

# DLM Product Data Sheet - Solder and Fluxes



## Tin / Lead Soft Solder

Composition	Typical Uses	Solidus	Liquidus	Type BS219 - 1987	Extruded stick	Hand poured stick	Solid Wire	Other
63% Tin 37% Lead	Electrical Wave Soldering (Eutectic)	183	183	A		Y		Feeder bar / chip
60% Tin 40% Lead	General Electrical & Lead lighting	183	188	K	5 mm rod	Y	Y	Resincore wire + *
50% Tin 50% Lead	General Plumbers Solder	183	212	F	Y	Y	Y	Resincore wire*
40% Tin 60% Lead	Blow pipe / Radiator Repair	183	234	G	Y	Y	3/16x25kg rl	Resincore wire*
35% Tin 65% Lead	Wiping of Cable / Pipe Joints	183	245	H	Y	Y	3/16x25kg rl	
30% Tin 70% Lead	Wiping of Cable / Pipe Joints	183	255	J		Y	3/16x25kg rl	Resincore wire*
27% Tin 73% Lead	Panel beating and body work	183	267			Y		

## Antimonial / Tin / Lead Soft Solders

50% Tin 3% Antimony 47% Lead	Coppersmiths and tinsmiths solders	185	204	B			Y	
45% Tin 2.5% Antimony 52.5% Lead	As above and soldering can ends	185	215	M			Y	
32% Tin 1.8% Antimony 66.2% Lead	Wiping metal cables and joint dipping baths	185	243	L			Y	

## Lead Free Soft Solders for Elevated Temperatures

96.5% Tin 3.5% Silver	EUTECTIC	221	221				Y	
95% Tin 5% Antimony	Electrical equipment, high conductivity + MP*	221	245*				Y	
99.3% Tin 0.7% Copper	Hard tin - resists foodstuffs, drugs, artist colours	227	228				Y	

Miscellaneous Products	Typical Uses	Solidus	Liquidus	Type				
Cerrobend	Fusible Alloy (aka Lippowitz)	70	73			Y		
Tin	Pure tin	225	232			Y	Y	castings / anodes
Acid core solder	40% Tin 60% Lead acid core	183	234					1.6 mm 3kg rl, 2.3mm 1/2kg rl
Tin paste Kemtex A	100 % pure tin - paste form							1 kg tins
Solder Paste Kemtex B	40% Tin 60% Lead - paste form							1, 12.5 kg tins
Galmend	Tin Zinc Lead (Repairs to Galvanising)	170	215			Y		
AL3 (Alglo 3)	Aluminium Solder	165	220			Y		
<b>Other grades available on request</b>								
DLM general purpose flux	Soldering flux (All non ferros metals)							0.1 , 1 litre bottles
Bakers Solderine paste	Soldering flux paste							150 gram tin
HC6040	DLM HANDY MAN RANGE - Resincore solder for general electrical and leadlighting	183	188	K				15 gram card 55 gram reel
HR6040								
HC5050	DLM HANDY MAN RANGE - Resincore solder for hobby, toy automotive and garden repairs	183	212	F				25 gram card 70 gram reel
HR5050								

## Diameter Conversion

*Type 39 Flux is available in 30/70, 40/60, 50/50, & 60/40 Resin Core Solder	More aggressive flux suited to older electrical soldering, automotive and refrigeration repair, and soldering of most non - ferrous metals.	10swg	13swg	16swg	18swg	20swg	22swg
*Type 35 Flux is only available in 60/40 Resin Core Solder	A less aggressive flux best suited for electrical and electronic manufacturing	3.2 mm	2.3 mm	1.6 mm	1.2 mm	0.91 mm	0.71 mm



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