

WBT Silver Solder (lead-free)

○ **WBT-0825**
0.8 mm dia.

○ **WBT-0845**
1.2 mm dia.

WBT Silver Solder is a quality, lead free solder which has been especially designed for use with high quality connectors, cables and electronic parts.

The **fine silver content of 3,8%** guarantees optimum metallurgical and electrical properties. The **halogen free flux** (organic resin based) allows for a proper wetting during the soldering operation, protects the surface and warrants a long term, stable and corrosion resistant joint. The soldering joint created with WBT Silver Solder contains no hygroscopic parts.

The **melting point of 216/219°C** is manageable and one of the lowest amongst lead free solder. Fundamentally lead free solder requires a higher soldering temperature than solder containing lead. A careful operation and a clean working surface should be maintained in order to prevent any damage to the materials around the joint through over heating.

The finished surface of the soldered joint will be generally less bright but

rather matt and less smooth than that of lead containing solder. Nevertheless, by observing the suggested recommendations, the resultant joint will be conductive and durable.

Recommended processing instructions:

- Capacity of the soldering equipment: 45 – 100 W
- Ideal temperature of the soldering tip: ca. 290°C

Important Information

Lead free and lead containing solder should never be mixed since uncontrollable melting temperatures could result! Therefore, it is preferable that lead free solder should not be used when repairing or supplementing a joint containing lead.

The inhalation of the resultant fumes during soldering represents a health risk. The higher soldering temperatures of lead free solder yield aggressive and in part metalliferous fumes. Adequate ventilation (extractor fan) should be provided in the working environment.