

ALPHA[®] CLEANWAVE

Wave Solder Metal

DESCRIPTION

ALPHA CLEANWAVE is manufactured using high purity raw materials and is treated using proprietary dross reducing technology to give a solder alloy that has Low Dross Characteristics.

As a general purpose wave soldering product, it has very good wetting and soldering performance, meets international specifications J-STD-006C, ISO 9453, JIS Z3282, and includes proprietary dross reducing technology.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

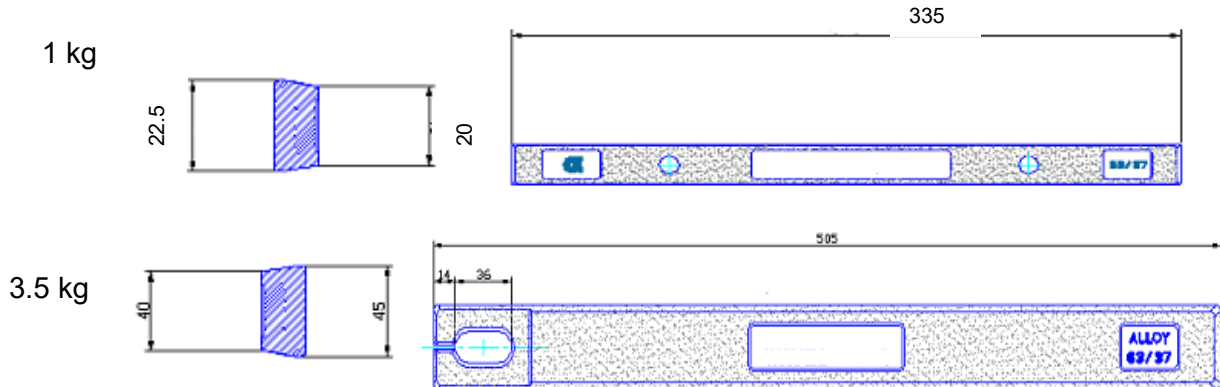
- **Low Dross Characteristics:** giving cost effective use of the solder alloy.
- **Low Dross Characteristics:** reducing the amount of dross in the wave pot leading to lower downturn and reducing the chance of oxide entrapped in joints.
- **Manufactured to Alpha's high standards:** giving a product that can be relied on to give good consistent soldering performance.

APPLICATION GUIDELINES

ALPHA CLEANWAVE can be used in all wave soldering systems and will give excellent soldering performance and good value per joint. A solder pot temperature of 240 to 250° C is recommended. For suitable wave solder fluxes, contact your local sales representative. Reclaim services including dedicated containers are also available. Please consult your local sales office.

DIMENSIONS OF BARS

All dimensions in mm.


TECHNICAL SPECIFICATIONS

The following indicates the alloy and impurity limits for ALPHA CLEANWAVE in relation to J-STD-006C, ISO9453, and JIS Z3282.

Element	Cleanwave	ISO9453 Sn63Pb37	J-STD-006C	JIS Z3282 H63A
Sn	62.5 to 63.5	62.5 to 63.5	62.5 to 63.5	62.5 to 63.5
Pb	Balance	Balance	Balance	Balance
Sb	0.20 max	0.20 max	0.20 max	0.20 max
Cu	0.05 max	0.08 max	0.08 max	0.08 max
Zn	0.001 max	0.001 max	0.003 max	0.001 max
Fe	0.01 max	0.02 max	0.02 max	0.02 max
As	0.02 max	0.03 max	0.03 max	0.03 max
Ni	0.01 max	0.01 max	0.01 max	0.01 max
Bi	0.10 max	0.10 max	0.10 max	0.10 max
Cd	0.001 max	0.002 max	0.002 max	0.002 max
Ag	0.10 max	0.10 max	0.10 max	0.10 max
Al	0.001 max	0.001 max	0.005 max	0.001 max
In	0.05 max	0.10 max	0.10 max	0.10 max

All figures are %

1. ISO 9453: 2006
Soft Soldering Alloys – chemical composition and form. ISO – International Standards Organization, a network of national standards institutes working in partnership.
2. J-STD-006C: July 2013
Requirements for Electronic Grade Solder alloys and non-fluxed solders. Joint Industry Standards between IPC and Electronic Industries Alliance (US Based). IPC formed in 1957 as an Institute of Printed Circuits, J-STD-006C supersedes J-STD-006B.
3. JIS Z 3282: 2006
Soft solders chemical composition and forms. JIS – Japanese Industrial Standards.

AVAILABILITY

ALPHA CLEANWAVE is available in 3.5 kg feeder bars, 1 kg bars, and solder chunks for first fill of solder baths.

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.**

CONTACT INFORMATION

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

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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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