

ALPHA® AS2

Flux Cored, Wire Solder, Type: J-STD-004 ORH1, ISO 12224 - 2.1.2

DESCRIPTION

ALPHA AS2 is a rosin-free activated cored solder wire. Its flux formation is based on volatile organic compounds with an extremely effective activator system. **ALPHA AS2** is particularly formulated for flame soldering, for example with bulb production and capacitor manufacturing. However, **ALPHA AS2** can be used with any other soldering technique if temperature is high enough and sufficient heat applied and SIR of flux residues is not a premium requirement.

FEATURES & BENEFITS

ALPHA AS2 flux is considered to be conditional corrosive and decomposition starts at 135°C. With continued heating the flux nearly completely evaporates. **ALPHA AS2** is not flammable and provides very smooth solder flow until volatilised. These properties are especially suited for flame soldering in bulb industries and capacitor production, but also for other applications, where activity of rosin flux is not sufficient.

PRODUCT INFORMATION

Standard	Alloy Designation	Melting or Solidus / Liquidus Temp °C	Flux Amount
ISO 9453	Sn97 Cu3	227 / 310	2.2%
ISO 9453	Sn99 Cu1	227 / ~235	2.2% & 3.3%

APPLICATION

ALPHA AS2 is suited for general use where the surfaces are hard to solder. **ALPHA AS2** is qualified for structural soldering, particularly for flame soldering. When cleaning is required, because of easy to corrode base material, flux residues can be cleaned off by water, and if required with additional cleaners.

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. By feeding the cored wire onto the parts, the flux is able to flow and remove oxidized metal, while the solder creates a thin inter-metallic bond which becomes the solder joint.

Note the following tips:

- If using a soldering iron:
- Select a tip size and form to suit the operation: small tips for soldering large components may prevent the formation of a joint or slow the process down.



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- Soldering iron systems should provide sufficient heat to satisfy the requirements of the points above.
- A typical solder tip temperature would be between 120°C and 160°C above the liquidus temperature of the alloy. The ideal temperature to use is dependant on how thermally demanding the assembly is.
- Select a solder wire diameter to suit both the soldering iron tip and the parts/components to be soldered.
- Do not overheat as this causes an increase in the depth of the inter-metallic layer, which in turn weakens the joint.

TECHNICAL DATA

Properties	Typical Values
Halide Content:	6.5 – 7.4 % wt/wt
Classifications:	ORH1 per IPC J-STD-004 2.1.2 per ISO 12224
Copper Mirror	>50% breakthrough per J-STD-004
Surface Insulation Resistance (Not cleaned)	Fails IPC-SF-818 Class III. Test results to J-STD-004 85°C/85 RH / 7 days Comb Down = Fail; Comb Up = 2.49×10^9 Ohms (Pass $>1 \times 10^8$ Ohms)

SAFETY

Observe standard precautions for handling and use. Use in well ventilated areas. DO NOT SMOKE during use. **ALPHA AS2** wire is not considered toxic. However, its use in typical soldering applications will generate a small amount of decomposition and fumes. These fumes should be adequately exhausted / vented for operator safety and comfort. Consult the SDS for additional safety information. The most recent version of the SDS is available from alphaassembly.com.

STORAGE

ALPHA Cored Solder Wires should be stored in dry conditions and within a temperature range of 0°C to 40°C. Alpha guarantees the product shelf life for three years from the date of manufacture when stored in the recommended conditions.

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CONTACT INFORMATION

To confirm this is the most recent issue, please contact Alpha Assembly Solutions

AlphaAssembly.com

North America 300 Atrium Drive Somerset, NJ 08873, USA 800.367.5460	Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 01483.758400	Asia 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100
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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 directory assistance Chemtrec 1 - 800 - 424 - 9300.

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