

OAJ WATER SOLUBLE CORED WIRE

FEATURES

- Excellent Wetting Properties
- High Activity Level
- Reduces Oxidation of Solder Iron Tip
- Residue Washes Easily with DI Water Alone
- Excellent Thermal Transfer

DESCRIPTION

OAJ Flux Cored Solder Wire has been formulated with an innovative amine neutralized halide-activator system. This novel system offers a high activation level that provides rapid oxide removal and maximum capillary action, resulting in faster wetting on all surface finishes and plating. OAJ flux residues MUST be removed after soldering. IPC flux classification – ORH1.

STANDARD AVAILABILITY

OAJ Cored Wire is available in Sn/Pb, SAC305 and SN100C[®] alloys. Other alloys, diameters and spool sizes may be available upon request.

APPLICATION

Solder iron tip temperature should be between $350^{\circ} - 400^{\circ}C$ ($650^{\circ} - 750^{\circ}F$) for Sn63, Sn62 and Sn60 alloys, $370^{\circ} - 425^{\circ}C$ ($700^{\circ} - 800^{\circ}F$) for SN100C®, Sn/Ag and Sn/Ag/Cu (SAC305, SAC405, CASTIN, etc.) alloys.



HANDLING & STORAGE

Time	Conditions
3 years	Cool < 30°C (< 86°F) Dry < 75%Rh

Store cored wire in a clean, dry area away from moisture and sunlight. Avoid freezing.

CLEANING

Post-process residues can remain in place up to 8 hours^{*}. Flux residue can be removed with normal tap water @ $38^{\circ} - 60^{\circ}C$ ($100^{\circ} - 140^{\circ}F$) with a DI water final rinse. Use of a pressurized spray cleaning system is suggested, but is not required.

*Environment and application dependent

SAFETY

Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

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TECHNICAL DATA SHEET

Test Method

Test Method

J-STD-004B 3.4.1.1

IPC-TM-650 2.3.32

J-STD-004B 3.4.1.2

IPC-TM-650 2.6.15 J-STD-004B 3.4.1.3

IPC-TM-650 2.3.28.1

J-STD-004B 3.5.1.1

IPC-TM-650 2.3.33

J-STD-004B 3.5.1.2

J-STD-004 3.4.1.4

IPC-TM-650 2.6.3.3

J-STD-004B 3.4.1.4

IPC-TM-650 2.6.3.7

J-STD-004B 3.4.2.1

IPC-TM-650 2.3.34

J-STD-004B 3.4.2.2

IPC-TM-650 2.3.13

J-STD-004B 3.4.2.5 J-STD-005A 3.9

IPC-TM-650 2.4.45

IPC-TM-650 2.3.35.1

J-STD-004B 3.3.1

J-STD-004

TEST DATA SUMMARY Name

IPC Flux Classification

IPC Flux Classification

Name

Copper Mirror

Quantitative Halides

Qualitative Halides,

Qualitative Halides,

Surface Insulation

Surface Insulation

Silver Chromate

Fluoride Spot

Resistance

Resistance

Flux Solids.

Nonvolatile

Acid Value

Visual

Wetting

Determination

Determination

Corrosion

Fluoride	J-STD-004B IPC-TM-650	PASS			
Flux Spreading	J-STD-004B 3.7.2 IPC-TM-650 2.6.14.1	PASS			
Metal/Flux Content	J-STD-005A 3.4 IPC-TM-650 2.2.20	98% / 2%			
Spread	J-STD-004B 3.7.2 IPC-TM650 2.4.46	PASS			
Cleanliness	TM125-03	PASS			
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Results

High - > 50%

Major Corrosion

 \geq 2.0% Typical

Halides Detected

None Detected

 $>100M\Omega$

>100MΩ

100%

Typical

Typical White Solid

PASS

 104 ± 2.68

Removal

DISCLAIMER information or the use of any materials designated. Please refer to http://www.aimsolder.com/terms-conditions to review AIM's terms and conditions.



Results

ORH1

ORH1

OAJ

31033

Image

Uncleaned

Cleaned

Cleaned

CONTROL

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