

## Flux cored solder wire with powerful wetting

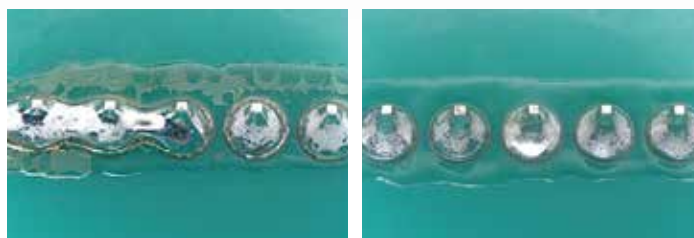
# 72M series

## Designed for Faster Soldering and Improved Wettability

### Powerful wetting prevents bridging in slide soldering

**72M series** contains new activators with superior activation characteristics results in improved wettability. The new resin composition aids to better flux coverage which results in preventing bridging even in conditions like lower iron tip temperatures or faster sliding speeds.

### Slide soldering comparison



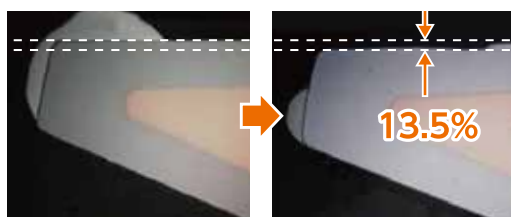
Conventional

S3X-72M

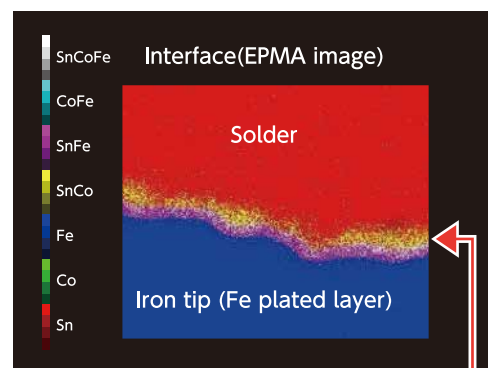
### Inhibits iron tip erosion

**S01X7Ca-72M(0.1Ag)** and **S03X7Ca-72M(0.3Ag)** form an IMC layer of Sn/Fe/Co between the solder and the iron tip. This IMC layer inhibits the erosion of Sn from the solder, and drastically extends the iron tip life.

### Condition of iron tips after 10,000 shots (S01X7Ca)



13.5%



Barrier layer of Sn/Fe/Co

### Wide variety of solder alloys to choose from

**S1XBIG-72M** contains very small amount of Bi and Ni, which helps in achieving more reliable solder joints with low Ag content. In addition to superior melting characteristics, this alloy exhibits good thermal fatigue resistance and stable crystal structure over time as compared to SAC305 alloy.

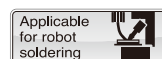
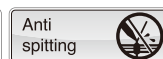
With 6% Indium, **SB6N-72M** demonstrates improved strength and forms high reliability joints, often required for extreme service conditions experienced typically in automotive electronics, aviation and industrial applications.

### Solder alloy lineup

Alloy	Features
S3X	Standard lead free solder alloy, SAC305
S01X7Ca	Ag 0.1%, anti-iron tip erosion
S03X7Ca	Ag 0.3%, anti-iron tip erosion
S1XBIG	Low Ag hybrid strengthen solder alloy
SB6N	In-containing high durability solder alloy

### Product specifications

Product name	S3X-72M	S01X7Ca-72M	S03X7Ca-72M	S1XBIG-72M	SB6N-72M
Alloy composition (%)	Sn 3.0Ag 0.5Cu	Sn 0.1Ag 0.7Cu+Co	Sn 0.3Ag 0.7Cu+Co	Sn 1.1Ag 0.7Cu 1.8Bi+Ni	Sn 3.5Ag 0.5Bi 6.0In
Melting point (°C)	217-219	217-227	217-227	211-223	202-210
Flux content (%)	3.2				
Halide content (%)	< 0.01				
Flux type*	ROLO				
Diameter(mm dia.)	0.3, 0.5, 0.6, 0.8, 1.0, 1.2				



\*Per IPC J-STD-004