

Weller®

WSW SAC M1 Lead free solder wire



Product Specification

1. Product-Name: WSW SAC M1

2. Validity: This specification is specified for:
Weller-Solder Wire WSW SAC M1

3. Diameter and Allowance:

Diameter	Order No.	Tolerance
∅ 0.3 mm	T005 13 865 99	+ 0.05
∅ 0.5 mm	T005 13 864 99	+ 0.05
∅ 0.8 mm	T005 13 863 99	+ 0.05
∅ 1.0 mm	T005 13 862 99	+ 0.05
∅ 1.2 mm	T005 13 861 99	+ 0.05
∅ 1.6 mm	T005 13 860 99	+ 0.05

4. Deliverable Reel Size:

Net Weight per Reel (kg)
0.5
+ 0.01

5. Physical Properties:

Solidus °C	Liquidus °C	Specific Weight
217	221	7.4

6. Chemical Composition: (%)

Composition	Main components		
	Sn	Ag	Cu
Standard	Rest	3.0	0.5

7. Characteristics:

Test	Characteritics	Test Methods
Flux content (%)	3.5% 3.0 ~ 4.0 (%)	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
Flux materials composition	RO	J-Std-004:1.2
Quantitative Halide	M1 < 0.5 %	IPC-TM-650:2.3.35
Solder spreading	n.a.	IPC-TM-650;2.4.46
SIR (85°C, 85%, 168 h) (Ω)	$\geq 1 \times 10^8$	IPC-TM-650:2.6.3.3
Corrosion Test	pass	IPC-TM-650:2.6.15

8. Identification:

Spule		Karton	
Name	WSW SAC M1	Name	WSW SAC M1
Flux Content	3.5%	Flux Content	3.5%
Diameter (mm)	0.3 / 0.5 / 0.8 / 1.0 / 1.2 / 1.6	Diameter (mm)	0.3 / 0.5 / 0.8 / 1.0 / 1.2 / 1.6
Weight	500 g	Weight	5.0 kg
Supplier	Weller Tools GmbH	Supplier	Weller Tools GmbH

9. Packing:

Individual Package		Outer Package
Weight (kg)	Packing	Cardboard
0.5	Plastic Sheet	

10. Supplier Adress

**Weller Tools GmbH
Carl-Benz-Str. 2
74354 Besigheim, Germany**

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

Weller Tools GmbH, Besigheim

Engineering department

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).