

# ALPHA® SACX Plus® 0807/SACX Plus® 0800

## LEAD FREE SOLDER ALLOY

### DESCRIPTION

ALPHA SACX Plus 0807 is a low silver lead-free alloy specially designed with proprietary additives to deliver soldering and reliability performance similar to higher silver SAC alloys (ie. SAC305, 405, etc...). The SACX Plus 0800 variant is used to stabilize / reduce the copper content in the wave solder bath; this requirement will depend on process conditions. As with all Alpha Metals wave solder alloys, Alpha's proprietary Vaculoy™ process is used to remove certain impurities, particularly oxides. SACX Plus 0807 can be used for the widest range of assemblies and under the widest range of operating conditions of any low silver or silver free alloy available today. SACX Plus 0807 is available in a variety of forms including solid wire for replenishment and rework requirements.

### FEATURES & BENEFITS

Feature	Benefit
<b>Low Silver Content</b>	Lower material costs vs SAC305
<b>Low Operating Temperature Requirement</b>	Wide processing window and energy cost savings. Drop in to most current lead free wave soldering machine temperature profiles
<b>Low Dross Rate</b>	Less dross means higher alloy utilization and less time spent on pot "maintenance"
<b>Low Copper Erosion Rate</b>	Less risk during high temperature, high exposure time processes (i.e. rework, selective soldering, etc...)
<b>Low Surface Tension Alloy</b>	Fast wetting with high wetting force delivering excellent hole fill and low SMD related defects
<b>Strong, Ductile Joints</b>	Lower warranty claims related to mechanical joint failures

The proprietary Vaculoy process is a highly effective method for removing included oxides from solder. This is extremely important because included oxides generate excessive drossing and increase the viscosity of the solder. Solder with higher viscosity can result in increased soldering defects (i.e. solder bridging).

### APPLICATION

ALPHA SACX Plus 0807 is suitable for wave soldering and selective soldering for electronic assemblers interested in implementing a lead-free process. It is suitable for nearly all types of boards (single & double-sided) and works particularly well on assemblies with OSP pad finishes that have been exposed to prior reflow excursions and where lower silver or silver free alloys have not worked. For suitable wave solder fluxes, please visit [www.alpha.alent.com](http://www.alpha.alent.com) and navigate to the Wave Solder Flux Selector tool on the Wave Solder flux main page. Lead free Reclaim services including dedicated lead free containers are also available; please consult your local sales office.

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### AVAILABILITY

ALPHA SACX Plus 0807 is available in a variety of sizes including 1kg bar, chunks, Feeder Ingots and solid wire.

### SAFETY

Consult the SDS for all safety information. The most recent version of the SDS is available from AlphaAssembly.com.

### TECHNICAL DATA

Complies with all requirements of RoHS Directive (Article 4.1 of the European Directive 2011/65/EU). Alloy specification for Maximum Lead (Pb) Content = 0.07%. *SACX Plus 0807 is also available in an Ultra Low Lead (ULL) version which contains a maximum of 0.05% Pb.* All alloy properties remain the same for SACX Plus 0807 ULL.

Material Property	SACX Plus 0807	Test Method
<b>Solidus</b>	216°C	Differential Scanning Colorimeter (DSC)
<b>Liquidus (peak)</b>	225°C	Cooling Curve
<b>Density</b>	7.4 g / cm <sup>3</sup>	Calculated
<b>Resistivity</b>	0.1399 μΩm	Measured resistance of solid wire at 22°C
<b>Coefficient of Thermal Expansion</b>	19.5 x 10 <sup>-6</sup> / C	30 - 100°C at 1°C / minute
	20.2 x 10 <sup>-6</sup> / C	100 - 180°C at 1°C / minute
<b>Spread Factor</b>	> 75%	JIS Z 3197
<b>Specific Heat</b>	0.23 J/g/°C	At 100°C, Differential Scanning Colorimeter (DSC)
<b>Hardness</b>	16.4 HV	Vickers Hardness (as cast)
<b>Tensile Strength</b>	30.7 MPa	Strain rate 10 <sup>-3</sup> per second
<b>Elongation</b>	21.0 %	Strain rate 10 <sup>-3</sup> per second
<b>Creep Strength</b>	> 1000 Hours	400 g/mm <sup>2</sup> load @ 100°C

