

ALPHA[®] ENERGIZED PLUS RA WIRE SOLDER

Type RA per QPL-571-28-89, Passes IPC-TM-650 2.6.3.3

DESCRIPTION

ALPHA Energized-Plus is the most effective RA MIL-SPEC rosin core solder yet developed for hand soldering. Similar in design to Energized core solder, Energized-Plus is more active still. It meets the full requirements of QPL listing for Federal Specification **QPL-571-28-89** for Type RA flux-core solder.

FEATURES & BENEFITS

ALPHA Energized-Plus is suitable for use in any electronic hand-soldering application requiring compliance with Military Specifications for RA class fluxes. It is also suitable for those commercial electronic operations modeled after Military Specifications. Some of these include: computer, aerospace, telecommunications, automotive and entertainment industry applications.

The unique activator system of **ALPHA Energized-Plus** enables the flux to penetrate even heavily tarnished surfaces among the following metals:

Beryllium Copper	Lead	Terne (Plate)
Brass	Nickel (Plate)	Tin (Hot Dip)
Bronze	Silver	Tin (Plate)
Cadmium	Solder (Plate)	
Copper	Solder (Hot Dip)	

RESIDUE REMOVAL

In applications requiring cleaning, **ALPHA Energized-Plus** flux residues can be readily removed using either Alpha 564M, 565 or 1003 solvents, an aqueous saponifier cleaning process using Alpha 2110, or semi-aqueous cleaning using Bioact[®] EC-7.

SAFETY

ALPHA Energized-Plus is not considered toxic, however, its use in typical soldering processes will generate a small amount of decomposition and reaction product fumes. These fumes must be adequately exhausted for operator safety and comfort. Consult the SDS for additional safety information. The most recent version of the SDS is available from alphaassembly.com.

SHELF LIFE

If >36 months from manufacture, please submit sample Alpha Assembly Solutions for testing.

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TECHNICAL DATA

Physical Properties	Typical Values
Softening Point	71°C (160°F)
Rosin Grade	WW per Fed. Spec. LLL-R-626
Water Extract Resistivity	> 50,000 ohm-cm., per QQS-571F
Plasticizier	Very high boiling solvent; creates low smoke and older properties
Wetting Balance Test	Fastest recorded wetting time of all RA; MIL-SPEC core solders
QPL Listing Number	571-27-89
J-STD-004	ROM1
ISO 12224	1.1.2

AVAILABILITY

Alloy Description	Flux Loading	Wire
63Sn/37Pb	P2 and P3 (2.2% and 3.3% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)
60Sn/40Pb	P2 and P3 (2.2% and 3.3% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)
40Sn/60Pb	P2 and P3 (2.2% and 3.3% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)
10Sn/88Pb/2Ag	P2 (2.2% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)
5Sn/93.5Pb/1.5Ag	P2 (2.2% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)
Vaculoy SACX0307 *	P2 and P3 (2.2% and 3.3% nominal)	.010" to .125" (Spool Weight 1, 5, 20 Lbs.)

* Lead-Free Alloy

This material can also be made available in an alloy that is nominally 95% Sn and 5% Sb. Please contact your local Alpha Assembly Solutions representative to discuss flux, loading, diameter and minimum order quantities for this alloy.

ALPHA Energized-Plus is available in ESD approved plastic spooling per the DOD 2000 specification.

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CONTACT INFORMATION

To confirm this is the most recent issue, please contact Alpha Assembly Solutions

AlphaAssembly.com

<p>North America 300 Atrium Drive Somerset, NJ 08873, USA 800.367.5460</p>	<p>Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 01483.758400</p>	<p>Asia 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p>
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency directory assistance Chemtrec 1 - 800 - 424 - 9300.

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