

Deoxidisation Tablets P 1

Description

The Alpha solders of the MP Series were developed specifically for soldering printed circuits in drag soldering systems and for dip tinning at higher temperatures.

After a certain time of use, the solder loses phosphorus, which is then replenished with the addition of *Alpha Deoxidisation Tablets P 1*.

Alloy

High phosphorus L-Sn60Pb

Melting range

183 °C - 190 °C

The phosphorus content of MP solders should be 10 - 40 ppm. This serves to reduce the surface tension, for a lower solder consumption, minimum drossing, and reduced stringing and bridging. On the surface of the melted solder, the phosphorus content promotes the formation of a colourless, passivating, and invisible film that protects the melt at temperatures of 250 °C - 300 °C from further oxidisation.

Safety

Alpha Deoxidisation Tablets P 1 may not be used directly as soft solder and may not come into contact with fluxes (toxic fumes).

Application

- The phosphorus content in flow and drag soldering systems is replenished with the addition of approx 5 - 7 *Alpha Deoxidisation Tablets P 1* per 10 kg of bath content.
- The phosphorus content in dip soldering systems (general tinning work) is replenished with the addition of 2 - 4 *Alpha Deoxidisation Tablets P 1* per kg of bath content.

The correct phosphorus content in the solder is verified with the so called tarnishing test.

Tarnishing test: The solder is heated to 350 °C, and the first oxide film is removed.

At the end of about one minute the solder may not exhibit any tarnishing.

Delivered form

Alpha Deoxidisation Tablets P 1 packaged in 250 g boxes. Size: 9 x 9 mm

We have provided this information to the best of our knowledge and according to the state of the art. However, this information does not provide any warranty for the accuracy of the data. We accept no responsibility for any damage caused by this information or the use of the product.



Cookson Electronics ASSEMBLY MATERIALS

alpha metals lötsysteme gmbh
Elisabeth-Selbert-Strasse 4
40764 Langenfeld (Germany)

tel +49-(0)-2173-8490-300
fax +49-(0)-2173-8490-310
central@cooksonelectronics.com
www.cooksonelectronics.com