

CHART OF ALLOYS FOR OXYFREE ® FLUX CORED WIRES

Description	Ref. ISO 9453	Ref. FONDAM
60	S-Sn60Pb40 E	FM1 - FM5 - FXM1 - HYDREL2
ST/N	Sn60Pb38Bi2	FM5
ST	S-Pb49Sn48Bi3	FM5
Type Cu2	S-Sn60Pb38Cu2	FM1
Type 221°	S-Sn96Ag4 *	FM1
Type 178°	S-Sn62Pb36Ag2 *	FM3 - FXM1
Type 300°	S-Pb93Sn5Ag2	FM1

* Eutectic Alloys

CHART OF FLUX CORED WIRES

WIRE	REFERENCE	Number of channels	TYPE OF FLUX	Standard Diameter (mm)
	<u>ALLOY</u>			
FM1	Type 300° & 221°	1	<u>CMA β</u> - Rosin mildly activated	0,5 - 0,6
	60		<u>CA α</u> - Rosin activated	
FM3	Type 221°	3	<u>CA β</u> - Rosin mildly activated	0,7 - 0,8
	Type 178°		<u>CMA α</u> - Rosin mildly activated	
FM5	63, 60, 50, ST, ST/N	5	<u>CMA α</u> - Rosin mildly activated	1,5 - 2,0
FXM1	60, Type 178°	1	<u>FXM</u> - No-clean	3,0
HYDREL2	60	1	<u>Hydrel</u> - Water Washable	

Standard Packaging : reels of 500 gr, 1 kg & 3 kg

CHART OF ALLOYS FOR FLUX CORED WIRES - Compositions & features

DESCRIPTION	COMPOSITION (in %)					Solidus	Liquidus	FIELDS OF APPLICATIONS
	Sn	Pb	Ag	Bi	Cu			
60	60	40				183	188	Standard electronic products
ST/N	60	37,5		2,5		180	185	Dull solder joints
ST	48	49		3		178	205	
Type Cu2	60	38			2	183	190	Copper Iron tip
Type 221°	96,25		3,75			221	221	Lead free alloy
Type 178°	62	36	2			178	178	Hybrid electronic products Silver or gold coated PCB
Type 300°	5	93,5	1,5			296	301	High temperature alloy