



SPECIFICATION

NAME : ALMIT KR – 19 60A P-2.5 Flux Cored Solder Wire

Lot No.	Marketing Name
	ALMIT KR - 19 60A Flux Content P-2.5 (2~3%) Dia (mm): 0.5 0.65 0.8 1.0 1.2 1.6 2.0

NIHON ALMIT Co. Ltd.

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1. **Product Name:** Almit KR – 19 60A P-2.5

2. **Scope:** This specification is specified for Almit flux cored solder wire Almit KR – 19 60A P-2.5
Delivered by Nihon Almit Co, Ltd to Messrs. _____

3. **Dimensions: Weight and Tolerances as follows:**

Diameter in mm							Weight of one Roll (Kg.Nett)		
0.5	0.65	0.8	1	1.2	1.6	2	0.5	0.8	1
+/- 0.05		+/- 0.1					+ 0.01 - 0		

* 0.65mm Dia contains 800g and the 0.5mm Dia 500g

4. **Chemical Composition: (wt. %) :**

Composition	Sn	Pb	Sb	Bi	Cu	Zn	Fe	Al
Standards	59.0/61.0	Bal	≤ 0.12	≤ 0.1	≤ 0.05	≤ 0.002	≤ 0.02	≤ 0.002

As	Cd	Au	Ag	In	Ni	P	S
≤ 0.03	≤ 0.002	≤ 0.2	≤ 0.1	≤ 0.1	≤ 0.01	≤ 0.01	≤ 0.005

5. **Characteristics:**

Items	Characteristics	Test Methods
Flux Content (%)	P-2 (2.0~3.0)	JIS-Z-3197:1999
Chloride & Bromide	0	By Ionchromat analyser
Insulation Resistance (Ω)	> 1 x 10 ⁸	JIS-Z-3197:1999 85°C/85%RH;168hr
Spreadability (%)	> 80	JIS-Z-3197:1999
Cu Plate Corrosion Test	Pass	JIS-Z-3197:1999
Dryness	Chalk powder should be easily removed from each test piece	JIS-Z-3197:1999
Solution Resistance (Ω cm)	> 50,000	JIS-Z-3197:1999
Flux Type	M1	J-STD-0004

6. **Physical Properties:**

Solidus Degs C	Liquidus Degs C	Specific Gravity
183	190	8.5

7. **Construction of one Lot:**

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

8. Quality & Inspection:

Test No.	Test Items	Estimation Results
1	Crack	Usable State
2	Smear	Usable State
3	Luster	Usable State
4	Size (mm)	0.5, 0.65, +/- 0.05 0.8, 1.0, 1.2, 1.6, 2.0, +/- 0.05
5	Weight (Kg.Nett)	0.5, 0.8, 1.0, + 0.01 - 0
6	Sn (%)	59.0 ~ 61.0
7	Pb and Impurities	Rest
8	Sb (%)	< 0.12
9	Flux Content (%)	P-2.5 (2.0~3.0)
10	Chloride & Bromide	Zero (by Ionchromat analyser)
11	Solution Resistance (Ω cm)	> 50,000
12	Insulating Resistance (Ω)	> 1 x 10 ⁸
13	Spreadability (%)	> 80

9. Test Method:

The tests are carried out in accordance with Federal Specification QQ-S-571F and JIS-Z-3197. (Test Method of Rosin Flux for Soldering)

10. Packaging:

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8, 1.0 Kg	Plastic Bag	5, 8, 10 Kg	Cardboard

11. Identification:

Roll		Cardboard	
Name	Almit KR-19 60A	Name	Almit KR-19 60A
Weight	(Ex. Nett 1 Kg)	Weight (Nett)	(Ex. Nett 10 Kg)
Lot No.	(Ex. 92.1.10)	Lot No.	(Ex. 92.1.10)
Sn Content	Sn60	Sn Content	Sn60
Size	mm Dia	Size	mm Dia
Maker	Nihon Almit Co.Ltd.	Maker	Nihon Almit Co.Ltd.
Standard	QQ-S-571F	Standard	QQ-S-571F

12. Maker Address:

Nihon Almit Co. Ltd. Miyata Bldg. 6F, 1 - 38, Yoyogi, Shibuya-ku, Tokyo, 151, JAPAN.

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

Signed _____ Date _____

14. This product is manufactured from guaranteed materials according to the

" **LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES** "

15. The basic quality of Solder and Flux in this product conforms to Federal Spec. QQ-S-571E

End