

Trade Name: HR19 M P2

1. **Company Address:** Almit GmbH Ph.: +49 6066 96884-0
 Dekan-Groh-Straße 4 Fax: +49 6066 96884-18
 (D) 64720 Michelstadt - near Frankfurt

2. **Validity:** This specification is specified for:
 Almit-Solder-Wire HR19 M P2
 Delivered by Almit GmbH to: _____

3. Diameter & Allowance:

Diameter (mm)										
		0.3	0.38	0.5	0.65	0.8	1.0	1.2	1.6	2.0
± 0.05										

3.1. Deliverable Reel Size:

Net Weight per Reel (kg)				
	0.1	0.5	0.8	1.0
+ 0.01 -0.00				

4. Physical Properties:

Solidus °C	Liquidus °C	Specific Gravity
183	190	8.5

5. Characterisitcs:

Test	Characteristics	Test Methods
Flux Content	2,2% (P2) 2.0 ~ 2.5 (%)	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
Dryness	pass	JIS-Z-3197:1999
Flux materials composition	RE	J-Std-004:1.2
Quantitative Halide	M1	IPC-TM-650:2.3.35
Solder spreading	>70 (%)	IPC-TM-650:2.4.46
SIR (85°C, 85%, 168hr) (Ω)	≥ 1 x 10 ⁸	IPC-TM-650:2.6.3.3
Corrosion Test	pass	IPC-TM-650:2.6.15

6. Chemical Composition: (%)

Composition	Components						
	Sn	Pb	Cu	Ag	Sb	Bi	
Standard	60.5±1.0	Rest	≤0.08		≤0.5	≤0.1	
Composition	Components						
	Al	As	Cd	Fe		Zn	
Standard	≤0.005	≤0.03	≤0.005	≤0.02		≤0.005	

7. **Lot Size:** A single lot contains 500kg which is the amount of one melting.

8. **Identification:**

Reel		Cardboard	
Name	HR19 M P2	Name	HR19 M P2
Flux Content	2,2% (P2)	Flux Content	2,2% (P2)
Diameter	mm	Diameter	mm
Net-Weight	e.g. 500g	Net-Weight	e.g. 5kg
Lot Nr.	e.g. 11.11.25	Lot Nr.	e.g. 11.11.25
Maker	Nihon Almit Co. Ltd.	Maker	Nihon Almit Co. Ltd.

9. **Packing:**

Individual Package		Outer Package
Weight (kg)	Packing	Cardboard
0.05 ; 0.1 ; 1.0	Plastic Bag	
0.5 ; 0.8	Plastic Sheet	

10. **Maker Address:** Nihon Almit Co. Ltd. - Productive Engineering Center
8154-227, Uenohara, Kitatsuru-gun, Yamanashi, 409-0112 Japan

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

Signature_____ Date_____

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).