

94-SEL

Rev: 15.1

**Date** 2021.08.17  
**Language** English  
**SDS** 950406



**Summary**

94-SEL is a RELO classified, partially water based flux for selective soldering. It is based on synthetic resins and is suitable for high reliability applications.

Flux code	94-SEL	
<b>PROCESS</b>		
No-Clean process	9	
Post-solder cleaning	7	

INDUSTRY APPLICATION		
Consumer electronics	6	
Standard industrial electronics	9	
Hi-Rel electronics (automotive)	9	

PROCESS CAPABILITY		
Dip Soldering	8	
Drag soldering	9	
Dropjet fluxing	9	
High Pre-heat compatible	9	
High soldering temp compatible	9	
Long contact time compatible	8	
Reduces spreading of flux	8	
Reduces solderballing	9	
Reduces bridging	8	
Improves TH filling	8	
Brilliant joint appearance	9	
Cosmetic Cleanliness	8	
ICCT compatible	9	
Conformal coating compatible	9	

Legend		
<i>Especially made for this purpose</i>	9 - 10	
<i>Generally qualified for this purpose</i>	7 - 8	
<i>Generally usable, but not the best choice</i>	5 - 6	
<i>Generally not usable for this purpose</i>	3 - 4	
<i>Wrong choice</i>	1 - 2	

CLASSIFICATION	
DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	RELO

PROPERTIES		
Density	@20°C [kg/dm³]	0.848
Acid number	[mg KOH/g]	13.9
Solid content	[% w/w]	2.6
Water content	[% w/w]	21
VOC content	[% w/w]	Remainder
Filmformer(s)		Resin
Color		Colorless
Odor		Mild alcoholic
Flashpoint COC	[°C]	16.5
Thinners		308-00

TEST REPORTS			
Certificate of Compliance			website
Application Note			english
Copper Mirror	IPC-TM-650 2.3.32		Pass
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		N/A
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		Pass

PACKAGING AND STORAGE		
Packaging bottle (HDPE) [liter]	(HDPE) [liter]	1
Packaging can (HDPE) [liter]	(HDPE) [liter]	5 / 10
Recommended shelf-life in Months		
Storage temperature	20-25 °C	9

**Check material compatibility with every process change!**

**Industrial chemical product.**

**Read MSDS before use.**

**Disclaimer:**

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