

4860-4865



Sn63/Pb37 No-Clean Solder Wires

4860-4865 solder wires are electronic grade and use the eutectic tin-to-lead alloy ratio, with a no-clean, synthetically refined, splatter-proof, resin flux core. They are the easiest solders to work with because it offers a low-melting temperature with a sharp melting/solidification point, which results in robust and reliable joints that are highly resistant to whisker formation.

They achieve a consistent solder and flux percentage thanks to our state-of-the-art extrusion wire-drawing machine, which continuously monitors the wire to prevent voids and ensure consistency, providing a top-grade solder wire.



Features & Benefits

Eutectic alloy (liquidus=solidus temperature)

Alloy exceeds J-STD-006C and meets ASTM

Flux meets J-STD-004B

Spreads like rosin-activated flux

Virtually non-splattering

Non-corrosive and non-conductive residue

Halide free

Available Packaging

Part #	Packaging	Gauge	Diameter	Net Wt.
4860-18G	Pocket Pack	21	0.032"	18 g
4865-227G	Spool	21	0.032"	227 g
4865-454G	Spool	21	0.032"	454 g

Storage and Handling

Store between 18 and 25 °C in a dry area, away from sunlight (see SDS).

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Properties

Flux Classification	RELO	J-STD-004B, MIL-F-14256F
Flux Type	Resin	J-STD-004B
Flux Activity	Low	J-STD-004B
Copper Mirror	No removal	IPC-TM-650 2.3.32
Corrosion Test	Pass	IPC-TM-650 2.6.15
Flux Residue Dryness	Pass	IPC-TM-650 2.4.47
Surface Insulation Resistance (SIR)	$2.3 \times 10^{11} \Omega$	IPC-TM-650 2.6.3.7
Electromigration (ECM)	Pass	Bellcore GR-78-CORE 13.1.4
Acid Number (mgKOH/g sample)	190–210	IPC-TM-650 2.3.13
Halides (by weight)	<0.05%	IPC-TM-650 2.3.35
Silver Chromate (Cl ⁻ + Br ⁻)	Pass	—
Softening Point of Flux Residue	24 °C	—
Solder Spread	130 mm ²	—
Splitting of Flux, cored wire solder	0.30 %	—
Post Reflow Flux Residue	55 %	—
Bellcore (Telecordia)	$6.1 \times 10^{11} \Omega$	—
Shelf Life	10 y	—

Disclaimer: This information is believed to be accurate. It is intended for professional end-users who have the skills required to evaluate and use the data properly. M.G. Chemicals Ltd. does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.

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