

ALPHA® TELECORE® HF-850

Halogen-Free, Halide-Free, No-Clean Cored Solder Wire

DESCRIPTION

ALPHA Telecore HF-850 is the fastest wetting and lowest spattering, Halogen-free and Halide-free cored wire offering from Alpha. It performs admirably when benchmarked against Halogen and Halide containing competitive products available in the market and is a viable option to meet environmental requirements.

ALPHA Telecore HF-850's rapid wetting enables its use in drag soldering and minimizes cycle time in robotic and hand soldering applications. Its clear residue allows easy inspection of solder joints and the very low spatter rate ensures board cosmetics and user comfort are maintained. All this translates to a safe and environmentally compliant product that is operator friendly while maintaining high levels of productivity.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

| Features | Benefits |
|--------------------------------|--|
| Very fast wetting | Low cycle times for component touch-up and manual assembly |
| Very low flux spatter | Safe to use, Operator friendly, Less residues on boards |
| Good spread characteristics | Excellent first pass solder joints. JIS Spread ≥ 80%. |
| Very low levels of fumes | Cleaner working environment, Less extraction maintenance |
| Clear non-tacky residue | No-clean residues, Useful for all applications |
| Provides good joint appearance | Makes inspection easy |
| Halogen and Halide-free | Environmental compliance and high electrical reliability |

ALPHA Telecore HF-850 is suitable for use in any electronic or industrial no-clean soldering application that specifies compliance with the IPC J-STD-004 ROL0 standard. It is ideal for electronic assemblies used in Automotive, Consumer Electronics, Computer and Peripherals, Mobile Devices, and all types of Household Appliance applications.

PRODUCT INFORMATION

| Standard | Alloy Designation | Melting or Solidus / Liquidus Temp °C | Flux Amount |
|-------------|---|---------------------------------------|-------------------|
| | InnoLot Alloy** Sn90.85/Ag3.8/Cu0.7/Sb1.5/Ni0.15/Bi3.0 (High reliability & high operating temp) | 212 / 220 | 2.2% |
| J-STD-006C | SAC305 | 217 / 221 | 1.1%, 2.2% & 3.3% |
| Proprietary | SACX Plus 0807 | 217 / 228 | 2.2% & 3.3% |
| Proprietary | SACX Plus 0307 | 217 / 228 | 2.2% & 3.3% |
| Proprietary | SnCX Plus 07 | 227 / 229 | 2.2% & 3.3% |
| J-STD-006C | Sn99.3/Cu0.7 | 227 | 2.2% & 3.3% |
| J-STD-006C | Sn63/Pb37 | 183 | 1.1%, 2.2% & 3.3% |
| ISO 9453 | Sn99Cu1 | 227 / ~235 | 2.2% & 3.3% |
| J-STD-006C | Sn60/Pb40 | 183 / 190 | 1.1% & 2.2% |

* ALPHA Telecore HF-850 may also be available in other alloys and flux amounts on request.

** All electronic components used with InnoLot solder alloy must be lead-free to eliminate the formation of tin/lead/bismuth intermetallic which has a melting point under 100 °C.

Note: Flux content designated as P1 = 1.1%; P2 = 2.2%; P3 = 3.3%.

APPLICATION GUIDELINES

A solder joint is formed by heating the parts to be soldered to a temperature in excess of the melting point of the alloy to be used; in hand soldering this is how a soldering iron is used. By feeding the cored wire onto the parts, the flux is able to flow and remove oxidized metal, while the solder creates a thin inter-metallic bond which becomes the solder joint. ALPHA Telecore HF-850 is also ideal for robotic soldering applications.

Note the following tips:

- Use a soldering iron tip size and form to suit the operation: small tips for soldering large components may prevent the formation of a joint or slow the process down.

- Select a solder wire diameter to suit both the soldering iron tip and the parts/components to be soldered.
- Soldering iron systems should provide sufficient heat to satisfy the requirements of the points above.
- A typical solder tip temperature would be between 120 °C and 160 °C above the liquidus temperature of the alloy. The ideal temperature to use is dependent on how thermally demanding the assembly is.
- Cored solder wires can be provided in different grades of alloy so always ensures that you have selected the right grade for the application.
- Do not overheat as this causes an increase in the depth of the inter-metallic layer, which in turn weakens the joint.

