88
Activated Rosin Cored Wire
For Lead-bearing and Lead-free alloys

Product Description

Kester 88 activated rosin flux for cored solder consists of high quality Grade WW rosin to which has been added an extremely effective activating agent. This rosin flux formulation is similar to the popular Kester 44 which has been the standard of the electronics industry for decades. The degree of activity has been increased, however, to be able to provide better fluxing action in those cases where Kester 44 flux will not wet metal surfaces which are excessively oxidized. Kester 88 flux core is classified as ROM1 per J-STD-004.

Kester 88 activated rosin flux is used for applications where organic flux residue is too corrosive and conductive and a more active flux than normal activated rosin flux is required. Kester 88 flux is recommended for difficult-to-solder metals such as nickel or for metals with excessive oxides.

Performance Characteristics:

- High activity RA formulation
- Solderability on nickel and other difficult-to-solder metallizations
- Compatible with leaded and lead-free alloys
- Classified as ROM1 per J-STD-004

RoHS Compliance

This product meets the requirements of the RoHS (Restriction of Hazardous Substances) Directive, 2002/95/EC Article 4 for the stated banned substances. (Applies only if this core flux is combined with a lead free alloy)

Reliability Properties

Copper Mirror Corrosion: Moderate
Tested to J-STD-004, IPC-TM-650, Method 2.3.32

Corrosion Test: Moderate
Tested to J-STD-004, IPC-TM-650, Method 2.6.15

Silver Chromate: Fail
Tested to J-STD-004, IPC-TM-650, Method 2.3.33

Chloride and Bromides: 0.88%
Tested to J-STD-004, IPC-TM-650, Method 2.3.35

Fluorides by Spot Test: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

Application Notes

Availability:

Kester 88 is available in a wide variety of alloys, wire diameters and flux percentages. For most applications, Sn63Pb37 or Sn96.5Ag3.0Cu0.5 is used. Consult the alloy temperature chart in Kester's product catalog for a comprehensive alloy list. The standard wire diameter for most applications is 1.00mm (0.031in). Wire diameters range from 0.25 - 6.00mm (0.010 to 0.250in). A "Standard Wire Diameters" chart is included in Kester's product catalog. The amount of flux in the wire dictates the ease of soldering for an application. For most applications, core 66 (3.3% flux by weight) is recommended. Other core sizes, 50 and 58, (1.1% and 2.2% respectively) are available. Kester 88 is packaged on spools of different sizes to accommodate a variety of applications.

Process Considerations:

Solder iron tip temperatures are most commonly between 315-371°C (600-700°F) for Sn63Pb37 and Sn62Pb36Ag02 alloys and 371-427°C (700-800°F) for lead-free alloys. Heat both the land area and component lead to be soldered with the iron prior to adding Kester 88 cored wire. Apply the solder wire to the land area or component lead. Do not apply the wire directly to the soldering iron tip. If needed, Kester 1544 Activated Rosin Flux may be used as a compatible liquid flux to aid in reworking soldered joints.

Cleaning:

Kester 88 flux residues are non-corrosive, non-conductive, and do not require removal in most applications.

Storage, Handling, and Shelf Life:

Storage must be in a dry, non-corrosive environment. The surface may lose its shine and appear a dull shade of grey. This is a surface phenomena and is not detrimental to product functionality. Flux cored solder wire has a limited shelf life determined by the alloy used in the wire. For alloys containing > 70% lead, the shelf life is two years from date of manufacture. Other alloys have a shelf life of three years from date of manufacture.

Health & Safety:

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

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Rev: 15Jun07