

## WF6538

*Water Soluble Liquid Flux*



### Product Description

WF6538, Asahi's water soluble liquid flux exhibits excellent capillary action on plated through-holes allowing especially effective soldering of multilayer boards.

The neutral chemistry of this flux is neither acidic nor alkaline. This is an important factor related directly to the reliability and high speed soldering and cleaning of printed circuit assemblies. This flux does not attack properly cured solder masks or FR-4 epoxy glass laminate.

### Application

WF6538 is specially formulated for spraying, foaming and dipping process. Recommended on-board preheat temperature is about 90 - 110°C. This flux is compatible with both SnPb and lead free solders.

### Residue Removal

Flux residue can be removed by plain water at 60 +/- 5 °C. Washing of the PCB when soldered with WF6538 should be done within 4 hours time length.

### Recommended Solvent

Asahi's complementary Solvent #3000. Solvent can be stored for about 2 years under normal storage conditions of 25°C.

### Health and Safety

Observe standard precautions for handling and use, such as well-ventilated areas and avoidance of prolonged or repeated contact with the skin. For more information, please refer to the Material Safety Data Sheet.

### Storage

Under proper storage condition, WF6538 can be stored for up to 12 months. WF6538 is flammable. Keep away from all sources of heat, sparks, flame and sunlight.

### Packaging

Available in 20kg/carboy.

#### DISCLAIMER OF LIABILITY

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### Specification

Item	Result
State	Liquid
Colour	Transparent
Specific Gravity @ 25°C	0.859 +/- 0.005
JIS Z 3197 8.2.2	
Non-volatile Solid Content (110°C, 3hr)	1.6 +/- 0.15 wt%
IPC-TM-650 2.3.34	
JIS Z 3197 8.1.3	
Halide Content	1.05 +/- 0.10 wt%
JIS Z 3197 8.1.4.2.1	
Water Extract Resistivity	> 1 x 10 <sup>4</sup> Ω-cm
JIS Z 3197 8.1.1	
Surface Insulation Resistance (85°C, 85%RH, 168hrs)	> 1 x 10 <sup>8</sup> Ω, Pass
IPC-TM-650 2.6.3.3	
JIS Z 3197 8.5.3	> 1 x 10 <sup>11</sup> Ω, Pass
Electromigration (85°C, 88.5%RH, 596hrs)	Pass
IPC-TM-650 2.6.14.1	
Spread Factor	> 85% (SnPb)
JIS Z 3197 8.3.1.1	

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