

PRODUCT DATA SHEET

CW-807

Halogen-Free No-Clean Flux-Cored Wire

Introduction

CW-807 is Indium Corporation's best selling flux-cored wire primarily because it is compatible with all Indium Corporation no-clean solder pastes, wave fluxes, and all common soft solder alloys. It also solders very well while still meeting the most recent requirements of J-STD-004B type ROLO. **CW-807** contains less than 500 ppm total halogen, so it can be considered halogen-free by both J-STD-004B and JEITA ET-7304. **CW-807** passes the more stringent Surface Insulation Resistance (SIR) and Electromigration (ECM) requirements of J-STD-004 revision B, therefore the no-clean residue will be electronically safe for virtually all applications. Also when properly configured,* cored wire with **CW-807** yields superior results in automated soldering operations, including laser soldering.

Features

- Halogen-free per J-STD-004B***
 To be halogen-free per J-STD-004B, the formula must contain less than 500ppm of any kind of halogen, ionic or nonionically bonded chlorine, bromine, or fluorine. This is new to J-STD-004B since fluxes that conform to the original J-STD-004 or J-STD-004A may still contain halogens that only disassociate at soldering temperatures, but leave a residue that contains ionic halogen.
- Light-colored, low-smoking, rosin-containing flux**
 Rosin, modified rosins, and resins contribute to enhanced heat stability and reliability. However, in some cases, rosins and resins may interfere with probe-testability.
- Tested compatibility with Hot Air Solder Leveled (HASL), Immersion Silver, Electroless Nickel Immersion Gold (ENIG), and Organically Solder Preserved (OSP) Copper surfaces.**
- Tested for use with all common lead-free and tin-lead alloys, including:**
 SAC305; SAC105; SAC0307; SACm™; 96.5Sn/3.5Ag; 63Sn/37Pb; 60Sn/40Pb; 93.5Pb/5Sn/1.5Ag; Indalloy® 227; Indalloy® 254; silver-free tin-copper plus additive alloys, such as Indium Corporation's Sn995; and many others.

Physical Properties

In the core, **CW-807** has a clear, colorless appearance. Upon soldering, **CW-807** smokes very little and has a mild, sweet odor. **CW-807** contains no added volatile solvents or water absorbent materials to limit spattering. The flux residue is clear and slightly shiny. It typically blends in well with epoxy glass circuit boards and does not detract from the board's appearance.

IPC J-STD-004B Classification	ROLO
Rosin Containing	Yes
Halogen Content	<500 ppm
Smoke	Minimal
Odor	Mild, sweet
Softening Point	74°C
Color	Clear, light
Compatible Alloys	All common soft solder alloys, including, but not limited to: SAC305; SACm™0510; Sn995; SAC105; SAC0307; SAC387; 96.5Sn/3.5Ag; 95Sn/5Sb; Indalloy® 227; Indalloy® 254; 63Sn/37Pb; 60Sn/40Pb; 93.5Pb/5Sb/1.5Ag; 43Sn/43Pb/14Bi; and many others.

Form No. 98757 R2

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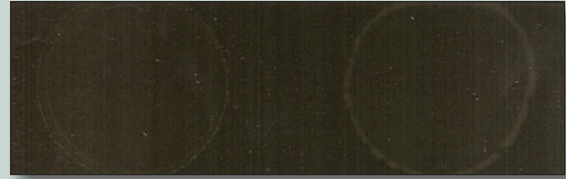
Test Data

Copper Mirror

The J-STD-004B copper mirror test is performed per IPC-TM-650 method 2.3.32. To be classified as an "L" type flux, there should be no complete removal of the mirror surface. **CW-807** shows no complete removal of the copper mirror and, therefore, is classified as an ROLO.



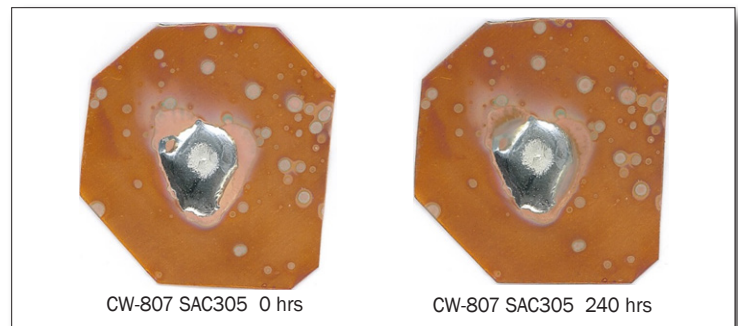
CW-807 5% soln (IPA) Standard Rosin
Front Side



CW-807 5% soln (IPA) Standard Rosin
Back Side

Copper Corrosion

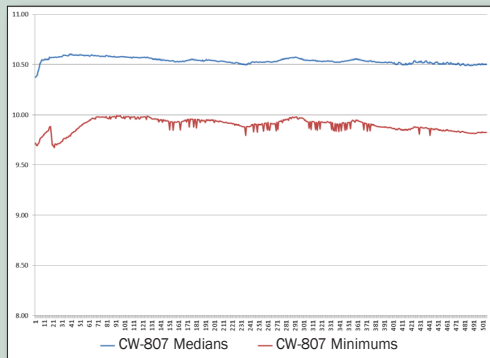
Copper corrosion is tested per IPC-TM-650 method 2.6.15. This test gives an indication of any visible reactions that take place between the flux residue after soldering and copper surface finishes. In particular, green copper corrosion (formed as copper-chloride) should not be seen.



