



## Rosin based, activated no-clean solder wire

### Description:

Interflux® **RosIX 705 SnPb(Ag)** is a no-clean solder wire that has been developed to give increased wetting on surfaces that are difficult to solder, e.g. OSP, Ni, Zn, brass, German silver,... as well as on degraded and oxidised surfaces.

The solder wire produces a non disturbing smell while soldering and is pleasant for operators to work with.

**RosIX 705 SnPb(Ag)** produces cosmetically nice solder joints with a smooth and transparent residue.

**RosIX 705 SnPb(Ag)** is useable in both hand soldering and automated soldering processes.

The solder wire contains halogens and is classified as RO L1 according to IPC and EN-standards.



Products pictured may differ from the product delivered

### Key properties

- Increased wetting properties on surfaces that are difficult to solder.
- Non disturbing smell
- Smooth transparent residue

### Availability

Flux type: RosIX 705  
Flux content: 2,2% w/w

alloy	melting point	diameters					
		0,35	0,50	0,70	1,00	1,50	2,00
Sn60Pb40	183°C—191°C	•	•	•	•	•	•
Sn63Pb37	183°C	•	•	•	•	•	•
Sn62Pb36Ag2	179°C	•	•	•	•	•	•

• = available

• = upon request



## Work Instructions

### Manual soldering

The advised working temperature is between 320°C and 360°C. For more dense metals like Nickel, the temperature may be elevated to 400°C.

The use of a good soldering station is important. Use a soldering station with a short response time and with enough power for your application.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact area with the surfaces to be soldered.

Heat up both the surfaces simultaneously. Slightly touch with the solder wire, the point where soldering tip and the surfaces to be soldered meet (the small quantity of solder ensures

a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. This will reduce the risk on flux spitting and premature flux consumption!

## Handling

### Storage

Store the solder wire in a clean environment at ambient temperature.

### Handling

To avoid spool and wire damage, handle package with care.

### Safety

Please always consult the safety datasheet of the product.



## Test results

Conform EN 61190-1-3(2007) and IPC J-STD-004(A)

Property	Result	Method
<b>Chemical</b>		
Flux designator	<b>RO L1</b>	J-STD-004A
	<b>F-SW 26</b>	DIN 8511
	<b>1.1.2</b>	ISO 9454
Qualitative copper mirror	<b>passed</b>	J-STD-004A IPC-TM-650 2.3.32 D
% halide content	<b>&lt; 0,5%</b>	
Fluorides by spot	<b>passed</b>	J-STD-004A IPC-TM-650 2.3.35.1
Total Acid Number (25% sol)	<b>55,94 ± 5 mg KOH/g</b>	J-STD-004A IPC-TM-650 2.3.13
Visual	<b>pass</b>	J-STD-004 Ref. paragraph 3.5.4
Spread Test	<b>155,18 mm<sup>2</sup></b>	J-STD-004A IPC-TM-650 2.4.46
Dryness Test	<b>Passed</b>	J-STD-004A IPC-TM-650 2.6.47
<b>Environmental</b>		
SIR test	<b>pass</b>	J-STD-004 IPC-TM-650 2.6.3.3
Qualitative corrosion, flux	<b>pass</b>	J-STD-004A IPC-TM-650 2.6.15



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## Technical data RosIX 705 SnPb(Ag)



### Packaging

Spools of 100g, 500g and 1000g

Not all diameters are available on all spool sizes

Trade name: RosIX 705 leaded, rosin based, activated no-clean solder wire

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