



QUALITEK®

DELTA® 792 Solder Paste Water Soluble

DESCRIPTION

792 is a halide free, water cleanable solder paste is designed for surface mount and other electronic assembly applications. Post reflow residue can be easily removed in warm DI water cleaning systems.

BENEFITS

- Halide Free
- Excellent heat stability during reflow
- Excellent tackiness
- Eliminates the use of solvents and saponifiers
- Residues are easily removed with warm water

APPLICATION

PRINTING / PARTICLE SIZE

≥ 50 mil pitch: Use -200 +325 mesh

≥ 16 mil pitch: Use -325 +500 mesh

≤ 16 mil pitch: Use -400 +635 mesh

ALLOYS

Sn63/Pb37, Sn62/Pb36/Ag2, etc.

(Meets J-STD-006 Specification)

METAL CONTENT

Stencil Printing: 90%

Screen Printing: 88%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 792 can be processed in most reflow media, (i.e. IR, Vapor-phase, Forced convection, etc.). Ramp rate of 2.5-3.0°C per second is desirable, since most components are rated for 4.0°C per second.

PHYSICAL / CHEMICAL CHARACTERISTICS

Color and Appearance	Metallic Gray
Copper Mirror Test	Pass
pH-5% Aqueous Solution (Flux Extract)	7.0 – 8.0
Viscosity	
Malcom ¹	245 – 280 kcps, 90% metal, (-325+500 mesh)
Brookfield ²	1,000 kcps +/- 10%, 90% metal, (-325+500 mesh)
Tack	
Time	6 - 8 Hours

SHIPPING & STORAGE

Recommended Storage Temperature	35°-50°F
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SHELF LIFE

Unopened Container	35°-65°F	6 Months (from DOM)
	77°F	1 Months (from DOS)

1. Malcom PCU-Series, 10 RPM, 25°C
2. Brookfield RVTD, TF spindle, 5 RPM, 25°C, 0.75" spindle depth

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Consult MSDS for health and safety information

792 PROFILE

