



TECHNICAL INFORMATION SHEET

50/50 ROSIN CORE TIN LEAD SOLDER

NOMINAL CHEMICAL COMPOSITION%:

| | |
|----------|-------------|
| Lead | Remainder |
| Tin | 49.5-51.5 |
| Antimony | 0.20 – 0.50 |

TYPICAL PHYSICAL PROPERTIES:

| | |
|----------|---------------|
| Solidus | 361°F (183°C) |
| Liquidus | 421°F (216°C) |

SOLDERING PROPERTIES:

This tin-lead solder contains a rosin core center and is a popular choice for soldering for electrical and electronic connections. Rosin core solders are generally used for small connections like this as there is a limited amount of flux available for protection of large surface areas. Heat sources include soldering guns, irons and torch applications.

Lead bearing solders are not to be used in potable water systems.

AVAILABLE FORMS

Standard wire diameters

RECOMMENDED FLUX:

Additional flux is generally not used with rosin core solder as the rosin core provides necessary flux activity. Flux residue remaining after soldering is considered non-corrosive.

SPECIFICATION COMPLIANCE:

ASTM B32 Alloy Grade Sn 50 Type WRAP-2
Solid wire J-STD-006 Sn50Pb50Sb0.4
Flux J-STD-004 R0L1

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.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), 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.

THE HARRIS PRODUCTS GROUP

A LINCOLN ELECTRIC COMPANY



4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

Additional information available at our web site: www.harrisproductsgroup.com