

Selective Soldering Solid Core & Flux

Since there has been a rapid increase in the use of selective soldering equipment for PCB assembly, Qualitek offers several alloys and diameters of Delta® Selective Solder Solid Wire that are compatible with ERSA® VERSAFLOW®, Pillarhouse® JADE®, Ace® KISS® and Nordson® SELECT® selective soldering equipment. We have also developed our No Clean fluxes for optimal performance.

Selective soldering can solder through-hole components on both sides of a two-sided printed circuit board assembly, which is the advantage over traditional wave soldering.

Delta® Selective Solder Solid Wire is available on 8 lb. green spools for lead-free alloys and 8 lb. white spools for leaded alloys. If your selective soldering equipment has a vision recognition option, it will differentiate leaded and lead-free wire based on spool color.

Solid Core Alloys:

Lead Free

SAC 305 (Sn96.5/Ag3.5/Cu0.5) Common Ag Alloy
Delta 99C® (Sn99.3/Cu0.7/Ni<0.1/Ge<0.01) Drop In Alloy
Sn100e® (Sn99.5/Cu0.5/Co trace alloy) LF Ag, Bi Free Alloy

Leaded

Sn63/Pb37 Common Leaded Alloy
Sn60/Pb40 Common Leaded Alloy



Diameters Available

Diameter (inch)	0.079	0.092	0.125
Diameter (mm)	2.01	2.33	3.18

Flux Selection Guide

No-Clean Solder Flux	Features	S.G.@25°C	% Solids	Acid No.	J-STD-004B	Thinner
302	Halogen-Free flux with very low solids, may be used for LEADED & LEAD-FREE applications for a broader process window.	0.800	2.3	20.0	ORL0	300A
393	Halogen-Free, low solids flux, may be used for LEADED & LEAD-FREE alloys. Good Solderability, non-tacky low residues for improved cosmetics.	0.811	2.9	23.5	ORL0	300A
380	Rosin-based flux leads to higher activity. Recommended for LEADED wave applications.	0.793	3.3	18.2	ROL0	300A
381F	Low solids flux compatible with both LEADED & LEAD-FREE systems that eliminates skips and shorts often experienced with wave assembly.	0.800	3.7	20.5	ROL0	300A
399-42	Halogen-Free, low solids flux, compatible with both LEADED & LEAD-FREE systems. Excellent wettability, non-conductive and tack-free residues.	0.832	4.5	36.0	ORL0	300A
305	Rosin-based, Halogen-Free flux designed for single and double sided plated through hole boards. Recommended for LEADED solder systems.	0.795	5.0	25.0	ROL0	300A
386	Rosin-containing flux provides excellent solderability for both general and high density boards. Use for LEADED & LEAD-FREE applications.	0.810	5.5	27.0	ROL0	300A



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