

# WS101 Power Core Wire Solder

## INTRODUCTION

WS101 Power Core Wire Solder is a high activity water washable solder for repairing through-hole, mixed and surface mount assemblies. The flux core provides faster and better fluxing activity than RA flux cores. WS101 flux is formulated to provide high activity soldering, leaving an easily washable residue in plain water without the need for cleaning additives.

## ATTRIBUTES

- Excellent cosmetics
- Fast wetting
- Easy rinsing

## APPLICATION

POWER CORE WS101 is suitable for use in any commercial hand soldering application. POWER CORE WS101 is ideal for difficult to solder metals such as brass, nickel and severely oxidized copper.

Solder iron temperature: 370 – 425C (700 – 800F)  
Angle: hold the iron at 45 to 60 deg to the surface

The flux residues must be removed as they can affect reliability of the joint if left un-cleaned. Cleaning is accomplished in plain water but a final rinse in D.I. water is recommended to ensure removal of all undesirable residues.

## AVAILABILITY

WS101 Power Core Wire Solder is available in SN100C and SAC305 alloys and with diameters ranging from 0.015" to 0.620". The flux concentration varies from 1.5 to 3% by weight.

## TEST RESULTS

Properties	Values
Alloys	SN100C, SAC305
Flux Content	1.5 to 3% by wt
Spread Factor	Over 90
Copper mirror	High activity
Halide Content	1.6 – 1.9%
Silver chromate	Halides present
Fluoride test	None detected
Ion chromatography	Halides detected
Flux class (J-STD-004)	ORH1

## SAFETY AND HANDLING

Refer to the Material Safety Data Sheet for further information.

Store in a cool, dry place away from moisture and the elements.