

## technical specification

### FEATURES

- \* Low impurity levels
- \* Virgin raw materials
- \* Lead free
- \* Eutectic composition

### DESCRIPTION

Afrisol 97/3 is a lead free, 97% tin/3% copper based eutectic solder manufactured in accordance with SABS 24 : 1994 requirements. Therefore consistency and quality can be guaranteed. The major raw materials, tin and copper, are batch selected to ensure that impurity levels are well below specification.

97/3 is a high quality, lead free solder for the demanding and specialised fields in the assembling of copper to copper surfaces, copper to pre-tinned, copper to steel and other metal to metal interfaces. In applications where it is vital to maintain high quality solder fillets it provides excellent tinning and solder wetting with **Powerflow flux** for industrial applications. 97/3 is manufactured to a eutectic formulation, and therefore the solidus and liquidus melting points are nearly identical, namely 227°C, hence quick, consistent and fast forming solder joints can be obtained. SABS specifies a melting range of 230-250°C due to the range in the metal content of the copper.

## 97/3 Plumbing Wire

### BENEFITS

- \* Solidifies quickly & consistently
- \* Low oxidation rate
- \* No lead contamination
- \* Consistent melting range

In industrial applications, solder wire from 2 to 3 mm are used, the flux is applied first over the total area to be soldered, followed by gentle heating to about 300°C of the metal surfaces and the solder wire is then applied with minimal heat. The capillary action will pull the molten solder into the solder joint.

In electronic applications solder wires of 0.5 to 1.25mm are used with a soldering iron and a no clean flux.

### SPECIFICATION

Tin	97%	(balance)
Copper	3%	(2.5 – 3.5%)
Lead	0.005%	

### AVAILABILITY AND PACKAGING

250gm and 500gm rolls  
20 and 40 rolls per box