

## 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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