



TECHNICAL INFORMATION SHEET

97/3 Rosin Core - Lead-Free Solder

NOMINAL CHEMICAL COMPOSITION %:

Copper – 3.0
Tin – 97.0

TYPICAL PHYSICAL PROPERTIES:

Melting Temperature - 445°F (229°C)

DESCRIPTION:

97/3 lead-free rosin core solder is formulated for electrical and electronic applications where corrosive flux residue must be avoided. This solder contains an inner core of flux so separate flux application is unnecessary. It is primarily used for soldering copper wire in electrical connections. It has a low melting point and narrow melting range to reduce heating time. 97/3 rosin core solder is lead and antimony free.

APPLICATION:

Prior to soldering, clean copper wire or connection with a brush or Scotch Brite® to remove surface oxide. Apply heat. For electrical connections, a soldering iron or gun is typically used. This heating method focuses heat from the tip to the area to be soldered. For other applications, an air-fuel hand torch, such as a Harris propane or MappPro® torch, is typically used. Apply heat to part and then apply solder. Avoid melting the solder with just the heating tip or flame.

RECOMMENDED FLUX:

Flux is contained in the solder core. Flux is a non-corrosive rosin mixture. Post soldering flux residue removal is unnecessary.

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.
- Flux may be harmful or fatal if inhaled or swallowed.
- Flux may cause skin and eye irritation.
- 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.

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