



Leaded Solder wire

IF R88

INTERFLUX®
ELECTRONICS N.V.



Technical data IF R88

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RMA based, No-clean solder wire

Description:

Interflux® **IF R88** No-clean solder wire is a mildly activated rosin based wire recommended when soldering in **classes I, II** (IPC-A-610).

It is especially well suited for surfaces with poor wettability and those applications where good solderability, fast wetting and excellent solder spreading are needed.

IF R88 has increased activity and shows very good through hole wetting and soldering speed.

IF **R88** shows excellent results in automated and robotic soldering.



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Key advantages:

- Classification to IPC and EN: **ROL1**
- Mildly activated
- For automated soldering
- Excellent wetting on surfaces with poor wettability
- Low flux spattering

Availability

Flux type: **R88**
Flux content: 1,0%w/w

diameters

alloy	melting point	0,20	0,35	0,50	0,70	1,00	1,50	2,00
Sn63 Pb 37	183°C	●	●	●	●	●	●	●
Sn99,3Cu0,7	227°C	●	●	●	●	●	●	●

● = available

● = upon request



Work instructions

Manual soldering

The working temperature is between 360°C and 390°C. For more dense metals like Nickel, the temperature may be elevated to 420°C.

Choose the correct soldering tip: to reduce the thermal resistance, it is important to create a large contact surface with the component and

solder pad.

The use of a good soldering station is important in order to always have the correct temperature on the soldering joint. Use a soldering station with a response time as short as possible.

Heat up the surfaces of both component and island simultaneously. Slightly touch with the solder wire,

the point where component lead, soldering island and soldering tip meet (the small quantity of solder ensures a drastic lowering of the thermal resistance). Add subsequently without interruption, the correct amount of solder close to the soldering tip without touching the tip. It is important that no solder wire is making contact with

the soldering tip during soldering to avoid flux spitting and premature flux consumption!

Handling

Storage

Store the solder wire in a clean environment between 0°C and 40°C

Handling

To avoid spool and wire damage, handle package with care



Test results

Conform EN 61190-1-3(2007), IPC J-STD-004 and Bellcore

Property	Result	Method
Chemical		
flux designator	ROL1	J-STD-004
	F-SW 26	DIN 8511
	1.1.2	ISO 9454
qualitative copper mirror	pass	J-STD-004 IPC-TM-650 2.3.32
	pass	GR-78-CORE Rev. 9/97 13.1.6
qualitative halide silver chromate (Cl, Br)	pass	J-STD-004 IPC-TM-650 2.3.33
	pass	GR-78-CORE Rev. 9/97 13.1.4
	pass	J-STD-004 IPC-TM-650 2.3.35.1
Environmental		
SIR test	pass	J-STD-004 IPC-TM-650 2.6.3.3
	pass	GR-78-CORE Rev. 9/97 13.1.4
qualitative corrosion, flux electro chemical migration	pass	J-STD-004 IPC-TM-650 2.6.15
	pass	GR-78-CORE Rev. 9/97 13.1.5



Packaging

Spools of 500g



Trade name: IF R88 Leaded, No-Clean Solder Wire

D i s c l a i m e r

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