

ALPHA FLUITIN 1535

No-Clean Cored Solder Wire

Type: J-STD-004 –ROL1 / IPC-SF-818-L2CN / ISO 12224 – 1.1.2 / DIN 8511–F–SW26

Europe Only

DESCRIPTION

ALPHA Fluitin 1535 is an activated rosin cored solder wire developed for general hand soldering applications. The unique activator system offers good thermal stability at pre-soldering temperatures ensuring that **ALPHA Fluitin 1535** performs extremely well on parts and surfaces which present poor or difficult soldering conditions.

ALPHA Fluitin 1535 leaves post-soldering residues that are hard and which can be safely left without the need to remove them. If the removal of residues is required then semi-aqueous or aqueous systems can be used effectively.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES AND BENEFITS

- ROL1 – Suitable for J-STD-001B Class III – High performance electronic products.
- Minimal, non-corrosive, clear and safe residues.
- Very fast wetting.
- Good spread characteristics.
- Pleasant pine smell.
- Ease of solderability.
- Provides good joint appearance.

APPLICATION GUIDELINES

ALPHA Fluitin 1535 is suitable for use in any commercial no-clean hand soldering application that specifies compliance to J-STD-004 – ROL1 standard.

This applies to products where continued high performance or performance on demand is crucial and equipment downtime cannot be tolerated and / or the end use environment may be uncommonly harsh. This classification would typically include military weapons, and defense systems, aerospace, life support systems and under the hood automotive electronics.

HINTS AND TIPS ON SOLDERING IN GENERAL

Always remember that a soldered joint is formed by heating the parts to be soldered to a temperature in excess of the melting point of the alloy to be used – in hand soldering this is how a soldering iron is used. By feeding the cored wire onto the parts, the flux is able to flow and remove oxide films, whilst the solder creates a thin intermetallic bond which becomes the solder joint.

Note the following tips:

- Use a soldering iron bit size and form to suit the operation: small bits for soldering large components may prevent the formation of a joint or slow the process down.
- Always select wire diameters to suit both soldering iron bit and the parts/components to be soldered.
- Soldering iron systems should provide sufficient heat to satisfy the requirements of the points above.
- Cored solder wires can be provided in different grades of alloy so always ensure you have selected the right grade for the application.
- Do not overheat as this causes an increase in the depth of the intermetallic layer, which in turn weakens the joint.

All ALPHA soldering materials are manufactured to meet the most stringent of standards and to ensure the best possible finish to every soldering application.

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TECHNICAL DATA

Category	Results
Physical Properties	
Rosin Grade	WW per Fed Spec. LL-R-626
Rosin Softening Point	71 °C (160 °F)
Acid Value:	170 to 190 (mg KOH/g)
Halide Content	0.35 to 0.45% (by weight)
Corrosiveness	Classified to J-STD-004 as L type material
Copper Mirror	Classified to J-STD-004 as <50% breakthrough

Category	Results
Surface Insulation Resistance (Not Cleaned)	Passes IPC-SF-818 Class III Test results to J-STD-004 85 °C/85% RH / 7 days CD = 3.73E10 Ohms CU = 3.22E10 Ohms (Pass >1E08 Ohms)
Classification	J-STD-004 – ROL1 IPC-SF-818 – L2CN ISO 12224 – 1.1.2. DIN 8511 – F – SW26

Standard	Alloy Designation	Meting or Solidus / Liquidus Temp °C	Flux Configuration
ISO 9453 (2)	S-Sn60Pb40	183 to 190	2.2%
ISO 9453 (5)	S-Pb60Sn40	183 to 235	2.2%

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at MacDermidAlpha.com/assembly-solutions/knowledge-base.**

CONTACT INFORMATION

To confirm this document is the most recent version, please contact
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE . Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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