

Technical Data Sheet

Trade name: A-19 (cored solders filling)

Overworked on: 12.10.2009

Date of print: 12.10.2009

Version: 2

Standard:	1.1.3.B / DIN EN 29454-1 resin - colophony - activated without halogens
Condition:	solid
Operating temperature:	approx. 150 - 400 °C
Proportion in cored solder:	between 0,5 % - 3,5 %
Soldering temperature:	Dependent from the alloy composition. Recommendation: approx. 30 - 50 °C above the liquidus temperature.
Chemical composition:	The flux based on natural or modified resin (colophony) with organic, halogen-free activators.
Application:	Electrical engineering, electronics, miniature technics, printed circuits.
Durability:	at least 24 months
Flux residues :	Flux residues can stay at the soldered joint.
Safety:	Soldering fume: Effective exhaust / fresh air supply must be provided during soldering. More information can be found in the "BGR 220 ".