



**Laboratory for Chemical Production
in Electronic Industry**

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Technical Data Sheet	Sn97Bi2Cu1P
Product name:	
Solder MARMOT® Sn97Bi2Cu1P	
Description and key properties:	
<ul style="list-style-type: none"> • Patented lead-free (RoHS) solder MARMOT® designed for soft soldering in electronics • Solder with excellent wetting, alloy does not cause microcrackles • For its great efficiency is perfect replacement for expensive silver soft solders • Low working temperature - crucial in cases such as soldering plastic connectors, eyelets and other thermally endangered parts • Soldered joints does not reach high glossy surface • Content of Copper reduces dissolving copper soldered parts and equipment • Content of Bismuth decrease internal molecular tension of soldered joint and increase its strength and reliability • Content of Phosphorus increase fluidity and reduces oxidization 	

Technical specification				Sn97Bi2Cu1P			
Commercial Name:				Cored wire solder MARMOT® Sn97Bi2Cu1P			
Supplied and shaped as multicored wire with flux. Manufactured according to MARMOT® patented invention.							
Diameter and Package:		0,5/0,8/1/1,5/2/3		mm	Reel	100/250	g
Fully complies EU directive RoHS					Reel	0,5/1/6	Kg
	List of components:	alloyed				content range	
			U	min.	max.	U	
Ag	Silver		%	0,000	0,050	%	
Bi	Bismuth	1,80	%	1,600	2,400	%	
Fe	Iron		%	0,000	0,020	%	
P	Phosphorus	0,05	%	0,016	0,200	%	
Sb	Antimony		%	0,000	0,050	%	
Al	Aluminium		%	0,000	0,001	%	
Cd	Cadmium		%	0,000	0,002	%	
In	Indium		%	0,000	0,050	%	
Pb	Lead		%	0,000	0,049	%	
As	Arsenic		%	0,000	0,010	%	
Cu	Copper	0,65	%	0,600	0,800	%	
Ni	Nickel		%	0,000	0,010	%	
Zn	Zinc		%	0,000	0,001	%	
Sn	Tin	97,5	%	rest	rest	%	
	Melting point:	223–225	°C				
	Working temperature*:	252	°C				
Working temperature is the temperature when fluidity is the best for soldering							