

Description

The 4942–4944 *Sn100e Lead Free RA Solder* is an electronic grade solder wire. It uses a high-purity, eutectic tin/copper/cobalt alloy that exceeds J-STD-006 purity specifications. It is complemented with a rosin activated, medium activity flux that is classified as ROM1 according to J-STD-004B.

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 494x forms brighter, shinier, and less grainy joints. Furthermore, it is less expensive than SAC305.

The 4942–4944 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

- **Lead free eutectic alloy**
(liquidus = solidus temperature)
- **Exceeds J-STD-006 impurity requirements**
- **Fast wetting**
- **Fast Flowing**
- **Non-corrosive**
- **Non-conductive residues**

COMPLIANCE

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

Wire Sizes Availability

Cat No.	Std. Wire Gauge	Diameter		Packaging	Sizes
4942	21	0.81 mm	0.032 in	Spool	¼ or 1 lb
4944	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	Fast wetting, fast flowing, non-conductive
Shelf life	Indefinite

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Flux Core Properties

The rosin activated flux wets rapidly and is fast flowing. It is also non-conductive and non-corrosive.

<i>Physical Properties</i>	<i>Method</i>	<i>Value</i>
Flux Classification	J-STD-004 MIL-F-14256F	ROM1 RA Rosin
Flux Type		0.5–2.0%
%Halides		Amber solid
Color	—	80 °C [176 °F]
Softening Point of Flux Extract		150–160
Acid Number (mgKOH/g sample)	IPC-TM-650 2.3.13	Detection
Silver Chromate—Chlorides + Bromides	IPC-TM-650 2.3.33	>1.0 × 10 ⁹ Ω
Surface Insulation Resistance (SIR)	IPC-TM-650 2.6.3.3	Non-corrosive
Corrosion Test	IPC-TM-650 2.6.15	Application dependent ^{a)}
Cleaning Requirements	—	

a) Since there is only 2.2% flux, removal of residue can be considered optional for some applications.

Sn100e Alloy Typical Literature Properties

<i>Physical Properties</i>	<i>Value</i> ^{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]
<i>Electric Properties</i>	<i>Value</i>
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.

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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 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. Store 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

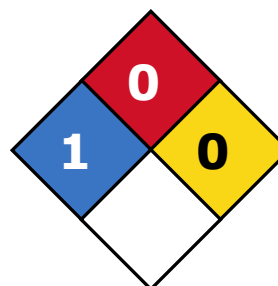
Please see the 4942-4944 **Safety Data Sheet** (SDS) for more details on transportation, storage, handling and other security guidelines.

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

<i>Cat. No.</i>	<i>Form</i>	<i>Package</i>	<i>Net Weight</i>	
4942-112G	Solid wire	Spool	112 g	0.25 lb
4942-454G	Solid wire	Spool	454 g	1.0 lb
4944-112G	Solid wire	Spool	112 g	0.25 lb
4944-454G	Solid wire	Spool	454 g	1.0 lb



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

Sn100e Lead Free RA Solder 4942-4944 Technical Data Sheet

4942-4944

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

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9347-193rd Street
Surrey, British Columbia, Canada
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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.

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