



# Lead-free solder wire

## IF 14-22

INTERFLUX®  
ELECTRONICS N.V.



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## Lead-free, no-clean and halide free solder wire

### Description:

Interflux® **IF 14-22** lead-free, no-clean solder wire contains no rosin, no halides and is recommended when soldering in **class 3** (IPC-A-610).

The body of the IF 14 flux carrier can almost fully evaporate during soldering (rather than carbonising).

The residues can easily be removed by hand (brush).

**IF 14-22** has increased flux content compared to the IF 14-16. It has a larger process window and is suitable for high thermal mass through hole soldering.

**IF 14-22** can give a bit more residues than the standard IF 14-16.



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### Key advantages:

- Non sticky residue, removable by hand
- No colophony fumes
- Classification to IPC and EN: **RE LO**
- Absolutely halogen free
- Long tip-life
- Very good wetting on Cu, Ag, Sn ...

### Availability

Flux type: IF 14  
Flux content: 2,2% w/w

alloy	melting point	diameters					
		0,35	0,50	0,70	1,00	1,50	2,00
Sn96,5Ag3Cu0,5	217°C—219°C	●	●	●	●	●	●
Sn96,5Ag3,5	221°C	●	●	●	●	●	●
Sn95,5Ag3,8Cu0,7	217°C-219°C	●	●	●	●	●	●
Sn99Ag0,3Cu0,7	217°C-227°C	●	●	●	●	●	●
Sn99,3Cu0,7	227°C	●	●	●	●	●	●

● = available

● = upon request



## Work instructions

### **Manual soldering**

The working temperature is between 360°C and 390°C. For more dense metals like Nickel, the temperature may be elevated to 420°C.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact surface with the component and

solder pad.

The use of a good soldering station is important in order to always have the correct temperature on the soldering joint. Use a soldering station with a response time as short as possible.

Heat up the surfaces of both component and island simultaneously. Slightly touch with the solder wire,

the point where component lead, soldering island and soldering tip meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. It is important that no solder wire is making contact with

the soldering tip during soldering to avoid flux spitting and premature flux consumption!

## Handling

### **Storage**

Store the solder wire in a clean environment at ambient temperature.

### **Handling**

To avoid spool and wire damage, handle package with care



## Test results

conform EN 61190-1-3(2007) and IPC J-STD-004

Property	Result	Method
<b>Chemical</b>		
flux designator	<b>RE / LO</b>	J-STD-004
	<b>F-SW 33</b>	DIN 8511
	<b>1.2.3</b>	ISO 9454
qualitative copper mirror	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.32
	<b>pass</b>	GR-78-CORE Rev. 9/97 13.1.6
qualitative halide silver chromate (Cl, Br)	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.33
	<b>pass</b>	GR-78-CORE Rev. 9/97 13.1.4
spot test (F)	<b>pass</b>	J-STD-004 IPC-TM-650 2.3.35.1
quantitative halide	<b>0,00%</b>	J-STD-004 IPC-TM-650 2.3.35
<b>Environmental</b>		
SIR test	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.3.3
	<b>pass</b>	TA-NWT-000078 13.1.4
qualitative corrosion, flux electro chemical migration	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.15
	<b>pass</b>	TA-NWT-000078 13.1.5 TA-NWT-000078 13.1.5



## Packaging

Spools of 100g, 500g and 1000g



Trade name : IF14-22 Lead-Free, Halide Free, No-Clean Solder Wire

D i s c l a i m e r

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