

Flux cored solder wire with powerful wetting

72M series

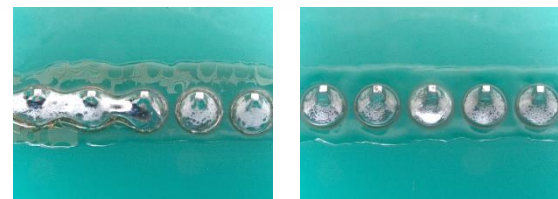
High wettability targets speed without compromise

Powerful wetting prevents bridging in slide soldering

-72M series contain new and more active activator for improved wettability and new resin composition for better flux coverage. They can prevent bridging even at bridging prone conditions such as low iron tip temperature for or fast sliding speed.

Slide soldering comparison

Slide Speed: 13mm/s, Iron Tip Temp.: 350 °C



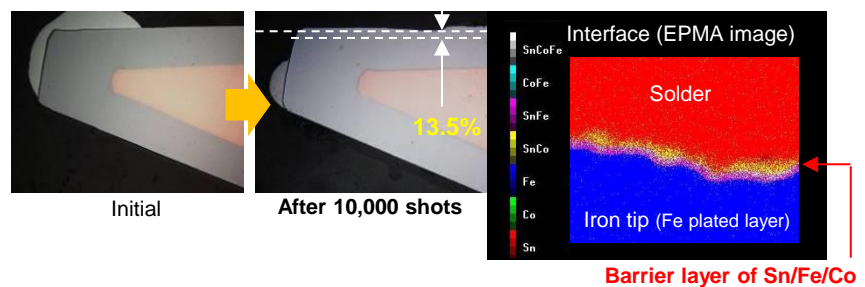
Conventional

S3X-72M

AEF Inhibits iron tip erosion

S01X7Ca-72M (0.1Ag) and **S03X7Ca-72M (0.3Ag)**, adopting Anti Erosion (AE) solder composition, form an IMC layer of Sn/Fe/Co between the solder and the iron tip. This IMC layer inhibits the erosion of Sn from the solder, and drastically extends the iron tip life.

Condition of iron tips after 100,00 shots (S01X7Ca)



Wide variety of solder alloys to choose from

Containing 6% Indium, **SB6NX-72M** shows improved strength and forms high reliability joints, even under extreme use environments such as automotive electronics, aviation and industrial equipment.

Together with standard lead-free alloy of **S3X** (SAC305) and AE (anti-erosion) alloys **S01X7Ca** / **S03X7Ca**, we offer 72M series in various alloy types for your needs to choose from.

Solder alloy lineup

Alloy	Features
S3X	Standard lead free solder alloy, SAC305
S01X7Ca	Ag 0.1%, anti-iron tip erosion
S03X7Ca	Ag 0.3%, anti-iron tip erosion
SB6NX	In-containing high durability solder alloy

Product specifications

Product name	S3X-72M	S01X7Ca-72M	S03X7Ca-72M	SB6NX-72M
Alloy composition (%)	Sn 3.0Ag 0.5Cu	Sn 0.1Ag 0.7Cu + Co	Sn 0.3Ag 0.7Cu + Co	Sn 3.5Ag 0.5Bi 6.0In 0.8Cu
Melting point (°C)	217-219	217-227	217-227	202-210
Flux content (%)	3.2			
Halide content (%)	< 0.01			
Flux type	ROLO			
Diameter (mm dia.)	0.3, 0.5, 0.6, 0.8, 1.0, 1.2			

