



Water Soluble Cored Wire Solder

Features:

- Improved Wetting Properties
- High Activity Level
- Reduces Oxidation of Solder Iron Tip
- Post-Process Residues Easily Cleaned
- Good Thermal Transfer

Description:

OAJ Cored Wire features a halide-activated system that has been neutralized with an amine. The aminehydrohalide provides a high activation level that produces excellent tarnish or oxide removal, and maximum capillary action, leading to faster wetting, and reducing the chances of thermal degradation of the board materials. OAJ flux residue is readily soluble in hot water. IPC flux classification for this material is ORH1.

Availability:

- OAJ is standard with a 2.0% flux core for tin-lead (3% flux core for lead-free) alloys.
- OAJ is available in Sn/Pb, Sn/Ag/Cu, SN100C[®] alloys.
- Standard spool sizes; ½ lb. for .010 and .015 diameters, 1 lb. for .020, .032, .040, .050, and .062 diameters.
- Packaging of ½ lb. and 1 lb. spools is standard in 12 lb. and 24 lb. cases.
- Other flux percentages, alloys, diameters and spool sizes may be available upon special request.

Application:

- Solder iron tip temperature should be between 350° - 400°C (650° - 750°F) for Sn60, Sn62 and Sn63 alloys, 370° - 425°C (700° - 800°F) for Sn/Ag and Sn/Ag/Cu alloys and 350° - 470°C (650° - 700°F) for Sn43/Pb43/Bi14.
- Hold the solder iron at a 45° to 60° angle to the work surface.
- The solder iron should contact both the component lead and PCB pad surface.
- Solder and flux should flow onto both the lead and pad or lead and barrel to promote optimum flux activity to the joint being worked.
- If additional flux is needed, the use of AIM's 716 flux is recommended. Operators should use an applicator capable of dispensing precise amounts of flux to eliminate over-saturation and excessive spread.

Cleaning:

Post-process residues should be removed within a three-hour period. This may be accomplished with normal tap water. Deionized water is recommended for the final rinse. A temperature of 38° - 60°C (100° - 140°F) is sufficient for removing residues. An in-line or other pressurized spray cleaning system is suggested, but is not required.

Handling and Storage:

- OAJ cored wire has an indefinite shelf life when proper storage conditions are observed.
- Store OAJ in a clean dry area away from moisture and sunlight.
- Do not freeze this product.

Safety:

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying MSDS for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

Manufacturing and Distribution Worldwide

USA +1-401-463-5605 · Canada +1-514-494-2000 · Europe +44-1737-222-258 · Mexico +52-656-630-0032 · Asia-Pacific +86-755-2993-6487
info@aimsolder.com · www.aimsolder.com
AIM IS ISO9001:2008 CERTIFIED

The information contained herein is based on data considered accurate and is offered at no charge. Product information is based upon the assumption of proper handling and operating conditions. All information pertaining to solder paste is produced with 45-micron powder. Liability is expressly disclaimed for any loss or injury arising out of the use of this information or the use of any materials designated. Please refer to <http://www.aimsolder.com/terms.cfm> to review AIM's terms and conditions.

08/09
Rev 2