

PRODUCT DATA SHEET

CW-102 Non-Activated Rosin Flux-Cored Wire

Introduction

Non-Activated Flux-Cored Wire CW-102 is a type "R" flux to be used with legacy military contracts requiring a flux-cored wire meeting QQ-S-571F (or predecessor). **CW-102** contains pure Grade WW gum rosin.

Features

- Contains Grade WW gum rosin
- Does not contain any additional activators
- Meets legacy specification QQ-S-571F type "R"
 - WRP2 or WRP3
- IPC J-STD Type ROL0

Physical Properties

Halogen Content	<50ppm
Silver Chromate Halide Test	Pass
Fluoride Spot	Pass
Copper Mirror Corrosion	Pass
Corrosion	Pass
Color	Amber
Odor	Mild (rosin)
Recommended Flux %	2% (WRP2) 3% (WRP3)
Compatible Alloys	63Sn/37Pb, 60Sn/40Pb, SAC305, and Cobalt995 Most other alloys melting between 140–330°C

Suitable for Soldering

- Gold
- Silver
- Solder coat
- Tin
- Clean copper

Commonly Available Diameters and Packaging

Metric Units		English Units	
Diameter	SAC305 Length	Diameter	SAC305 Length
.254mm ± .051mm	595m	.010" ± .002"	1,950ft
.381mm ± .051mm	618m	.015" ± .002"	2,025ft
.508mm ± .051mm	347m	.020" ± .002"	1,140ft
.813mm ± .051mm	136m	.032" ± .002"	445ft

Values are only approximate. Actual lengths will vary.

Shelf Life

	Warranted	Practical*
Tin-Lead Alloys	10 years from DOM	Indefinite
Lead-Free Alloys	10 years from DOM	Indefinite
>85% High-Lead	2 years from DOM	Indefinite

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

Always store cored wire in a cool, dry environment. 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 (>85%) alloy cored wire shipped or stored under very high-humidity conditions.

Technical and Customer Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Materials Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder properties, alloy compatibility and selection of solder preforms, wire, ribbon, and paste. Indium Corporation's Technical Support Engineers provide rapid response to all technical inquiries.

Safety Data Sheets

Please refer to the SDS document within the product shipment, or contact our local team to receive a copy.

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All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified. Indium Corporation is an ISO 9001:2015 registered company.

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