

Description

The 4933–4935 *Sn100e Lead Free No Clean Solder* is an electronic grade solder wire. It uses a high-purity, eutectic tin/copper/cobalt alloy that is complemented with a no clean, synthetically refined, splatter-proof, resin flux core. The 4933–4935 solder meets J-STD-004 and exceeds J-STD-006 specifications.

This solder is a great lead-free alternative to leaded solders. It generally provides better wetting, contact angle, flow, and visual appearance than typical Sn63/Pb37 no clean solders, while still delivering excellent performance characteristics. It offers superior solder penetration into plated through holes and surface mount interconnects. Further, it is a suitable replacement for SAC305 solder since the 493x forms brighter, shinier, and less grainy joints. Furthermore, it is less expensive than SAC305.

The 4933–4935 solders achieve a consistent solder and flux percentage through a state-of-the-art, extrusion, wire-drawing machine. This machine continually monitors the wire to prevent voids and ensure consistency, providing a top-grade solder wire.

Benefits & Features

- **Eutectic alloy**
(liquidus = solidus temperature)
- **Spreads like rosin activated flux**
- **Virtually non-splattering**
- **Non-corrosive**
- **Non-conductive**
- **Halide free**

COMPLIANCE

- ✓ Dobb Frank ([DRC conflict free](#))
- ✓ REACH ([compliant](#))
- ✓ RoHS ([compliant](#))

Wire Sizes Availability

Cat No.	Std. Wire Gauge	Diameter		Packaging	Sizes
4935	21	0.81 mm	0.032 in	Spool	¼ or 1 lb
4933	25	0.51 mm	0.020 in	Spool	¼ or 1 lb

General Flux Parameters

Property	Value
Residue Removal	Not required
Flux Percentage	2.2%
Flux feature	Wets and spreads like a RA type flux and virtually non-splattering.
Shelf life	Indefinite

Continued on the next page

Flux Core Properties

The synthetically refined resin wets and spreads like a RA flux. This no clean flux is virtually non-spattering. It gives rise to a hard, non-conductive, and non-corrosive residue.

Physical Properties	Method	Value
Flux Classification	J-STD-004 EN29454-1	RELO Type 1.1.3 Resin
Flux Type		Low
Flux Activity		<0.05%
Halides %(wt)		Lightly opaque
Solid Flux Color	Visual	24 °C [75 °F]
Softening Point of Flux Extract		190–210
Acid Value (mgKOH/g sample)	IPC-TM-650 2.3.13	No removal
Copper Mirror	IPC-TM-650 2.3.32	Pass
Silver Chromate—Chlorides + Bromides	IPC-TM-650 2.3.33	130 mm ²
Solder Spread	IPC-TM-650 2.4.46	Pass
Flux Residue Dryness	IPC-TM-650 2.4.47	0.30%
Spitting of Flux-Cored Wire Solder	IPC-TM-650 2.4.48	Non-corrosive
Corrosion Test	IPC-TM-650 2.6.15	2.3 × 10 ¹¹ Ω
Surface Insulation Resistance (SIR)	IPC-TM-650 2.6.3.3	6.1 × 10 ¹¹ Ω
Bellcore (Telecordia)	Bellcore GR-78-CORE 13.1.3	Pass
Electromigration	Bellcore GR-78-CORE 13.1.4	55%
Post Reflow Residue	TGA Analysis	Optional
Cleaning Requirements	—	

Sn100e Alloy Typical Literature Properties

Physical Properties	Value ^{a)}
Color	Silvery-white metal
Density @26 °C [78 °F]	7.4 g/cm ³
Tensile Strength	28 N/mm ² [4 100 lb/in ²]
Elongation	27%
Shear Strength	~20 N/mm ² [~2 900 lb/in ²]
Electric Properties	Value
Volume Resistivity	12.3 μΩ·cm
Electrical Conductivity ^{b)}	15% IACS

a) N/mm² = mPa; lb/in² = psi;

b) International Annealed Copper Standard: 100% give 5.8 × 10⁷ S/m.

Continued on the next page

Continued...

