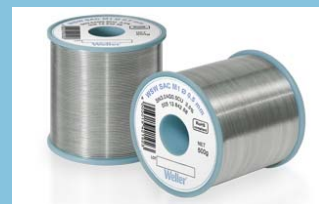


Weller®

WSW SAC M1 Lead free solder wire



Product Specification

1. **Product-Name:** WSW SAC M1

2. **Validity:** This specification is specified for:
Weller-Solder Wire WSW SAC M1

3. **Diameter and Allowance:**

Diameter	Order No.	Weight	Tolerance
ø 0,3 mm	T005 13 881 99	100 g	+ 0,05
ø 0,3 mm	T005 13 865 99	500 g	+ 0,05
ø 0,5 mm	T005 13 882 99	100 g	+ 0,05
ø 0,5 mm	T005 13 864 99	500 g	+ 0,05
ø 0,8 mm	T005 13 885 99	250 g	+ 0,05
ø 0,8 mm	T005 13 863 99	500 g	+ 0,05
ø 1,0 mm	T005 13 886 99	250 g	+ 0,05
ø 1,0 mm	T005 13 862 99	500 g	+ 0,05
ø 1,2 mm	T005 13 861 99	500 g	+ 0,05
ø 1,6 mm	T005 13 860 99	500 g	+ 0,05

4. **Deliverable Reel Size:**

Net Weight per Reel (kg)						
ø	0,3	0,5	0,8	1,0	1,2	1,6
kg	0,1; 0,5	0,1; 0,5	0,25; 0,5	0,25; 0,5	0,5	0,5
± 0,01						

5. **Physical Properties:**

Solidus °C	Liquidus °C	Specific Weight
217	221	7.4

6. **Chemical Composition: (%)**

Composition	Main components		
	Sn	Ag	Cu
Standard	Rest	3.0	0.5

7. Characteristics:

Test	Characteritics	Test Methods
Flux content (%)	3.5% 3.0 ~ 4.0 (%)	IPC-TM-650:2.3.34
Copper Mirror Test	pass	IPC-TM-650:2.3.32
Silver Chromate	n.a	IPC-TM-650:2.3.33
Flux materials composition	RO	J-Std-004:1.2
Quantitative Halide	M1 < 0.5 %	IPC-TM-650:2.3.35
Solder spreading	n.a.	IPC-TM-650;2.4.46
SIR (85°C, 85%, 168 h) (Ω)	≥ 1 x 10 ⁸	IPC-TM-650:2.6.3.3
Corrosion Test	pass	IPC-TM-650:2.6.15

8. Identification:

Spule		Karton	
Name	WSW SAC M1	Name	WSW SAC M1
Flux Content	3.5%	Flux Content	3.5%
Diameter (mm)	0.3 / 0.5 / 0.8 / 1.0 / 1.2 / 1.6	Diameter (mm)	0.3 / 0.5 / 0.8 / 1.0 / 1.2 / 1.6
Weight	100 g 250 g 500 g	Weight	1.070 g 2.570 g 5.000 g
Supplier	Weller Tools GmbH	Supplier	Weller Tools GmbH

9. Packing:

Individual Package		Outer Package
Weight (kg)	Packing	Cardboard
0.1, 0.25, 0.5	Plastic Sheet	

10. Supplier Address

**Weller Tools GmbH
Carl-Benz-Str. 2
74354 Besigheim, Germany**

11. In case of changing this specification it should be accepted by:

Weller Tools GmbH, Besigheim

Engineering department

12. This product is manufactured, using all guaranteed materials according to the legal law regulations.

13. Shelf life:

Up to two (2) years from the manufactured date (lot number).