Product Information

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ELSOLD®
Lotprodukte / *Solder Products*

>> Deoxidation Tablets for the Lead-free Soldering Process

The ever increasing use of lead-free solder alloys and the higher process temperatures required by these alloys automatically lead to a faster oxidation rate and more dross formation. The addition of our newly developed lead-free deoxidation tablets helps to largely avoid the aforementioned negative effects.

Composition / Description

Sn99P1 or Sn95.5Ag3.5P1 in the form of tablets

Advantages:

- much reduced oxidation tendency on the liquid solder
- distinct reduction of bridges and icicles
- improved hole fill due to optimized surface tension
- lower solder consumption

Application

Upon request the phosphor content can already be correctly adjusted in lead-free ELSOLD soft solders when being shipped to the customer. During the soldering process the correct content of phosphorous can be maintained by adding our original deoxidised ELSOLD soft solders.

In case of solder baths with limited throughput and/or increased operating temperature the phosphorous content may be used up after a longer period of operation. This can be compensated by adding deoxidation tablets. The same applies for solder baths using original lead-free solders without phosphorous.

Usage

In dip solder baths for general tinning work, add 1-2 tablets per kg of solder. In wave or drag soldering machines, to replace the used phosphorous: 4-6 tablets per 10kgs of solder. The exact number of required tablets depends also on the respective process parameters

Functional Test / Tarnishing Test

A solder bath adjusted to the correct phosphorous level must not show any discolouration / tarnishing of its surface after one minute at 350°C.

Delivery Form

ELSOLD deoxidation tablets come in small bottles of 50 pcs or in plastic jars of 800 pcs.

Shelf Life

Minimum 1 year if stored in dry and clean environment.

Health and Safety

Please refer to the relevant material safety data sheet for health and safety advice.

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