Thermal Properties	Value
Melting Point, Solidus	228 °C [442 °F]
Melting Point, Liquidus	228 °C [442 °F]
Tip Temperature Upper Limit	Do not exceed 425 °C [800 °F]
Coefficient of Thermal Expansion (CTE) ^{c)}	23.5 ppm/°C
Thermal Conductivity	82 W/(m·K)
Specific Heat Capacity	294 J/(kg·K)

NOTE: This table present typical literature values for Sn99.5/Cu0.5/Co alloys.

c) CTE for pure tin; unit conversions: ppm/°C = $\mu\text{m}/(\text{m}\cdot\text{K}) = \text{in}/\text{in}/^\circ\text{C} \times 10^{-6} = \text{unit}/\text{unit}/^\circ\text{C} \times 10^{-6}$

Solder Alloy Composition

Properties	Value	Properties	J-STD-006C	4933–4935 Values
MAIN INGREDIENTS	COMPOSITION	IMPURITIES ^{a)}	REQUIREMENTS	SPECIFICATIONS
Sn	99.3 to 99.7%	Sb	≤0.20% Max	≤0.025% Max
Cu	0.49 to 0.51%	Ag	≤0.10% Max	≤0.001% Max
Co	<0.1%	Bi	≤0.10% Max	≤0.01% Max
		In	≤0.10% Max	≤0.01% Max
		Pb	≤0.07% Max	≤0.05% Max
		Au	≤0.05% Max	≤0.0002% Max
		As	≤0.05% Max	≤0.0035% Max
		Fe	≤0.02% Max	≤0.005% Max
		Ni	≤0.01% Max	≤0.006% Max
		Al	≤0.005% Max	≤0.001% Max
		Zn	≤0.003% Max	≤0.001% Max
		Cd	≤0.002% Max	≤0.001% Max

a) Meets the requirements of J-STD-006

Storage

Protect from direct heat or sunlight. Keep at around between 18 to 27 °C [65 to 80 °F].

Cleaning

The flux residue does not need to be removed for typical applications. If removal is desired, a solvent system like the *MG 4140* can be used. For best results, warm the cleaning solution to about 40 °C [104 °F].

Health and Safety

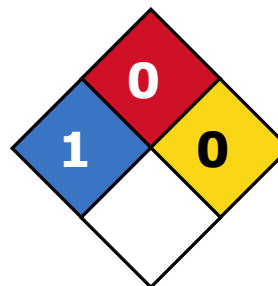
Please see the 4933-4935 **Safety Data Sheet** (SDS) for more details on transportation, storage, handling and other security guidelines.

Health and Safety: Avoid breathing fumes. Wash hands thoroughly after use. Do not ingest.

HMIS® RATING

HEALTH:	* 1
FLAMMABILITY:	0
PHYSICAL HAZARD:	0
PERSONAL PROTECTION:	

NFPA® 704 CODES



Approximate HMIS and NFPA Risk Ratings Legend:

0 (Low or none); 1 (Slight); 2 (Moderate); 3 (Serious); 4 (Severe)

Soldering Instructions

To achieve best hand-soldering results

1. Set the tip temperature between 370–425 °C [700–800 °F].
2. Place the solder tip in contact with the joint connection (lead/pad surface) at an angle of around 50° to heat the parts to be soldered.
3. While the soldering tip is applied, touch the solder wire to the opposite side of the soldering joint, not to the soldering tip.
4. Immediately after the solder has flowed around the whole heated connection, remove the solder wire and remove soldering tip from connection.

TIP! Do not move the connection while the solder is cooling.

WARNING! Avoid putting too much or too little solder.

ATTENTION! To avoid damage, do not overheat electrical component.

Packaging and Supporting Products

Product Availability

<i>Cat. No.</i>	<i>Form</i>	<i>Package</i>	<i>Net Weight</i>	
4933-112G	Solid wire	Spool	112 g	0.25 lb
4933-454G	Solid wire	Spool	454 g	1.0 lb
4935-112G	Solid wire	Spool	112 g	0.25 lb
4935-454G	Solid wire	Spool	454 g	1.0 lb



ISO 9001 Registered Quality System.
Burlington, Ontario, Canada QMI File # 004008

Sn100e Lead Free No Clean Solder 4933–4935 Technical Data Sheet

4933-4935

Technical Support

Contact us regarding any questions, improvement suggestions, or problems with this product. Application notes, instructions, and FAQs are located at www.mgchemicals.com.

Email: support@mgchemicals.com

Phone: 1-800-340-0772 (Canada, Mexico & USA)

1-905-331-1396 (International)

Fax: 1-905-331-2862 or 1-800-340-0773

Mailing address: **Manufacturing & Support**
1210 Corporate Drive
Burlington, Ontario, Canada
L7L 5R6

Head Office
9347–193rd Street
Surrey, British Columbia, Canada
V4N 4E7

Warranty

M.G. Chemicals Ltd. warrants this product for 12 months from the date of purchase by the end user. *M.G. Chemicals Ltd.* makes no claims as to shelf life of this product for the warranty. The liability of *M.G. Chemicals Ltd.* whether based on its warranty, contracts, or otherwise shall in no case include incidental or consequential damage.

Disclaimer

This information is believed to be accurate. It is intended for professional end users having the skills to evaluate and use the data properly. *M.G. Chemicals Ltd.* does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.