



## SPECIFICATION

**NAME : ALMIT KR - 19 SH RMA (Ag2) Flux Cored Solder Wire**

<b>Lot No.</b>	<b>Marketing Name</b>
	ALMIT KR - 19 SH RMA Sn 62 (Ag2) Flux Content P-2 type ( 1.6~2.6%) Dia (mm): 0.3 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, Tokyo  
164, **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: FloBerstrasse 56, D-74321, Bietigheim-Bissingen,  
**Germany**  
Tel: +49(0)7142 773327 Fax: +49(0)7142 773335

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

1. **Product Name:** Almit KR - 19 SH RMA (Ag2) P-2

2. **Scope:** This specification is specified for Almit flux cored solder wire, Almit KR-19 SH RMA (Ag2) P-2

Delivered by Nihon Almit Co, Ltd to Messrs: \_\_\_\_\_

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

Dia (mm)							Weight of one Roll (Kg.Nett)		
0.3	0.5	0.65	0.8	1	1.2	1.6	0.5	0.8	1
± 0.05							+ 0.01 - 0		

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

Composition	Sn	Ag	Pb	Cu	Zn	Fe	Al	As
Standards	61.5~62.5	1.7~2.3	Rest	≤ 0.08	≤ 0.005	≤ 0.02	≤ 0.005	≤ 0.03

Au	Bi	In	Ni	P	S	Cd	Sb
≤ 0.2	≤ 0.1	≤ 0.1	≤ 0.01	≤ 0.01	≤ 0.005	≤ 0.005	≤ 0.5

5. **Characteristics:**

Items	Characteristics	Test Methods
Flux Content ( % )	P-2 (1.6~2.6)	QQ-S-571F
Chloride & Bromide	Pass	QQ-S-571F
SIR after Humid Conditions (Ω)	Class AA > 1 x 10 <sup>12</sup>	JIS-Z-3197
Surface Insulation Resistance (Ω)	> 1 x 10 <sup>9</sup>	QQS-571F 85C°/85% RH,165hr
Spreadability ( % )	> 80	JIS-Z-3197:1999
Copper Mirror Test	Pass	QQ-S-571F
Copper Plate Corrosion	Smaller than that of the Standard sample	JIS-Z-3197:1999
Dryness	Chalk powder should be easily removed from each test piece	QQ-S-571F
Solution Resistance (Ω cm)	> 100,000	QQ-S-571F
Flux Type	L1	J-STD-0004

6. **Physical Properties:**

Solidus Degs C	Liquidus Degs C	Specific Gravity
179	182	8.4

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 Dia.)	0.3, 0.5, 0.65, 0.8, 1.0, 1.2, 1.6 : $\pm 0.05$
5	Weight ( Kg.Nett )	0.5 0.8, 1.0 : +0.01 - 0
6	Sn (%)	61.5~62.5
7	Pb and Impurities	Rest
8	Ag (%)	1.7~2.3
9	Flux Content (%)	P-2 (1.6 ~ 2.6)
10	Chloride & Bromide	Pass
11	Solution Resistance ( $\Omega$ cm)	100,000
12	SIR after Humidity ( $\Omega$ )	Class AA: $> 1 \times 10^{12}$
13	Spreadability (%)	$> 80$

## 9. Test Method:

Tests should be carried out to Federal Spec. QQ-S-571E and JIS - Z - 3197.

## 10. Packaging: Almit KR-19 SH RMA (Ag2)

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.5, 0.8, 1.0 Kg	Vinyl film roll	5, 8, 10 Kg	Cardboard

## 11. Identification:

Roll		Cardboard	
<b>Name</b>	Almit KR-19 SH RMA (Ag2)	<b>Name</b>	Almit KR-19 SH RMA (Ag2)
<b>Weight</b>	1 Kg.	<b>Weight (Nett)</b>	10 Kg.
<b>Lot No.</b>	( Ex 62.3.13 )	<b>Lot No.</b>	( Ex. 62.3.13 )
<b>Sn Content</b>	Sn62	<b>Sn Content</b>	Sn62
<b>Flux Content</b>	P-2	<b>Flux Content</b>	P-2
<b>Size</b>	mm Dia	<b>Size</b>	mm Dia
<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>	<b>Maker</b>	<b>Nihon Almit Co.Ltd.</b>
<b>Standard</b>	QQ-S-571F	<b>Standard</b>	QQ-S-571F

**12. Makers 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 \_\_\_\_\_

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

**End**