

4.Rework or Repair

It is essential that any repairs or rework be carried out using lead-free solder also. This means it is necessary to be sure which solder has been used before attempting to rework it. Usually this is clearly marked on a module or PCB.

The alloys used in lead-free solder can vary depending on the application, but it is safe to use the 99C alloy (99.7% tin, 0.3% copper) for all lead-free hand soldering as this is compatible with all lead-free alloy options. A trace of silver is added to some lead-free solder pastes to assist with the wetting and joint formation during the rapid reflow phase of typical SMT assembly processes, but even re-working these joints is quite safe using the 99C alloy.

Further Assistance

For any further assistance or technical support, please contact your local Farnell InOne technical sales team.

338612

Lead Free Alloy, Rosin Flux



- Lead free
- Contains multiple cores of rosin based flux
- Amber coloured (rosin) residues do not require cleaning
- For all general purpose lead-free electronic assembly and re-work applications

- Complies with all lead-free legislative requirements

Alloy Lead Free 99.3% Tin (Sn), 0.7% Copper (Cu) Alloy Melting Temperature 227°C Tip Temperature (Approx.) 350°C

338630

Weight	Wire Diameter	Order Code	Price Per Reel	
			1+	10+
250g Reels	0.5mm	507-1290	1,037.00	962.00
	0.7mm	507-1306	806.00	747.00
	0.9mm	507-1318	774.00	717.00
	1.2mm	507-1320	693.00	643.00
500g Reels	0.7mm	507-1343	1,349.00	1,251.00
	0.9mm	507-1355	1,312.00	1,217.00
	1.2mm	507-1367	1,147.00	1,063.00

Lead Free Alloy, No-Clean Flux



- Halide free (Zero activation) flux formulation
- Low fuming and low spitting
- Minimal clear residues do not require cleaning
- Complies with all lead-free legislative requirements

- Suitable for high solderability, lead-free, no-clean assembly, or rework of PCBs assembled in a lead-free no-clean process or that have already been cleaned

Alloy 99.3% Tin (Sn), 0.7% Copper (Cu) Alloy Melting Temperature 227°C Tip Temperature (Approx.) 350°C

338631

Weight	Wire Diameter	Order Code	Price Per Reel	
			1+	10+
250g Reels	0.5mm	507-1379	999.00	927.00
	0.7mm	507-1380	739.00	686.00
	0.9mm	507-1392	721.00	668.00
	1.2mm	507-1409	696.00	646.00
500g Reels	0.7mm	507-1422	1,357.00	1,259.00
	0.9mm	507-1434	1,316.00	1,220.00
	1.2mm	507-1446	1,270.00	1,179.00

Lead-Free Alloy, High Activity Rosin Flux



- Contains multiple cores of halide-free rosin based flux
- Pale coloured residues do not require cleaning
- Extra wetting ability for faster soldering
- For all general purpose lead-free electronic assembly and re-work applications
- Complies with all lead-free legislative requirements

Alloy Lead Free, 99.3% Tin (Sn), 0.7% Copper (Cu) Alloy Flux Type Halide-Free Rosin Based Flux. Type 511 Melting Temperature 227°C Tip Temperature (Approx.) 350°C - 370°C

339057

Weight	Wire Diameter	Order Code	Price Per Reel	
			1+	10+
250g Reels	0.5mm	509-0593	882.00	812.00
	0.7mm	509-0600	673.00	618.00
	0.9mm	509-0611	659.00	606.00
	1.2mm	509-0623	633.00	583.00
500g Reels	0.7mm	509-0647	1,249.00	1,150.00
	0.9mm	509-0659	1,213.00	1,116.00
	1.2mm	509-0660	1,164.00	1,071.00

Lead Free Alloy, Mildly Activated No-Clean Flux



- Mildly activated no-clean flux formulation
- Increased flux content (3% by weight) - low fuming and low spitting
- Minimal clear residues no not require cleaning
- Complies with all lead-free legislative requirements

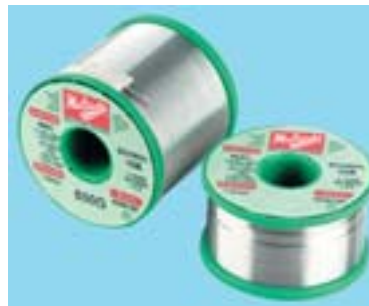
- Suitable for general lead-free, no-clean assembly, or rework of PCBs assembled in a lead-free no-clean process

Alloy Lead Free, 99.3% Tin (Sn), 0.7% Copper (Cu) Alloy Melting Temperature 227°C Flux Type Mildly Activated No-Clean. Type 505 Tip Temperature (Approx.) 350°C - 370°C

339059

Weight	Wire Diameter	Order Code	Price Per Reel	
			1+	10+
250g Reels	0.5mm	509-0672	711.00	692.00
	0.7mm	509-0684	611.00	562.00
	0.9mm	509-0696	590.00	544.00
	1.2mm	509-0702	570.00	524.00
500g Reels	0.7mm	509-0726	1,179.00	1,085.00
	0.9mm	509-0738	1,143.00	1,053.00
	1.2mm	509-0740	1,107.00	1,018.00

Lead Free (99C) Alloy, 309 Rosin Flux



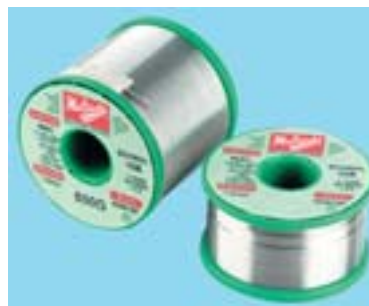
- Pale coloured residues do not require cleaning
- Extra wetting ability for faster soldering
- For all general purpose lead-free electronic assembly and re-work applications
- Complies with all lead-free legislative requirements

Alloy Lead Free, 99.3% Tin, 0.7% Copper Alloy Flux Type Five cores of Halide-free, non-corrosive 309 Rosin Based Melting Temperature 227°C Tip Temperature (Approx.) 350°C - 370°C

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Weight	Wire Diameter	Order Code	Price Per Reel	
			1+	10+
250g Reels	0.5mm	509-0866	1,194.00	1,085.00
	0.7mm	509-0878	909.00	826.00
	0.9mm	509-0880	890.00	810.00
500g Reels	0.7mm	509-0910	1,691.00	1,537.00
	0.9mm	509-0921	1,640.00	1,490.00
	1.2mm	509-0933	1,576.00	1,432.00

Lead Free (99C) Alloy, X39 No-Clean Flux



- Halide free (Zero activation) flux formulation
- Low flux content (1% by weight) - low fuming and low spitting
- Minimal clear residues no not require cleaning
- Complies with all lead-free legislative requirements
- Flux residues meet reliability requirements of Bellcore and IPC Class 3 specifications

- Suitable for high solderability, lead-free, no-clean assembly, or rework of PCBs assembled in a lead-free no-clean process or that have already been cleaned

Alloy Lead Free, 99.3% Tin, 0.7% Copper Alloy Flux Type Halide Free (Zero Activation), No clean Melting Temperature 227°C Tip Temperature (Approx.) 350°C - 370°C

Soldering

25

Compliant
Non-compliant
+ Limited stock - RoHS replacement available
RoHS