CW-807 SAC305 0 hrs

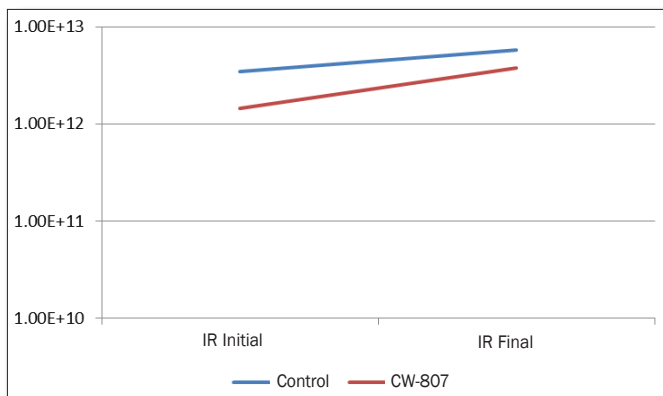
CW-807 SAC305 240 hrs

Surface Insulation Resistance (SIR)



The Surface Insulation Resistance test is performed per IPC-TM-650 Method 2.6.3.7, using boards prepared per IPC-TM-650 method 2.6.3.3. All boards soldered with **CW-807** pass the requirements of having exhibited no dendritic growth, no visible corrosion, and a minimum insulation resistance of 100 megohms (1×10^8). The values shown on the adjacent graph show the number of ohms times ten to the power of the vertical axis. The IPC-TM-650 SIR is a 7-day test and gives a general idea of the effect of the flux residue on the electrical properties of the surface of the circuit board.

Electromigration (ECM)



	Control	CW-807-A
IR Initial	3.43E+12	1.44E+12
IR Final	5.73E+12	3.75E+12

The electromigration test is performed to IPC-TM-650 method 2.6.14.1 with boards prepared using IPC-TM-650 method 2.6.3.3. The test conditions for this test are 496 hours at $65^\circ\text{C} \pm 2^\circ\text{C}$ and $88.5\% \pm 3.5\%$ RH. To pass this test, there should be no visible corrosion and no dendritic growth that decreases line spacing by more than 20%. In addition, the insulation resistance should not drop more than one order of magnitude after the first 96-hour stabilization period when a bias voltage is applied. **CW-807** passes all of the ECM requirements.

Performance Test (Spread Test)

The spread test is not a pass/fail test, but rather is one that measures the relative wetting strength and surface tension characteristics of fluxes. The spread test is performed per IPC TM-650 method 2.6.46A. A 10% solution of flux solids is created. A known volume is then applied along with a known volume of 60Sn/40Pb solder to a brass coupon and reflowed at 508 °F. After reflow, the area of solder is measured. The test is performed three times and an average is determined.

Test	Area
1	61.4574 mm ²
2	70.9803 mm ²
3	68.4278 mm ²
x-bar	66.9552 mm ²

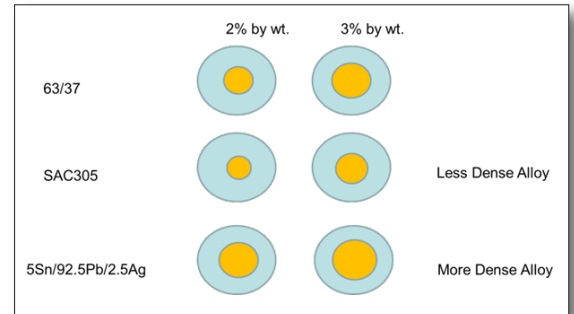
Application Recommendations

Soldering Iron Temperature		
Alloy Family	Alloy Melting Range	Soldering Iron Temperature
Tin-Lead	170°C to 190°C	340°C to 370°C
Lead-Free	210°C to 250°C	370°C to 400°C
High Lead	280°C to 320°C	400°C to 425°C

Choosing the correct soldering tip temperature is a balancing act between optimizing the speed of heating up the solder joint, melting the solder, charring of the flux, and degradation of the soldering iron tip. At lower temperatures, soldering occurs more slowly, but there is less of a chance of damaging circuit boards, fluxes will not char, and soldering iron tips last longer. The recommendations above are for a middle path between performance and safety.

