

■ General Description

ELFLUX 3002 M NC is a water-based flux with low solid content. It is a halide-free, organic flux for use in wave soldering under normal or inert gas atmosphere.

The residues on the printed circuit board are not tacky. Electrical in-circuit testing can be done without any problem. The solder joints are low in residues and in general cleaning is not necessary.

ELFLUX 3002 M NC improves the soldering result and minimizes the formation of solder bridges and solder balls. ELFLUX 3002 M NC contains a corrosion inhibitor reducing the risk of corrosion on copper surfaces under humid conditions.

■ Areas of Use

ELFLUX 3002 M NC has been developed especially for OSP surfaces but also shows very good soldering results on chemical tin or HAL surfaces.

ELFLUX 3002 M NC can be used both for the automotive and the telecommunication areas. ELFLUX 3002 M NC has been developed also for processing lead-free alloys like SnCu0.7, SnAg3.5, SnAg3.5Cu0.7 and similar alloys.

■ Classification

ELFLUX 3002M NC has been classified as ORLO per DIN EN 61190-1-1 and IPC ANSI/J-STD-004.

■ Technical Specification

	ELFLUX 3002 M NC
Appearance	Clear, transparent liquid
Smell	Odourless
Solids content [%] (per IPC-TM-650 2.3.34)	3.1
Density [g/cm ³] (20°C)	1.008 ±0.003
VOC content [%]	None
Acid number [mg KOH/g Flux]	27.5
Halides [%]	None
pH value (20°C)	2.6
Flash point [°C]	None
Ignition temperature [°C]	None

■ Application

ELFLUX 3002 M NC can be applied exclusively by spraying. ELSOLD recommends spray fluxers which are able to process the flux directly from the delivery container. The optimum preheating temperature is 110-135°C as measured on the top side (component side) of the board. The use of more nitrogen is recommended for most solder equipment types in order to avoid the formation of vapour in the soldering tunnel. Soldering equipment makers will be able to advise you accordingly. Partial convection pre-heating saves energy.

■ Lead-free Solders

ELFLUX 3002 M NC is thermally stable and can therefore also be used under increased preheating temperature.

■ Corrosion and Electrical Tests

SIR per IPC-TM-650 2.6.3.3	Result
Flux	4,5 x 10 ⁹ Ω after 11 days
Control	7,4 x 10 ⁹ Ω after 11 days

Test condition	Result
Climate	35°C /85% humidity
Bias	45-50 V
Comb pattern	IPC-B-25
Insulation Resistance Value (11 days)	
Pattern Up	4,5 x 10 ⁹ Ω
Pattern Down	5,0 x 10 ⁹ Ω
Control	7 x 10 ⁹ Ω

■ Packing Sizes

ELFLUX 3002 M NC is available in containers of 10 L / 20 L

■ Cleaning

Cleaning of the boards: ELFLUX 3002M NC is a no-clean flux. Generally, cleaning is not required.

■ General Safety Precautions

ELFLUX 3002M NC should be used according to industrial standards of practice. For safety advice please refer to the material safety data sheet.

■ Storage

ELFLUX 3002M NC is not flammable and are therefore not subject to any restrictions regarding the stored quantity, not even near the soldering machine. The product does not have to be stored in dangerous goods stores. ELFLUX 3002M NC is water-based and should not be stored under 3°C.

■ Shelf-Life

Under adequate conditions ELFLUX 3002M NC can be stored in original unopened containers for a minimum of 12 months.

The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.