

# FONTARGEN A 630

## Soft solder



EN ISO 9453:	S-Pb50Sn50 / Alloy-no. 111
DIN EN 29454.1 (Flux):	F 600: 3.1.1.A (corrosive fluid, for low alloyed and alloyed steel and heavy metals)
	F 600 CW: 3.1.1.C (paste-like, soldering flux, activated, limited corrosive)
	F 600 CC: 1.1.2. (paste-like, colophony based)
	Soft solder with active flux core
	1.1.2 C. (paste-like, colophony based)

### Composition, typical analysis (% w/w):

Sn	Sb	Pb
50	0.12	Remainder

### Mechanical and physical properties:

Melting range:	183 - 215 °C
Tensile strength (solder):	39 N/mm <sup>2</sup>
On Ms 58:	81 N/mm <sup>2</sup>
Hardness (BHN):	12 HB
Electrical conductivity:	6.7 Sm/mm <sup>2</sup>
Specific gravity (metal):	8.9 g/cm <sup>3</sup>

### Characteristics / Applications:

Tubular installations, electrical industry, thin sheet metal packages and tinning work. Soft solder with long melting interval and good gap-bridging properties. Good wetting properties on copper and copper alloys.

### Heat sources:

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

### Availability:

Bare rods	Coated rods	Wire	Foil	Preforms	Powder	Paste
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