



# STANNOL®

Wenn's ums Löten geht  
When it's about soldering  
Quand il s'agit du soudage

## Technical Data Sheet

### STANNOL® Solder Wire HF-32

**STANNOL® Solder Wire HF-32** has been developed to meet industry's increasingly stringent quality requirements. It is designed for use in electronics application. **STANNOL® Solder Wire HF-32** is a flux cored solder wire. The activated, halide-free flux meets DIN EN 29454 Typ 1.1.3 (DIN 8511 F-SW32) standard. The flux residues are transparent, dry, and hard, and are not corrosive when tested in accordance with DIN 8516.

#### Application

**STANNOL® Solder Wire HF-32** can be used for hand-soldering and automatic wire feed operations. For manual soldering, the soldering iron tips should be temperature-controlled, to prevent excessive heat from being applied to the wire. Flux spatter from the formulation is minimal.

**STANNOL® Solder Wire HF-32** meets the requirements of DIN 8516, with respect to surface insulation resistance and electromigration.

#### Cleaning

The flux residues are not corrosive to non-ferrous metals. If cleaning is required the residues can easily removed by means of **STANNOL® FLUX-Ex200/B** (CFC-free) or most conventional organic solvents.

#### Physical Properties of the Flux

Flux Type:	DIN EN 29454 Typ 1.1.3 (F-SW32 DIN 8511)
Flux Content per DIN 8516:	3.5% by weight (Standard)
Spread Area:	130 mm <sup>2</sup> per DIN 8516
Corrosive Effects:	None, per DIN 8516
Surface Insulation Resistance:	No reduction, per DIN 8516
Standard Alloys:	S-Sn60Pb40 (183-190°C) S-Sn60SnPb38Cu2 (183-190°C) S-Sn63SnPb37 (183°C)
Diameters Supplied:	from 0.5 mm (.020" or 25 swg)
Standard Reels:	250 grs, 500 grs, 1 kilo

The above values are typical and represent no form of specification. The Data Sheet serves merely for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.

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