

QUALITEK®

Cored Solder Wire RA, RMA, SRA, WS

RMA 200 (Rosin Mildly Activated)

RMA 200 has been formulated for use in high reliability electronic assembly where pure rosin core does not provide fast spreading and wetting actions and activated rosin residues may be electrically less reliable. Meets J-STD-004 / J-STD-006.

RA 300 (Rosin Activated)

Rapid wetting action and fast flowing properties of RA 300 are the main characteristics of this flux-core formulation. Other important features include the non-corrosive and electrically non-conductive properties. RA 300 meets J-STD-004 / J-STD-006.

Solid Wire (No Core)

Qualitek solder wire is available in many alloys, wire diameters and spool sizes. Meets J-STD-006.

SRA 500 (Super Activated Rosin)

Qualitek SRA 500 is the supreme activated rosin flux-core wire. It is recommended for highly oxidized metals and difficult-to-solder metals. Meets J-STD-004 / J-STD-006.

WS 700 (Water-Soluble)

WS 700 core is formulated for electronic applications where rapid wetting action and ease of cleaning flux residue with water rinse or in-line cleaning is required. It is very compatible with all liquid water-soluble organic flux. It will not decompose and carbonize under prolonged heat. Meets J-STD-004 / J-STD-006.

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PHYSICAL & CHEMICAL CHARACTERISTICS (FLUX EXTRACT)

	RA	RMA	SRA	WATER-SOLUBLE
Color & Appearance	Amber Solid	Amber Solid	Amber Solid	Lt. Opaque Solid
Softening Point, C°(Flux Extract)	80°	92°	92°	60°
Acid Number (mgKOH/g sample)	150-160	150-160	130-150	120-130
Silver Chromate(Qualitative Halides)	Detection	No Detection	Detection	Detection
Classification Per J-STD-004	ROM1	ROL0	ROH1	ORH1
Surface Insulation Resistance	>1.0 x 10 ⁹	>1.0 x 10 ⁹	>1.0 x 10 ⁹	>1.0 x 10 ⁹ (cleaned)
Shelf Life	Indefinite	Indefinite	Indefinite	Indefinite
Residue Removal	Not Required. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Not Required. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Recommended. May be removed with CFC replacement solvent or Qualitek 1005 Saponifier	Required. Use soft or DI water at 130° – 150°F

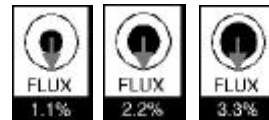
STANDARD PACKAGING

Qualitek flux-core wire and solid wire are packed in ½ pound, 1 pound, 1 kilogram, and 5 pound spools. We also offer 50 pound to 250 pound Quali-packs in rugged fiber containers.

STANDARD WIRE DIAMETERS

DIAMETER/INCH	0.125	0.092	0.062	0.050	0.040	0.032	0.025	0.020	0.015	0.010
DIAMETER/MM	3.17	2.36	1.57	1.27	1.01	0.81	0.63	0.50	0.38	0.25
STD.WIRE GAUGE	11	13	16	18	19	21	23	25	28	31

STANDARD FLUX CORE PERCENTAGE



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Consult MSDS for health and safety information