Cored Wire Flux Percent

Indium Corporation is capable of coring wire in a variety of flux percents. Flux cores are typically determined by weight percent of flux compared to weight percent of solder. As can be seen by the graphic to the right, 1% more flux by weight adds considerably more flux by volume. The trade-off: higher flux contents make soldering faster, easier, and reduce defects, but increase the amount of residue that can be seen cosmetically and that may interfere electrically. The most common nominal flux contents are 2% by weight and 3% by weight.



Cored Wire for Robotic and Laser Soldering

Indium Corporation specializes in making fine diameter wire, typically between 0.008" (0.2mm) and 0.015" (0.375mm) diameter for robotic and laser soldering. To make robotic and laser soldering effective and eliminate peaking and bridging with a mild, halogen free cored wire flux such as the **CW-807**, higher than normal flux content must be used. The standard range of flux content for lead-free (SAC305 and similar alloys) robotic or laser soldering is 4.3% to 4.7% by weight.

Shelf Life

When stored in a cool, dry environment, there is no reason that Indium Corporation's cored wire cannot retain its intended soldering properties for many years. The main causes of degraded cored wire reflow performance are the buildup of a thick oxide layer on the surface of the wire, caused by prolonged exposure to higher than normal temperature and humidity conditions, or the buildup of lead carbonate on high-lead (>90%) alloy cored wire shipped or stored under very high humidity conditions.

	Warranted	Practical*
Tin-Lead Alloys	3 years from DOM	Indefinite
Lead-Free Alloys	3 years from DOM	Indefinite
>90% Lead Alloys	1 year from DOM	Indefinite

*When stored at less than 40°C and less than 80% RH

Residue Removal Recommendations

All of Indium Corporation's no-clean fluxes, including this formula, are designed to be electrically safe under normal consumer electronic and telecommunication operating conditions. Unless otherwise specified, electrically safe means that the post soldering residues pass J-STD-004B SIR and ECM testing. However, it is understood that some customers desire to remove residues for cosmetic reasons, improved in-circuit testing, improved compatibility with specific conformal coatings, or where the operating parameters of the circuit board may be in extreme conditions for a prolonged period.

If the removal of no-clean flux residues is desired, most commercially available cleaning agents will be effective. Indium Corporation's Technical Support Engineers work closely with cleaning agent vendors and have confirmed flux residue removal capabilities from several vendors using their recommended products and parameters. It is unlikely that users of Indium Corporation's no-clean products will need to change their current residue removal materials and parameters from those currently used. However, when establishing a new process or desiring confirmation of process recommendations, please contact Indium Corporation's Technical Support Staff for assistance.

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Indium Corporation Compatible Products

- Solder Paste: Indium8.9HF
- Wave Flux: WF-9945 (rosin-containing) or WF-9955 (low or no rosin)
- Flux Pen: FP-500 (rosin-containing)

Indium Corporation's cored wire has been designed to be fully compatible with our solder paste, wave fluxes, and rework fluxes, and is also expected to be compatible with many of our competitors' products. For example, **CW-807** cored wire flux is not only compatible with Indium8.9HF solder paste, but also with our 5.2LS, 8.9 series, 92 series, and 10 series products. Indium Corporation determines compatibility primarily by matching flux chemistry. However, a select number of wave, reflow, and rework product combinations have been thoroughly tested to ensure that the combined flux residues meet the electrical and reliability requirements of IPC J-STD-004B. Please contact Indium Corporation Technical Support if you are interested in knowing about these fully-tested combinations.

Health, Safety, Environmental, and Shipping

REACH

No substances of very high concern (SVHC) are used in this product.

Hazard Labels

For all CW-807 Cored Wire:



For Lead-Containing CW-807 Cored Wire:



Shipping Classification

Transport in accordance with applicable regulations and requirements. Not regulated under US DOT (United States Department of Transportation).

Not hazardous under shipping regulations. UN–none

Additional Information

Commonly Available Diameters and Packaging

Diameter	Spool Weight	63/37 Length	SAC305 Length
0.010" ± 0.002"	1/4 lb	966 ft	1097 ft
0.015" ± 0.002"	1/4 lb	429 ft	487 ft
0.020" ± 0.002"	1 lb	966 ft	1097 ft
0.025" ± 0.002"	1 lb	618 ft	702 ft
0.032" ± 0.002"	1 lb	377 ft	428 ft
0.040" ± 0.002"	1 lb	242 ft	274 ft
0.062" ± 0.002"	1 lb	101 ft	114 ft
0.25mm ± 0.05	125 g	324 m	368 m
0.40mm ± 0.05	125 g	144 m	164 m
0.50mm ± 0.05	500 g	324 m	368 m
0.60mm ± 0.05	500 g	208 m	236 m
0.80mm ± 0.05	500 g	127 m	144 m
1.00mm ± 0.05	500 g	81 m	92 m
1.55mm ± 0.05	500 g	34 m	38 m

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