

ALPHA[®] Sn63Pb37 PLUS

Solder Alloy for Miscellaneous Applications

DESCRIPTION

ALPHA Sn63Pb37 Plus is a leaded alloy suitable for use in wave solder, selective soldering, lead tinning and PV Ribbon tinning applications. **ALPHA Sn63Pb37 Plus** has been engineered to minimize copper dissolution as compared to the generic ALPHA Sn63Pb37 alloy and to improve total cost of ownership. As with all Alpha bar solder, Alpha's proprietary Vaculoy manufacturing process is used to remove certain impurities, particularly oxides. The product is further enhanced with the addition of other elements designed to further reduce alloy drossing.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES AND BENEFITS

Features:

- Copper Erosion – Low Cu erosion rates compared to conventional alloys.
- Dross Generation – Lowest in class due to the Vaculoy process in conjunction with the addition of a dross reducing agent.
- Solder Fillet Surface – Smooth and bright.

Benefits:

- Lowers Total Cost of Ownership due to high yields and low dross generation.
- Provides good solderability due to good wettability.
- Reduces erosion of copper plating which improving assembly reliability.
- Delivers good performance across different soldering processes.

The proprietary Vaculoy process is a highly effective method for removing included oxides from solder. This is extremely important because included oxides generate excessive drossing and increase the viscosity of the solder. Solder with higher viscosity can result in increased soldering defects (i.e., solder bridging).

APPLICATION GUIDELINES

ALPHA Sn63Pb37 Plus is suitable for wave soldering, selective soldering, lead tinning and PV Ribbon tinning applications. A solder pot temperature of >240 °C (>464 °F) is recommended, depending on the soldering applications. Appropriate liquid Alpha fluxes should be selected based on the application.

TECHNICAL DATA

Material Property	Units	Sn63Pb37Plus
Solidus	Celsius	183
Liquidus	Celsius	183
Density	g/cc	8.53
Electrical Resistivity	$\mu\Omega\cdot m$	0.145
Thermal Conductivity	W/m.K	50

Alloy Composition Specification

ALPHA Sn63Pb37 Plus (% by weight)			
Sn	63.0 +/- 0.5	As	0.020 max
Pb	Balance	Ni	0.050 max
Ag	0.100 max	Bi	0.100 max
Cu	0.050 max	Cd	0.001 max
Sb	0.200 max	Al	0.001 max
Zn	0.001 max	In	0.050 max
Fe	0.010 max	Au	0.050 max

AVAILABILITY

ALPHA Sn63Pb37 Plus is available in 1kg (2.2lb) Bar, chunks, Feeder Ingots and Autofeed Wire.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams. Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at MacdermidAlpha.com/assembly-solutions/knowledge-base.**

STORAGE

Store the solder bar in a cool, dry and non-corrosive environment. Wrap up the solder bar when not in use to reduce exposure to environment.

CONTACT INFORMATION

**To confirm this document is the most recent version, please contact
 Assembly@MacDermidAlpha.com
www.macdermidalpha.com**

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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