



SOLDER CONNECTION

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QUALITEK® Technical Bulletin

NC601E SN100E SOLDER WIRE

DESCRIPTION

A no clean cored solder wire that provides the fluxing activity levels that promote fast-wetting action and maximum wetting spread. NC601E contains purely organic acid activators so leaves minimal residue and spreads like an RA type cored solder wire. NC601E exhibits virtually no spattering and conforms to IPC-J-STD-004B.

FEATURES AND BENEFITS

- Excellent wettability
- Non-tacky residues
- RoHs compliant
- Colophony/Rosin Free

FEATURES AND BENEFITS

	Specification
Color & Appearance	Amber solid
Flux Classification	ORL0
Softening Point (Flux Extract)	75°C
Acid Value (mgKOH/g)	350-370
Silver Chromate	
Qualitative Halides	No Detection
Melting Point	228°C
SIR	>1.0 x 10 ⁹

WIRE DIAMETER

Delta Solder Wire NC601 SN100E is available in a variety of diameters. The chosen diameter is based on application methods, pad size, and desired solder joint volume. Generally, the diameter of the wire should be slightly larger than the width/diameter of the joint or connection to be soldered. Below is a list of standard diameters.

DIAMETER/INCH	0.125	0.092	0.062	0.050	0.040	0.032	0.025	0.020	0.015	0.010
DIAMETER/MM	3.17	2.3	1.57	1.27	1.01	0.81	0.63	0.50	0.38	0.25
STD. WIRE GAUGE	11	13	16	18	19	21	23	25	28	31

FLUX PERCENTAGE

Utilizes a state-of-the-art automatic wire extrusion and wire drawing machines to manufacture consistent solder. The introduction of flux core in the wire extrusion process involves continual monitoring of flux percentage to ensure minimal flux voids and irregular wire. Available in 2.2% flux for SN100E solder wires.

PHYSICAL PROPERTIES

A no clean resin based core flux with SN100 alloy. SN100 alloys conform to and exceed the impurity requirements of IPC-J-STD-006C.

FLUX RESIDUES & CLEANING

NC601 is a no clean formulation; therefore, residue removal is not required for typical applications.

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STORAGE & SHELF LIFE

Solder wire storage should be in a 65-80 °F environment away from direct heat. We recommend using gloves when handling solder wire directly. Solder wire has an indefinite shelf life.

DISPOSAL

SAC alloy NC601 lead-free solder should be disposed of in accordance with federal, state & local authority requirements.

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