



QUALITEK[®]

Cored Solder Wire RA, RMA, SRA, WS

RMA 200 (Rosin Mildly Activated)

RMA 200 has been formulated for use in high reliability electronic assembly where pure rosin core does not provide fast spreading and wetting actions and activated rosin residues may be electrically less reliable. Meets J-STD-004 / J-STD-006.

RMA 258 (Rosin Mildly Activated)

RMA 258 has been formulated to meet the requirements of QQS-571e for type RMA. This core flux is composed of ww gum rosin and mildly activated organic compound. It also provides fast spreading and wetting action. Meets J-STD-004 / J-STD-006.

RA 300 (Rosin Activated)

Rapid wetting action and fast flowing properties of RA 300 are the main characteristics of this flux-core formulation. Other important features include the non-corrosive and electrically non-conductive properties. RA 300 meets J-STD-004 / J-STD-006.

SRA 500 (Super Rosin Activated)

Qualitek SRA 500 is the supreme activated rosin flux-core wire. It is recommended for highly oxidized metals and difficult-to-solder metals. Meets J-STD-004 / J-STD-006.

WS 700 (Water-Soluble)

WS 700 core is formulated for electronic applications where rapid wetting action and ease of cleaning flux residue with water rinse or in-line cleaning is required. It is very compatible with all liquid water-soluble organic flux. It will not decompose and carbonize under prolonged heat. Meets J-STD-004 / J-STD-006.

Solid Wire (No Core)

Qualitek solid solder wire is available in many alloys, wire diameters and spool sizes. Meets J-STD-006.

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PHYSICAL & CHEMICAL CHARACTERISTICS (FLUX EXTRACT)

	RA	RMA	SRA	WATER-SOLUBLE
Color & Appearance	Amber Solid	Amber Solid	Amber Solid	Lt. Opaque Solid
Softening Point, °C (Flux Extract)	80°	92°	92°	60°
Acid Number (mgKOH/g sample)	145-160	190-220	130-150	180-200
Silver Chromate (Qualitative Halides)	Detection	No Detection	Detection	Detection
Classification per J-STD-004	ROM1	ROLO	ROH1	ORH1
Surface Insulation Resistance	>1.0 x 10 ⁹	>1.0 x 10 ⁹	>1.0 x 10 ⁹	>1.0 x 10 ⁹ (cleaned)
Shelf Life	Indefinite	Indefinite	Indefinite	Indefinite
Residue Removal	Not Required. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Not Required. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Recommended. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Required. Use soft or DI water at 130° – 150°F

STANDARD PACKAGING

Qualitek flux-core wire and solid wire are packed in ½ pound, 1 pound, 1 kilogram, and 5 pound spools. We also offer 50 pound to 250 pound Quali-packs in rugged fiber containers.

STANDARD WIRE DIAMETERS

DIAMETER/INCH	0.125	0.092	0.062	0.050	0.040	0.032	0.025	0.020	0.015	0.010
DIAMETER/MM	3.17	2.36	1.57	1.27	1.01	0.81	0.63	0.50	0.38	0.25
STD. WIRE GAUGE	11	13	16	18	19	21	23	25	28	31

STANDARD FLUX CORE PERCENTAGE



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Consult MSDS for health and safety information