If you choose to use a liquid rework flux, ALPHA NR205 No-Clean Low Residue Flux is recommended to maintain high electrical reliability and halogen-free residues. ALPHA NR205 is available in ALPHA Write Flux Pens for precision flux application.

HALOGEN STATUS

ALPHA TELECORE HF-850 is a Halogen-free product and passes the standards listed in the table below:

| Halogen Standards | | | |
|---|--|--------------------|--------|
| Standard | Requirement | Test Method | Status |
| IEC 612249-2-21 | Post Soldering Residues contain < 900 ppm each or total of < 1500 ppm Br or Cl from flame retardant source | TM EN 14582 | Pass |
| JEDEC <i>A Guideline for Defining "Low Halogen" Electronics</i> | Post soldering residues contain < 1000 ppm Br or Cl from flame retardant source | | Pass |

TECHNICAL DATA

| Physical Properties | Typical Values |
|------------------------|--|
| Rosin Softening Point: | 70 to 80 °C |
| Acid Value: | 180 to 200 mg KOH/g flux (IPC-TM-650 2.3.13) |
| Halide Content: | <500 ppm (IPC-TM-650 2.3.28.1) |
| Classification: | JIS - 1a3N Grade AA ROLO per IPC J-STD-004A/B |

| Chemical Reliability Test | Requirements | Results |
|---|-------------------------------|---------|
| Copper Mirror Test (JIS) | No complete removal of copper | PASS |
| Copper Mirror Test (IPC-TM-650 2.3.32) | No complete removal of copper | PASS |
| Copper Corrosion Test (JIS) | No evidence of corrosion | PASS |
| Copper Corrosion Test IPC-TM-650 2.6.15 | No evidence of corrosion | PASS |

| Electrical Reliability Test | Product Combination | Requirements | Results |
|---|--|-------------------------------------|---------|
| Automotive Damp-Heat Cyclic Test (IEC 60068-2-78) | Telecore HF-850 | $1.0 \times 10^8 \Omega$ minimum * | PASS |
| | Telecore HF-850 + CVP-390 Solder Paste | | PASS |
| JIS SIR Test (JIS-Z-3197) | Telecore HF-850 | $1.0 \times 10^{11} \Omega$ minimum | PASS |
| JIS WER Test (JIS Z 3283:2006) | Telecore HF-850 | WER Grade AA >1000 ohm-m | PASS |
| IPC SIR Testing (J-STD-004B) | Telecore HF-850 | $1.0 \times 10^8 \Omega$ minimum | PASS |
| | Telecore HF-850 + CVP-390 Solder Paste + EF-6100 Liquid Flux | | PASS |

| Electrical Reliability Test | Product Combination | Requirements | Results |
|-----------------------------------|--|--|---------|
| | Telecore HF-850 + CVP-390 Solder Paste + NR205 Liquid Flux | | PASS |
| IPC SIR Testing (J-STD-004A) | Telecore HF-850 | $1.0 \times 10^8 \Omega$ minimum | PASS |
| Bellcore SIR Test (GR-78-CORE) | Telecore HF-850 | $1.0 \times 10^{11} \Omega$ minimum | PASS |
| Bellcore EM Test (GR-78-CORE) | Telecore HF-850 | SIR(initial)/SIR (Final) < 10 | PASS |

* IEC 60068-2-78 does not specify a minimum resistance value. Alpha has adopted the stated value.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at MacDermidAlpha.com/assembly-solutions/knowledge-base.**

STORAGE

ALPHA Cored Solder Wires should be stored in dry conditions and within a temperature range of 0 to 40 °C. Alpha guarantees the product's shelf life for three years from the date of manufacture when stored in the recommended conditions.

CONTACT INFORMATION

**To confirm this document is the most recent version, please contact
Assembly@MacDermidAlpha.com**

www.macdermidalpha.com

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| <p>North America 109 Corporate Blvd. South Plainfield, NJ 07080, USA 1.800.367.5460</p> | <p>Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400</p> | <p>Asia 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p> |
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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