b>        |                               |                                 |
| Specific Gravity                           | 8.42                          |                                 |
| Liquidus Temperature                       | 183 °C                        |                                 |
| Solidus Temperature                        | 183 °C                        |                                 |
| <b>3) Core Flux Characteristics:</b>       |                               |                                 |
| Flux Activity Classification               | <b>Specifications</b>         | <b>Standards / Test Methods</b> |
| Flux Content (wt%)                         | ROM0                          | IPC J-STD-004A                  |
| Silver Chromate Test                       | 2.3 +/- 0.3                   | Singapore Asahi                 |
| Copper Mirror Test                         | Halide Absent                 | IPC-TM-650 2.3.33               |
| Spread Factor                              | Classified as "M",            | JIS Z 3197: 1999 8.1.4.2.3      |
| Surface Insulation Resistance              | Pass                          | IPC-TM-650 2.3.32               |
| (85°C / 85 %RH)                            | >75% (Sn63Pb37)               | JIS Z 3197: 1999 8.4.2          |
| Water Extract Resistivity                  | >1 x 10 <sup>8</sup> Ω        | JIS Z 3197: 1999 8.3.1.1        |
|  | >1 x 10 <sup>11</sup> Ω       | IPC-TM-650 2.6.3.3              |
|  | >1 x 10 <sup>4</sup> Ω-cm     | JIS Z 3197: 1999 8.5.4          |
|  |                               | JIS Z 3197: 1999 8.1.1          |
| <b>4) Standard Packing:</b>                |                               |                                 |
| ( ) 0.25 kg per roll. 100 rolls per carton |                               |                                 |
| ( ) 0.5 kg per roll. 50 rolls per carton.  |                               |                                 |
| ( ) 1 kg per roll. 20 rolls per carton.    |                               |                                 |

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