

TECHNICAL SPECIFICATION

GROSVENOR PURE ALLOY

RAW MATERIALS

Grosvenor Pure Alloy Bar Solder is manufactured exclusively from high grade materials. We are aware that re-cycled material can be used, but in our opinion reclaimed scrap metal leaves too many impurities to satisfy the quality demands of Today's Electronics Industry.

SPECIFICATIONS.

The most common purchasing specification used in the UK is BS 219 (1977/1984). We illustrate below a typical independent analysis of Grosvenor Solder when compared with BS 219.

The comparison clearly shows that Grosvenor Solder contains a far lower level of impurities than allowed in the British or other National Standards. (We believe most National standards have to give excessively high impurity levels to allow for the re-cycling of scrap metal.

Typical Batch Analysis: High Purity Virgin Tin

Sn	Sb	Pb	Cu	Zn	Fe	As	Ag	Bi	In
99.95	0.009	0.002	0.0002	0.0001	0.002	0.002	0.0001	0.0001	0.0003

Typical Batch Analysis: High Purity Virgin Lead.

Sn	Sb	Pb	Cu	Zn	Fe	As	Ag	Bi	In
0.001	0.002	99.99	0.003	0.0001	0.002	0.0005	0.002	0.005	0.0003

Typical Batch Analysis: Grosvenor Pure Alloy 63/37 (BS 219)

Sn	Sb	Pb	Cu	Zn	Fe	As	Ag	Bi	In
63.5	0.0095	REM	0.0007	0.0002	0.002	0.001	0.0005	0.0003	0.0003

BS 219. 63/37 AP

Sn %	Sb %	Pb %	Cu %	Zn %	Fe %	As %	Ag %	Bi %	In %
63 - 64.	0.2	REM	0.08	0.003	0.02	0.03	-	0.1	0.0005

ANALYTICAL SERVICE.

A regular check on bath composition and impurity levels is advisable. A full analytical report enables problems to be solved quickly which means a more constant through-put of flow solder production. A 3 monthly check is normally found sufficient, but this depends on workload.

DROSS SERVICE.

Agitation of solder by wave soldering or dipping will cause oxidisation (known as dross). Dross must be regularly removed and placed carefully into the free of charge containers supplied on request, for return to Grosvenor.

SPECIFICATION

BS 219	TIN	LEAD	MELTING RANGE
	AP 63-64%	REM	183-185°C
	KP 59-60%	REM	183-188°C

QQ-S-571E

SN63 62.5-63.5%

REM

183°C

SPECIFICATIONS

**IMPURITY LEVELS. (MAX)
AS SPECIFIED.**

KP & AP (MAX) TYPICAL

BS219		QQ-S-571E	BS219		QQ-S-571E
AP		Sn63	AP/KP		Sn63
Sb	0.2%	0.2%-0.5%	Sb	<0.02%	<0.2-0.5%
Cd	0.005%	0.001%	Cd	<0.001%	<0.001%
Bi	0.1%	0.25%	Bi	<0.005%	<0.005%
As	0.03%	0.03%	As	<0.001%	<0.001%
Fe	0.02%	0.02%	Fe	<0.001%	<0.001%
Cu	0.08%	0.08%	Cu	<0.001%	<0.001%
Zn	0.003%	0.005%	Zn	<0.001%	<0.001%
Al	0.001%	0.005%	Al	<0.0001%	<0.0001%
Others	0.08%	0.08%	Ag	<0.0005%	<0.0005%

Please refer to Quality Information for a typical Analysis of our AP Bar Solder.

TECHNICAL INFORMATION

All soldering operations will introduce contaminates to the solder bath. Unfortunately different materials and operations will introduce differing levels of contaminants. Listed are typical contaminants found.

Aluminium *: As little as 0.005% may increase dross rate without affecting joint formation. 0.001% may result in a sluggish or gritty solder.

Antimony: Certain of the specification require the intentional addition of antimony. Ostensibly this is to retard the transformation of tin into its grey state, sometimes known as ‘tin pest’, however this argument no longer appears to have validity in a eutectic or near eutectic alloy.

