



# STANNOL®

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

## Technical Data Sheet

### STANNOL® solder wire HF32

**STANNOL® solder wire HF32** has been developed to meet industry's increasingly stringent quality requirements. It is designed for use in electronics application.

#### Description

**STANNOL® solder wire HF32** is a flux cored solder wire. The activated, halide-free flux meets DIN EN 29454 type 1.1.3 and IEC 61190-1-3 type ROL0 standard. The flux residues are solid and dry, and are not corrosive when tested in accordance with DIN 8516.

#### Application

**STANNOL® HF32** can be used for hand-soldering and automatic wire feed operations. For manual soldering, the soldering iron tips should be temperature-controlled, to prevent excessive heat from being applied to the wire. Flux spatter from the formulation is fairly low.

**STANNOL® solder wire HF32** meets the requirements of DIN 8516, with respect to surface insulation resistance and electromigration.

The flux residues are not corrosive to non-ferrous metals. 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 HF32	
Flux type:	ROL0 (IEC 61190-1-3) / 1.1.3.B (DIN EN 29454-1) / F-SW32	
Flux content:	standard 3.5 weight % $\pm$ 0.3 %	
Halide content:	none, according to DIN EN ISO 9455-6	
Corrosion effect:	none, according to DIN EN 29455-5 and -15	
Surface Insulation Resistance:	85% r.H. 7 d	$> 10^{10} \Omega$
Standard alloys acc. to ISO 9453:2006:	lead-containing:	lead-free (ECOLOY® Series):
	S-Sn60Pb40	ECOLOY® TC (S-Sn99Cu1)
	S-Sn60Pb39Cu1	ECOLOY® TSC (S-Sn95Ag4Cu1)*
	S-Sn62Pb36Ag2	ECOLOY® TSC305 (S-Sn96Ag3Cu1)*
Available diameters:	from 0.3 mm	
Available reel sizes:	250 g, 500 g, 1 kg	

\* The use of this solder can lead to solder joints / soldered parts, which possibly can become patent-protected in the USA and consequently liable to licence fees.  
As a licence holder, we can discharge the royalties for our clients. Please contact us.

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 advice 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.