

62/36/2

(2 Ag / 62 Sn / 36 Pb Silver-Tin-Lead Soft Solder)

NOMINAL COMPOSITION

Tin	61.5-62.5%	Antimony	0.5% Max	Arsenic	0.03% Max
Lead	Remainder	Cadmium	0.001% Max	Iron	0.02% Max
Copper	0.08% Max	Aluminum	0.005% Max	Zinc	0.005% Max
Silver	1.75-2.25% Max	Bismuth	0.25% Max		

PHYSICAL PROPERTIES

Color	White
Melting Point (Solidus)	354°F (179°C)
Flow Point (Liquidus)	372°F (189°C)
Specific Gravity	8.44
Density (Lbs/in ³)	0.305
Electrical Conductivity (%IACS)	N/A
Electrical Resistivity (Microhm-cm)	N/A

*IACS = International Annealed Copper Standard

SOLDERING CHARACTERISTICS

Silver-Tin-Lead solders are widely used when soldering silver-coated surfaces. The addition of silver to the Sn/Pb Eutectic reduces the erosion of the silver coating. The presence of silver also enhances mechanical properties including the joint strength due to the formation of the ductile Ag₃Sn intermetallic. This alloy has been used in joining of electronic components and general purpose applications for both manual and automatic soldering where fast flow and higher strengths are desired.

PROPERTIES OF SOLDER JOINTS

This alloy offers excellent corrosion resistance and is generally used where temperature requirements are critical. Joint clearances of 0.003 in to 0.005 in (0.076 - 0.127 mm) are optimum, but larger variations can still produce sound joints.

AVAILABLE FORMS

Wire, strip, engineered preforms, specialty preforms per customer specification, powder and paste.

SPECIFICATIONS

62/36/2 alloy conforms to the following specifications:

- American Society for Testing and Materials (ASTM) B32 Sn62

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 63-625.

SAFETY INFORMATION

The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information refer to the Material Safety Data Sheet for 62/36/2.

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