Arsenic: 0.03% can cause dewetting but arsenic is not usually a contaminant in electronic applications

Bismuth: 0.5% has been observed to cause discoloration and oxidation of solder, but appreciable amounts of Bismuth would not normally be present in high quality electronic grade alloys or finishes.

*Cadmium**: At levels of 0.002% joint formulation will be noticeably affected. At 0.005% there will be a high incidence of bridging and icicling, together with a deterioration in joint strength.

*Copper****: Generally, at levels of 0.25% copper or even less, joint formulation will deteriorate.

*Gold****: At levels of 0.1% and quite often even less, the solder becomes sluggish and dull joints are formed.

Iron: 0.02% of iron can make joint formulation gritty.

Sulpher: As little as 0.001% may inhibit wetting and may produce grittiness.

Zinc: The presence of Zinc can cause dulling and increase bridging and icicling. 0.005% can cause lack of adhesion and grittiness.

- NOTES: **When Copper and Gold in combination add to 0.25% joint formulation will usually have deteriorated.
- * The effects of Aluminium, Cadmium and Zinc are cumulative. If more than one element is present the following lower maxima are suggested 0.0005%, 0.002% and 0.001%.

SOLDER ALLOYS

Solder used in Electronic process contains principally tin and lead. Special solders may contain silver, antimony or copper. A potential health risk from solder is associated with its lead content, the other components are not usually regarded as hazardous in this context.

The metal can give rise to lead fumes at temperatures above 500°C, but this level is rarely met with in electronic soldering.

Oxide can be transferred to the hands while using these products and we recommend that eating, drinking and smoking should not be permitted at work stations. Hands should be washed with soap and warm water before eating.

Oxide evolved as dross on a wave soldering machine should be handled with care to avoid raising dust. Dross should be stored in a metal container with a sealed lid and returned to Grosvenor for disposal. Bar solder should be kept dry to avoid the risk of violent splashing that can occur if wet solder is added to a hot molten solder bath.

Grosvenor recommend that gloves should be used for handling wire and bar and suitable eye protection should be worn when adding solder to the machine, bath and when hand soldering.

HEALTH AND SAFETY AT WORK ACT 1974.

PRODUCT:	Bar Solder, Ingot, Solid Wire, Tinmans, Blowpipe and pellets.
NATURE OF HAZARDS:	Contains Lead - Absorption can arise from the oxide which forms on the surface of molten alloys.
PHYSICAL DATA:	Lustrous metal.
FIRE AND EXPLOSION DATA:	Flash Point - None. Non - Flammable. Store in a Dry Place.
HEALTH HAZARD:	Molten metals can cause burns.
EMERGENCY FIRST AID:	Treat all burns. Get medical help.
SPILLAGE:	Allow to cool, collect and return to supplier.
REACTIVITY:	Do not place wet or damp metal into a molten bath - could cause explosion.
SPECIAL PROTECTION INFO:	Personal hygiene is important, wash hands after contact and before meals.
SPECIAL INFORMATION:	Further details are given in the Lead Code of Practice for Health Precautions, issued by the Department of Employment.
C.O.S.H.H. LIMITS:	LEAD: - A cumulative poison, moderate to high toxicity. Possible systemic and long term effects. Maximum exposure limit: 0.15mg per cubic metre (T.W.A.8 hrs) ANTIMONY: - Moderate toxicity, a severe irritant. Possible systemic and long term effects. Maximum exposure limit: 0.5mg per cubic metre (T.W.A. 8hrs) CADMIUM: - High toxicity, irritant to nasal passages, carcinogenic and possible systemic effects. Maximum exposure limit: 0.05mg per cubic metre (T.W.A. 8hrs) COPPER: - High toxicity, possible systemic and long term effects Maximum exposure limit: 1.0mg per cubic metre (T.W.A. 8hrs)

ADDITIONAL INFORMATION: If you require any further information on the above data or fume extraction, please do not hesitate to contact our Sales office.

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