

FONTARGEN A/AF 611

Silver-bearing, lead-free solder



EN ISO 9453:	S-Sn96Ag4 / Alloy-no. 701
A 611	Blank wire
AF611 F-SW 26	Cored wire with DIN EN 29454.1 (Flux) : 1.1.2 (non corrosive flux, colophony base)
AF 611 F-SW 12	Cored wire with DIN EN 29454.1 (Flux) : 3.1.1 (corrosive flux)

Composition, typical analysis (% w/w):

Ag	Sn
3.5	Remainder

Mechanical and physical properties:

Melting range:	221 - 230 °C
Tensile strength (solder):	44 N/mm ²
On Ms 58:	53 N/mm ²
Shear strength on Cu:	30 N/mm ²
On Ms:	20 N/mm ²
On St:	25 N/mm ²
Hardness (BHN):	15 HB
Electrical conductivity:	7.5 Sm/mm ²
Specific gravity:	7.3 g/cm ³

Characteristics / Applications:

Solders on steel, stainless steel, copper and copper alloys. Foodstuffs industry, electrical industry and general apparatus engineering, refrigerating industry, copper pipe installations, hot and cold water installations, heating installations up to 100 °C, oil piping in accordance with DVGW specification sheet.

Lead- and cadmium-free eutectic solder with very good flowing properties. The solder remains brilliant even after a long period of using the soldered objects. Cold-resistant up to -200 °C.

Heat sources:

Acetylene torch (fuel gas excess), air-gas torch, soldering lamp, soldering iron, dip bath.

Flux:

F 600 - Series

Availability:

Bare rods	Cored wire	Wire	Foil	Preforms	Powder	Paste
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13/10/JL/2