



SRA500 (Sn63/Pb37)
S.R.A. DELTA®
SOLDER WIRE

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Description

Flux Core

Delta® Solder Wire SRA500 contains a supreme activated rosin core that is available with both lead-containing alloys and lead-free alloys. SRA500 is recommended for highly oxidized metals and difficult-to-solder metals. SRA500 contains activators for instant wetting action and fast-spreading action. SRA500 conforms to IPC-J-STD-004B specifications.

Main Features

- ❑ High activity formulation
- ❑ Excellent solderability for a wide variety of applications
- ❑ Classified as ROH1 per IPC-J-STD-004B

Technical Data (Flux Extract)

	Specification	Test Method
Flux Classification	ROH1	IPC-J-STD-004B
Softening Point	92 °C	
Copper Mirror	Partial removal of copper film	IPC-TM-650 2.3.32
Corrosion	Pass	IPC-TM-650 2.6.15
SIR	2.10 x 10 ¹⁰	IPC-TM-650 2.6.3.3
Post Reflow Flux Residue	60%	TGA Analysis
Acid Value (mgKOH/g)	150 - 180	IPC-TM-650 2.3.13
Flux Residue Dryness	Pass	IPC-TM-650 2.4.47
Solder Spread	170 mm ²	IPC-TM-650 2.4.46
Shelf Life	Indefinite	

Wire Diameter

Sn63/Pb37 SRA500 Delta Solder Wire is available in a variety of diameters. The chosen diameter is based on application methods, pad size, and desired solder joint volume. Generally, the diameter of the wire should be slightly larger than the width/diameter of the joint or connection to be soldered. Below is a list of standard diameters.

Standard wire diameters

Diameter/Inch	0.125	0.092	0.062	0.050	0.040	0.032	0.028	0.025	0.020	0.015
Diameter/mm	3.18	2.33	1.57	1.27	1.01	0.81	0.71	0.63	0.51	0.38
Std.Wire Gauge	11	13	16	18	19	21	22	23	25	28
Tolerance, in.	+/-0.006	+/-0.005	+/-0.003	+/-0.002	+/-0.002	+/-0.002	+/-0.002	+/-0.002	+/-0.002	+/-0.002

Flux Percentage

Qualitek utilizes a state-of-the-art automatic wire extrusion and wire drawing machines to manufacture consistent solder. The introduction of flux core in the wire extrusion process involves continual monitoring of flux percentage to ensure minimal flux voids and irregular wire. Typical flux percentage for leaded solder is **1.1 – 3.3%**.

Physical Properties

Solder Composition

Qualitek has developed a super-rosin activated based core flux with alloy composition, Sn63/Pb37, which is a eutectic alloy. Qualitek Sn63/Pb37 alloy conforms to and exceeds the impurity requirements of IPC-J-STD-006C.

Typical Analysis													
Sn	Ag	Cu	Pb	Sb	Bi	In	As	Fe	Ni	Cd	Al	Zn	Au
62.5 -63.5	0.100 Max	0.080 Max	Bal	0.200 Max	0.100 Max	0.100 Max	0.030 Max	0.020 Max	0.010 Max	0.002 Max	0.005 Max	0.003 Max	0.050 Max

	Sn63/Pb37		Sn63/Pb37
Melting Point, °C	183 E	Yield Strength, psi	3950
Hardness, Brinell	14 HB	Total Elongation,%	48
Coefficient of Thermal Expansion	24.7	Joint Shear Strength, at 0.1mm/min 20 °C	23
Tensile Strength, psi	4442	Joint Shear Strength, at 0.1mm/min 100 °C	14
Density, g/cm ³	8.42	Creep Strength, N/mm ² at 0.1mm/min 20 °C	3.3
Electrical Resistivity, (μΩ-cm)	14.5	Creep Strength, N/mm ² at 0.1mm/min 100 °C	1
Electrical Conductivity, 10 ⁴ /ohm-cm	6.9	Joint Fatigue Cycle, 15N/mm ² 20 °C	1100
		10N/mm ² 100 °C	900

Flux Residues & Cleaning

SRA500 is a super-rosin activated formulation contains corrosive residues so residue removal is recommended. We recommend using Qualitek Multi-Cleaner 1515 or Everkleen 1005 Buffered Saponifier with a 5-15% concentration in hot 60 °C (140 °F) de-ionized water.

Storage & Shelf Life

Solder wire storage should be in a cool, dry environment away from direct heat. We recommend using gloves when handling solder wire directly. Solder wire has an indefinite shelf life.

Packaging

Qualitek flux-core wire and solid wire are packed in

12.5lb -box of ½ lb. spools

25 lb -box of 1 lb. spools

12.5kg -box of ½ kg spools

8 kg -box of 1kg spools

40 lb -box of 5 lb spools

20 lb -box of 20 lb. spools

Disposal

Sn63/Pb37 SRA500 leaded solder should be disposed of in accordance with federal, state and local authority requirements.