TECHNICAL DATA SHEET

CATEGORY: **WATER SOLUBLE CORED WIRE**

NAME: **OAJ CORED WIRE**

FEATURES

- IMPROVED WETTING PROPERTIES
- POST-PROCESS RESIDUES EASILY CLEANED
- REDUCES OXIDATION OF SOLDER IRON TIP
- HIGH ACTIVITY LEVEL
- 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.

HANDLING

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

APPLICATION

- Solder iron tip temperature should be between 650° and 750°F for Sn63, Sn62 and Sn60 alloys, 700° - 800°F for Sn/Ag and Sn/Ag/Cu alloys and 650° to 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 flux dispensing pens is recommended for dispensing precise amounts of flux, eliminating over-saturation.

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 100° - 150°F is sufficient for removing residues. An in-line or other pressurized spray cleaning system is suggested, but is not required.

PACKAGING

- OAJ core wire is standard with a 2% flux core. Other flux core %'s are available upon request.
- OAJ is available in Sn60, Sn62, Sn63, Sn96, CASTIN® and other custom alloys upon request. These solder alloys are manufactured to meet the IPC J-STD-006 standard.
- Standard spool sizes; ½ lb. for .010 and .015 diameters, 1 lb. for .020, .032, .040, .050, and .062 diameters. Other spool sizes and wire diameters are available upon special request.
- Packaging of ½ lb. and 1 lb. spools is standard in 12 lb. and 24 lb. cases.

SAFETY

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **M**aterial **S**afety **D**ata **S**heet for any specific emergency information.
- Do not dispose of any waste materials in non-approved containers.

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