



SPECIFICATION

**NAME : ALMIT SR34 SUPER LFM-48
Lead Free Cored Solder Wire**

Lot No.	Marketing Name
	ALMIT SR34 SUPER LFM-48 Flux Content =3.5% Dia (mm): 0.5, 0.65, 0.8, 1.0, 1.2, 1.6.

NIHON ALMIT Co. Ltd.

Head Office: Almit Bldg., 2-14-2, Yayoicho, Nakano-ku, Tokyo164, **Japan.**
Tel: 03-3379-2277 Fax: 03-3374-2593

Almit Technology Ltd: Unit 7, Forest Row Business Park, Station Road, Forest Row,
East Sussex. RH18 5DW. **England**
Tel: +44(0)1342 822 844 Fax: +44(0)1342 824 155

Almit GmbH: Ohrnbachtalstr.33, D-64720. Michelstradt. **Germany.**
Tel: +49 0600-969 100 Fax: +49 6066-969 102

Venso Elektronik AB: Ogardevagen 21, SE-433 30 Partille, **Sweden**
Tel: +46(0)31 3400250 Fax: +46(0)31 3400275

1. Product Name: Almit SR34 SUPER LFM-48

2. Scope: This specification is for Almit flux cored solder wire, Almit SR34 SUPER LFM-48
Delivered by Nihon Almit Co, Ltd to Messrs. _____

3. Chemical Composition: (%) :

Composition	Sn	Cu	Ag	Sb	Pb	Bi	Zn	Fe
LFM 48	95.5~97.5	0.3~0.7	2.8~3.2	≤0.20	≤0.09	≤0.10	≤0.003	≤0.020

Al	As	Cd	Au	In	Ni	P	S
≤0.005	≤0.030	≤0.002	≤0.05	≤0.10	≤0.010	≤0.010	≤0.005

4. Physical Properties:

	LFM-48	Sn63
Melting Point: Solidus (°C)	217	183
Liquidus(°C)	220	183
Specific Gravity	7.4	8.4

5. Characteristics:

Items	Characteristics	Test Methods
Chlorides and Bromide by Silver Chromate Method (%)	Not passed	IPC-TM-650;2,3,33
Corrosion Test (%)	Passed	IPC-TM-650;2,6,15
Copper Mirror Test	M(Less than 50% breakthrough)	IPC-TM-650;2,3,32
SIR Test (Ω)	□ 1×10 ⁸	IPC-TM-650;2,6,3,5 85□85%,168h
Spread Test (%)	≥ 70	IPC-TM-650;2,4,46

6. Dimensions: Weight and Tolerances as follows:

Dia (mm)						Weight of one Roll (Kg. Net)	
0.5	0.65	0.8	1.0	1.2	1.6	0.5	0.8
± 0.05						+0.01 -0	

*0.5 mm= 0.5kg spool, 0.8mm to 1.6mm =0.8kg spool

7. Construction of one Lot:

A lot contains 500 Kgs which is the amount of a single melting.

8. Packaging: Almit SR34 SUPER LFM-48

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8 Kg	Plastic Bag	5 & 8 Kg	Cardboard Box

9. Identification:

Roll		Cardboard Box	
Name	Almit SR34 SUPER LFM-48	Name	Almit SR34 SUPER LFM-48
Flux Content	3.5%	Flux Content	3.5%
Diameter	mm Dia	Diameter	mm Dia
Weight	0.8 Kg.	Weight (Nett)	8 Kg.
Lot No.	(Ex 99.1.10)	Lot No.	(Ex. 99.1.10)
Maker	Nihon Almit Co.Ltd.	Maker	Nihon Almit Co.Ltd.

10. Makers Address:

Nihon Almit Co. Ltd. Almit Bldg. 2-14-2 Yayoicho, Nakano-ku. Tokyo, **JAPAN.**

11. Changes to this specification must be approved by:-

Signed _____ Date _____

**12. This product is manufactured from guaranteed materials according to the
" LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES"**