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### RECOMMENDED WAVE SOLDER PROCESS SETTINGS

Wave Configuration	Process Parameter	Suggested Process Settings
Single and Dual Wave	Pot temperature	255 - 270° Celsius (491 - 518° F)
	Contact time	3 - 6 seconds
	Wave Height	1/2 to 2/3 of board thickness
	Dross removal	Once per 8 hour run time
	Copper Check	Every 8,000 boards until 40,000

*These are general guidelines which have proven to yield excellent results. However, depending upon your equipment, components and circuit boards, your optimal settings may be different. In order to optimize your process, it is recommended to perform a design experiment, optimizing the most important variables (i.e. amount of flux applied, conveyor speed, topside preheat temperature, solder pot temperature, board orientation, etc...).*

### MANAGEMENT OF COPPER LEVELS IN THE SOLDER BATH

**Copper should be controlled in the solder bath between 0.7% and 1.0%**

Management of the copper level in the wave solder bath is critical to ensure low defects in the soldering process. There is a tendency for the copper levels within a high tin bearing alloy wave solder bath to increase due to copper dissolution from the PCB. This effect increases based on the level of exposed copper on the assembly, as in the case of boards using OSP pad finishes.

Studies have shown a typical leaching rate of 0.01% Cu per 1000 boards. As each process is unique, this rate should be viewed as a guideline only. It is recommended that the copper is controlled at between 0.7% and max 1.0% for SACX Plus 0807 alloy. If the copper levels are higher than 1.0% then this will increase the liquidus temperature which in turn may mean that the solder bath temperature has to be increased to maintain the process yields.

The copper levels in the bath can be controlled by means of adding SACX Plus 0800 to the wave solder pot. It may be the case that equilibrium can be attained by continuing with SACX Plus 0800 additions as the only means of solder top up, however each process is unique and we would recommend regular analysis of the solder bath so that good control of copper can be maintained.

This analysis service is available from Alpha; contact your local sales office for details.

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### RECOMMENDATION ACTION LEVELS FOR WAVE SOLDER IMPURITIES

Please find below a list of recommended action levels for wave solder bath impurities. For information of specific action plans to bring your solder bath back to an acceptable condition please contact your local sales office.

Element	ACTION Levels %	Notes
Sn	<b>BAL</b>	No Action level.
Pb	<b>0.10</b>	RoHS Directive 2011/65/EU states a maximum Lead content of 0.1%
As	<b>0.03</b>	Levels greater than 0.03% can cause de-wetting.
Cu	<b>1.0</b>	SACX Plus 0807 is tolerant to copper levels up to 1.0%, SACX Plus 0800 copper free should be added to maintain copper levels. Levels above 1.0% may cause more bridging.
Bi	<b>0.20</b>	Lead Free alloys are tolerant to Bi up to 1.0%, however if levels above 0.20% are detected this indicates some contamination issues that should be investigated
Zn	<b>0.003</b>	Levels greater than 0.003% may cause increased bridging and icicling, as well as, increased crossing rates in the solder bath.
Fe	<b>0.02</b>	Greater than 0.02% Iron can be an indicator of pot erosion and may cause gritty joints and the formation of FeSn <sub>2</sub> IMC needles that can cause bridging.
Ag	<b>1.0</b>	Silver levels of 4% are used in some SAC alloys, however if the levels in SACX 0807 rise above 1% then some investigations should be held to establish the cause.
Sb	<b>0.20</b>	Lead Free alloys are tolerant to Sb up to 1.0%, however if levels above 0.20% are detected this indicates some contamination issues that should be investigated
Ni	<b>0.05</b>	Levels greater than 0.05% may start to slow wetting and may reduce hole fill. Evaluate soldering performance if levels exceed 0.05%. Locate and eliminate source of high Ni levels.
Cd	<b>0.003</b>	RoHS Directive 2011/65/EU states a maximum Cadmium content of 0.01%. Levels of 0.003% may cause higher level of bridging and icicling.
Al	<b>0.002</b>	Levels greater than 0.002% may cause higher levels of bridging and icicling and a greater level of surface oxidation in the solder bath.

# ALPHA<sup>®</sup> SACX Plus<sup>®</sup> 0807/SACX Plus<sup>®</sup> 0800

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### CONTACT INFORMATION

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

<p><b>North America</b> 300 Atrium Drive Somerset, NJ 08873, USA 800.367.5460</p>	<p><b>Europe</b> Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 01483.758400</p>	<p><b>Asia</b> 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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