



STANNOL®

Wenn's ums Löten geht  
When it's about soldering  
Quand il s'agit du soudage

## Technical Data Sheet

With the **ECOLOY® Series** for lead free soldering in electronics assembly and electrical engineering Stannol provides a product line, which meets all requirements of the EU directives ROHS and WEEE.

The following **lead-free** alloys are available from the **ECOLOY® series**:

Alloy	Composition*	Melting point °C
ECOLOY® TC	S-Sn99Cu1	227
ECOLOY® TC300	S-Sn97Cu3	227-310 (only solder bars)
ECOLOY® TS	S-Sn96Ag4	221
ECOLOY® TSC	S-Sn95Ag4Cu1*	217
ECOLOY® TSC305	S-Sn96Ag3Cu1	217-223
ECOLOY® TS300	S-Sn97Ag3	221-224
ECOLOY® TSC263**	Sn97.1Ag2.6Cu0.3	217-224
ECOLOY® TSC0307**	S-Sn98Cu1Ag	217-227

\* Complying with ISO 9453:2006 and/or internal specifications.

\*\* These alloys are subject to minimum order quantities!

## Products from the ECOLOY® Series

### Solder Bars and Ingots:

The alloys listed above are available in triangular bars, kilo bars and ingots with hanging hole.

### Flux Cored Solder Wires:

Solder wires are available with **ECOLOY®** lead-free alloys. Solid wires as well as flux cored solder wires are intensively tested in our laboratory and approved by our customers. Following types from the established STANNOL® solder wires are considered best for lead-free application:

Solder wire	IEC 61190-1-3 DIN EN 29454-1	Flux content	Number of cores
HS10	ROM1 / 1.1.2	2.5%	1
KS100	REL0 / 1.2.3	3.0%	1
KS115	REM1 / 1.2.2	3.0%	1
Kristall 400	REL0 / 1.2.3	2.2%	5
Kristall 511	REM1 / 1.2.2	2.7%	5

### Liquid Fluxes:

For wave soldering, the fluxes **EF270**, **EF330**, **EF350** and **WF300S** (VOC-free) have proven to be so-called "Drop-In"-products, which facilitate optimal soldering results before, during and after implementation of a **lead-free** process.

### Around soldering:

For your **lead-free** manufacturing process of course all other products like **preforms**, **anti-oxidant-pellets** and **solder tip tinner/cleaner** will be available in **lead-free** form.

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.