

## PRODUCT DATA SHEET

# Replenisher Bar

### Introduction

During wave soldering, when the molten solder contacts a copper-containing PCB such as an OSP board, the copper from the board can be pulled into the solder wave, increasing the solder pot's copper content to undesirable levels. As copper levels gradually rise to become out-of-spec within an Indalloy®291 solder pot, adverse effects to wetting performance and solder joint aesthetics can become more perceptible. Indium Corporation's **Replenisher Bar** is used to bring the copper levels back within the recommended solder pot specifications.

### Features

- Brings solder pots with high, out-of-spec copper levels back within spec
- Improved wetting performance
- Reduces melting point temperature and brings alloy back to eutectic state
- Aesthetically sound fillets

### Adding to an Indalloy®291 Solder Pot

To rebalance an out-of-spec solder pot, a calculated amount of **Replenisher Bar** will need to be added to the pot. Shorting or exceeding this calculation for **Replenisher Bars** can adversely affect soldering performance. Upon request, Indium Corporation will analyze the solder pot and provide technical support regarding how much **Replenisher Bar** should be added to optimize the solder pot. When adding the **Replenisher Bar** into the solder pot, it is recommended to do so into the solder pot only. We do not recommend adding the **Replenisher Bar** into the wave.

### Standard Packaging and Availability

Form	Packaging
Solder Bar	25lbs per box
Bar Solder Chips	25lbs per box

This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the products described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

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.

## From One Engineer To Another®

Contact our engineers: [askus@indium.com](mailto:askus@indium.com)

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### Solder Analysis

Solder pot analysis is important for maintaining solder joint quality and optimal first-pass soldering yield. By allowing a solder pot to collect too high a level of contaminants from circuit boards and components, the solder can get sluggish, causing overly large fillets, poor wetting, bridging, and expensive rework and repair. Indium Corporation's solder analysis service allows customers to purchase an individual analysis or pre-paid solder analysis mailers in bulk. Contact Indium Corporation at 1-315-853-4900 or 1-800-4INDIUM.

### Solder and Solder Dross Recycle Program

The Solder and Solder Dross Recycle Program is a service offered by Indium Corporation to complete the usage cycle for bar solder. Up to 50% of bar solder used in wave soldering will be converted to dross, which still contains mostly usable metal. Indium Corporation can recycle these materials and return the metal value to you as a credit, or convert them to usable bar for a fee. During an alloy switchover, use Indium Corporation's recycling service to reclaim value on the pot dump and leftover bar. For more information about our Solder and Solder Dross Recycle Program, please send an email to [askus@indium.com](mailto:askus@indium.com).

### Technical 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

The SDS for this product is available by contacting [askus@indium.com](mailto:askus@indium.com)



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