

# ALPHA<sup>®</sup> FLUITIN 1532

No Clean, Flux Cored, Wire Solder

J-STD-004-ROM1/ IPC-TM-650 2.6.3.3 / ISO 1224-1.1.2 / DIN 8511-F-SW26

## DESCRIPTION

**ALPHA Fluitin 1532** is an activated rosin cored solder wire developed for general hand soldering applications. The unique activator system offers good thermal stability at pre-soldering temperatures ensuring that Fluitin 1532 performs extremely well on parts and surfaces which present poor or difficult soldering conditions.

**ALPHA Fluitin 1532** leaves post-soldering residues that are hard and which can be safely left without the need to remove them. If the removal of residues is required then semi-aqueous or aqueous systems can be used effectively.

## FEATURES & BENEFITS

- Very fast wetting → Low Cycle times for component touch-up and manual assembly
- Good spread characteristics → Excellent Solder Joints
- Pleasant pine smell → Operator Friendly
- Clear and safe residue → No-Clean Residues, Useful for all Applications
- Provides good joint appearance → Makes Inspection easy

**ALPHA Fluitin 1532** is suitable for use in any commercial no-clean hand soldering application that specifies compliance to J-STD-004 – ROM1 standard. It is suited to such areas of industry (subject to the above criteria) as TV, Audio equipment, Video/DVD, Games box and all types of household appliances.

## PRODUCT INFORMATION

Standard	Alloy Designation	Melting or Solidus / Liquidus Temp °C	Flux Amount
ISO 9453	SAC305	217 / 221	2.2% & 3.3%
Proprietary	SACX Plus <sup>®</sup> 0307	217 / 228	2.2% & 3.3%
ISO 9453	Sn99/Cu1	227 / ~235	2.2% & 3.3%
ISO 9453	Sn50/Pb50	183 - 216	2.2%
ISO 9453	Sn60/Pb40	183 - 190	1.4% & 2.2%
ISO 9453	Sn60/Pb38/Cu2	183 - 190	1.1% & 2.2%
ISO 9453	Sn62/Pb36/Ag2	178 - 190	2.2%
ISO 9453	Sn63/Pb37	183	1.1% & 2.2%

\* Fluitin 1532 may also be available in other alloys and flux amounts on request.

# ALPHA<sup>®</sup> FLUITIN 1532

No Clean, Flux Cored, Wire Solder

J-STD-004-ROM1/ IPC-TM-650 2.6.3.3 / ISO 1224-1.1.2 / DIN 8511-F-SW26

## TECHNICAL DATA

Physical Properties	Typical Values
Rosin grade	WW per Fed Spec. LL-R-626
Rosin Softening Point:	71°C (160°F)
Acid Value:	170 - 190 mg KOH/g flux (IPC-TM-650-2.3.13)
Halide Content:	0.80 – 1.10% weight (IPC-TM-650-2.3.28.1)
Copper Mirror:	<50% breakthrough per IPC J-STD-004A
Classification:	ROM1 per IPC J-STD-004A ISO 12224 – 1.1.2. Din 8511 – F – SW26

Electrical Reliability Test	Requirements	Results
IPC SIR Testing (J-STD-004A)	$1.0 \times 10^8 \Omega$ minimum	PASS

## APPLICATION

A soldered joint is formed by heating the parts to be soldered to a temperature in excess of the melting point of the alloy to be used – in hand soldering this is how a soldering iron is used. By feeding the cored wire onto the parts, the flux is able to flow and remove oxidized metal, while the solder creates a thin inter-metallic bond which becomes the solder joint. Fluitin 1532 is also ideal for robotic soldering applications.

Note the following tips:

- Use a soldering iron tip size and form to suit the operation: small tips for soldering large components may prevent the formation of a joint or slow the process down.
- Select a solder wire diameter to suit both the soldering iron tip and the parts/components to be soldered.
- Soldering iron systems should provide sufficient heat to satisfy the requirements of the points above.
- A typical solder tip temperature would be between 120°C and 160°C above the liquidus temperature of the alloy. The ideal temperature to use is dependant on how thermally demanding the assembly is.
- Cored solder wires can be provided in different grades of alloy so always ensures that you have selected the right grade for the application.
- Do not overheat as this causes an increase in the depth of the inter-metallic layer, which in turn weakens the joint.

If you choose to use a liquid rework flux, **ALPHA 615** Flux is recommended to maintain high electrical reliability. **ALPHA 615** flux is available in Alpha's 'Write Flux Pens' for precision flux application.

# ALPHA® FLUITIN 1532

No Clean, Flux Cored, Wire Solder

J-STD-004-ROM1/ IPC-TM-650 2.6.3.3 / ISO 1224-1.1.2 / DIN 8511-F-SW26

## SAFETY

Observe standard precautions for handling and use. Use in well ventilated areas. DO NOT SMOKE during use. **ALPHA Fluitin 1532** wire is not considered toxic. However, its use in typical soldering applications will generate a small amount of decomposition and fumes. These fumes should be adequately exhausted / vented for operator safety and comfort.

Consult the SDS for all safety information. The most recent version of the SDS is available from AlphaAssembly.com.

## STORAGE

ALPHA Cored Solder Wires should be stored in dry conditions and within a temperature range of 0°C to 40°C. Alpha guarantees the product shelf life for three years from the date of manufacture when stored in the recommended conditions.

## CONTACT INFORMATION

To confirm this is the most recent issue, please contact Alpha Assembly Solutions

AlphaAssembly.com

<p><b>North America</b> 300 Atrium Drive Somerset, NJ 08873, USA 800.367.5460</p>	<p><b>Europe</b> Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 01483.758400</p>	<p><b>Asia</b> 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p>
---	---	---

Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency directory assistance Chemtrec 1 - 800 - 424 - 9300.

DISCLAIMER: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. No statement or recommendation shall constitute a representation unless set forth in an agreement signed by officers of seller and manufacturer. NO WARRANTY OR MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE IS MADE. The following warranty is made in lieu of such warranties and all other warranties, express, implied, or statutory. Products are warranted to be free from defects in material and workmanship at the time sold. The sole obligation of seller and manufacturer under this warranty shall be to replace any product defective at the time sold. Under no circumstances shall manufacturer or seller be liable for any loss, damage or expense, direct or consequential, arising out of the inability to use the product. Notwithstanding the foregoing, if products are supplied in response to a customer request that specifies operating parameters beyond those stated above, or if products are used under conditions exceeding said parameters, the customer by acceptance or use thereof assumes all risk of product failure and of all direct, indirect and consequential damages that may result from use of the products under conditions, and agrees to exonerate, indemnify and hold harmless MacDermid Incorporated therefrom. No suggestion for product use nor anything contained herein shall be construed as a recommendation to use any product in infringement of any patent rights, and seller and manufacturer assume no responsibility or liability for any such infringement.

® Registered Trademark of MacDermid Performance Solutions. ™ Trademark of MacDermid Performance Solutions.  
© Platform Specialty Products Corporation and its subsidiaries 2016.