



STANNOL®
Wenn's ums Löten geht
When it's about soldering
Quand il s'agit du soudage

Technical Data Sheet

STANNOL® Solder Wire HS10

The **electronic solder wire HS10** is a proven and reliable product of Stannol research, which was developed to meet high quality requirements in industrial electronic production as well as for quick rework.

Description

STANNOL® solder wire HS10 is very efficient by its high activity, which results in quick spread of solder and electrical safe residues.

STANNOL® solder wire HS10 is a halide activated rosin (colophony) flux.

STANNOL® solder wire HS10 conforms to IEC 61190-1-3 type ROM1

This activated rosin shows following properties:

- safe soldering even at low soldering temperatures
- solid and dry residues, pin testable
- fast soldering, high spread speed
- high reliability

Application

STANNOL® solder wire HS10 can be used for hand and robot soldering in electronics and electrical assembly, audio devices and telecommunication. Flux residues can remain on surfaces without cleaning. If cleaning is necessary for optical or technical reasons, we recommend the use of the cleaner **STANNOL® Flux-Ex 200B** or **STANNOL® Flux-Ex 500**.

Physical Properties and Data

General properties	STANNOL® solder wire HS10	
Flux type:	ROM1 (IEC 61190-1-3) / 1.1.2.B (DIN EN 29454-1) / F-SW26	
Flux content:	standard 2.5 weight % \pm 0.3 %	
Halide content:	0.9 %	
Corrosion effect:	none, according to DIN 8516	
Standard alloys acc. to ISO 9453:2006	lead-containing:	lead-free (ECOLOY® Series):
	S-Sn60Pb40	ECOLOY® TS (S-Sn96Ag4) - not patented
	S-Sn60Pb39Cu1	ECOLOY® TSC (S-Sn95Ag4Cu1)
	S-Pb60Sn40	ECOLOY® TC (S-Sn99Cu1) - not patented
	S-Sn62Pb36Ag2	ECOLOY® TSC305 (S-Sn96Ag3Cu1)
Available diameters:	from 0.3 mm	
Available reel sizes:	250 g, 500 g, 1 kg	

Other alloys, diameters flux contents or reel sizes are available on request.

Health and Safety

Before using please read the material safety data sheet carefully and observe the safety precautions described.

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.