



HR95 Solder Bar

Physical Properties

Melting Temp (°F)	414
Melting Temp (°C)	212
Density (lbs/in ³)	0.32
Specific Gravity (g/m ³)	7.28
Electric Resistivity (10 ⁻⁹ ohm-m)	145
Wetting Time (sec)	0.9
Wetting Force (mN)	4.4
Hardness (HV10)	26
Tensile Strength (Mpa)	80
Tensile Elongation (%)	24
Spread Factor	70

Chemical Specifications

ELEMENT	JSTD-006C (%)
Tin	Balance
Silver	0.5 - 0.7
Cadmium	0.002
Lead	0.07
Aluminum	0.005
Copper	0.6 - 0.8
Arsenic	0.03
Iron	0.02
Zinc	0.003
Gold	0.05
Indium	0.10
Antimony	0.20
Bismuth	2.1 - 2.5
Nickel	0.01

Additional solder alloys manufactured by Nathan Trotter

Lead-Free Alloys

Sn96.5/Ag3.0/Cu0.5 (SAC305)
 Sn99/Ag0.3/Cu0.7 (SAC 0307)
 Sn100 (Tin Bar)
 Sn95/Sb5
 Sn97/3Cu

Leaded Alloys

Sn60/Pb40
 Sn62/Pb36/Ag2
 Sn30/Pb70
 Sn20/Pb80
 Sn40/Pb60

Limits are % max unless otherwise shown as range or stated otherwise. Except where otherwise indicated, the component elements in each alloy shall deviate from their nominal mass percentage by not > 0.10% of the alloy mass when their nominal percentage is ≤ 1.0%; by not > 0.20% of the alloy mass when their nominal percentage is > 1.0% to ≤ 5.0% or by not > 0.50% when their nominal percentage is > 5.0%.



APPLICATION

Nathan Trotter HR95 Solder Bar is a high reliability option that compares to silver bearing SAC alloys in terms of thermal cycling and shock resistance, while minimizing cost as a result of the reduced silver content. Operating temperatures are slightly lower than SAC alloys and dross rates should remain low.

BAR SIZE/SHAPE

Standard sizes typically vary by application.

Application	Bar Description	Approx. Weight
Wave (PCB/THT)	KG Bar, Tri-Bar, Feeder Bar	1 lb, 2.2 lbs, 20 lbs
Radiator	Ingot, Handy Bar, Notch Bar	40 lbs, 20 lbs, 7 lbs
Industrial (Battery)	Ingot, Finger, Shot	60 lb, 1 lb, 2 grams

PACKAGING

Packaging can be made to customer specification. Standard packaging is either boxed (25 lbs or 50 lb boxes) or in the case of larger ingots, stacked and wrapped on a pallet. Each box is labeled with the alloy name, lot number, date of manufacture, weight of packaging unit, and any customer specific information required. Each lot will be accompanied by a certificate of analysis showing lot-specific chemistry.

POT MAINTENANCE

In conjunction with the use of Nathan Trotter solder bar, NT offers a complimentary solder pot analysis program to ensure the user's application remains at optimal chemistry. In-house OES spectrometers are used for a timely turnaround for customer samples. It is recommended that this program is utilized regularly to verify pot chemistry is within operating specification.

RECYCLING / RECLAIM

Tin Technology and Refining (www.tintech.com) is the recycling/reclaim division of Nathan Trotter. Tin Tech works in conjunction with Nathan Trotter solder bar customers to recycle dross, drippings, residues, paste, and other solder scrap that is generated from the use of solder. Tin Tech operates as a permitted, environmentally responsible smelter with full reduction capabilities enabling optimal recoveries for all types of solder scrap material.

STORAGE, HANDLING, SHELF LIFE

Nathan Trotter Solder Bar has an indefinite shelf life when stored in a dry, non-corrosive environment. Bars and packages should always be handled with care as material is naturally heavy.

HEALTH AND SAFETY

This product, during handling or use, may be hazardous to your health. Read the Safety Data Sheet (SDS) and warning label prior to use. SDS can be downloaded from our home page www.nathantritter.com