

Technical Data Sheet



WAVE FLUX

Product Name: Surf 130

Product Type: VOC-free, water based, no-clean Flux

Description

Surf 130 is a water-based, halide-free and low-solid flux, developed for the use in industrial electronics manufacturing. It helps to reduce emissions of volatile organic compounds (VOC) by replacing IPA with water as solvent.

Typical Properties

Chemistry :

Colour:	clear, colourless liquid
Solid content:	3,0%
Halide content:	Zero
Acid value (on liquid):	26 mg KOH g ⁻¹
Specific density at 25°C (77°F)	1.007 g/cm ³
Recommended thinner:	no thinner required
J-STD-004 classification:	OR L0
SIR-Test:	10 ¹⁰ Ohm
Copper mirror:	Pass L0
Copper corrosion:	Pass L0
DIN EN 29454-1 classification:	2.1.3.A

Recommended Processing Guidelines

Spray Application:

The use of thinners will not be required. The flux is used as supplied and the fresh flux is spray applied to the board for only Spray system.

Preferred Upper Limit of Flux Coverage:

To ensure that the soldered boards pass the cleanliness test, the upper limit for flux coverage is 15-20ml/m² circuit.

Key Benefits

- No-Clean formulation
- Leaves electrical safe residues - no removal of residues required
- For all available lead-free alloys / solders
- Application with spray fluxer
- Non-flammable formulation - <1% VOC - meets US air quality legislation
- Ensures a good wetting on surfaces and in through holes

Appearance after soldering

- No readily observable residues
- Most of the used solder resist are shiny and not tacky
- Shiny solder joints

Topside Preheat

The special mixing of alcohol used into the formulation of Surf 130 allows to get a fast evaporation of the solvents. The acids are already activated at room temperature and any special thermal profile is required. In most of the case at 100-130 °C at the exit of the preheat zone is enough to get a good wetting and quality solder joints.

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Soldering Atmosphere

Air or Nitrogen

Cleaning

Although designed as a no clean product, if residues need to be removed they can readily be removed using standard cleaning systems and solvents.

General Notes

The recommended leading to a contact time with the molten solder of 3-6 seconds. The solder temperature can be between 265-280 °C

Storage Conditions

The flux must be stored at room temperature. The shelf life in this condition is maximum 24 months. Ensure that the flux has reached room temperature before use.

The Surf 130 is manufactured by Stannol
Oskarstraße 3-7 • 42283 Wuppertal

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