



TECHNICAL INFORMATION SHEET

95/5 TIN/ANTIMONY ACID CORE SOLDER

NOMINAL CHEMICAL COMPOSITION%:

Sb 4.0 – 6.0
Sn Remainder

PHYSICAL PROPERTIES:

Solidus 455°F (235°C)
Liquidus 464°F (240°F)
Deposit color – silver/gray
Shear Strength room temperature – 5613 PSI
212°F – 3089 PSI
Electrical resistivity ($\mu\Omega\cdot m$) – 0.145
Density (g/cm^3) – 7.26

SOLDERING PROPERTIES:

95/5 acid core is a lead-free alloy frequently used to solder copper, brass, and steel, often as a replacement for lead bearing alloys. Flux is contained in the solder core and flows out to protect the surface during heating. This solder form minimizes the amount of flux used per part and makes it an ideal choice for semi-automated soldering applications.

95/5 has a higher melting temperature vs. tin/lead solders which is helpful in certain elevated temperature service applications. 95/5 has a narrow melting range which provides rapid flow when melted. This trait means parts with reasonably close tolerances, (0.002" – 0.005") are recommended.

AVAILABLE FORMS:

Standard diameters on 1 lb., 5 lb., and 25 lb. spools.

FLUX:

Flux is contained in the solder core. Remove flux residue upon completion.

SPECIFICATION COMPLIANCE:

ASTM B32 – Sb5 (solder wire component)
J STD – 006, Sn95Sb05A Flux core -
J STD -004 type OR

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health. **HEAT RAYS**, (infrared radiation) from flame or hot metal can injure eyes.
SOLDER FLUXES may contain chlorides, acids, or other ingredients that are considered hazardous via inhalation, ingestion, or skin or eye contact.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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