



ESL EUROPE

SOLDER PASTES &
THICK-FILM MATERIALS

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SOLDER PASTE

3716

93.5Pb / 5Sn / 1.5Ag Alloy Solder Paste

3716 is a high reflow temperature solder paste. Reflow temperatures depend on the board and component size and should be optimised to give minimal charring of the small amount of flux residues.

PASTE DATA

Solder Alloy: (Meets QQ-S-571-E Specifications)	93.5Pb / 5Sn / 1.5Ag
Particle Size:	-325 / +500 mesh
Viscosity: (Brookfield RVTD, Helipath Stand, 5 rpm, TF spindle, 25.5 ± 0.5 °C)	550 ± 50 Pa.s
Solids:	85 ± 0.5 %
Solidus / Liquidus Temperatures:	296 / 301 °C
Reflow Temperature:	> 340 °C
Flux:	Rosin Activated
Flux Removal:	Residue can be removed using standard flux solvent or saponifier cleaning methods
Thinner:	ESL 401
Packaging:	500 - 1000 g in jars and 1 kg cartridges
Shelf Life (5 - 25 °C):	6 months

ESL Europe 3716 0507-E

ESL Worldwide

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See Caution and Disclaimer on next page.

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CAUTION: Proper industrial safety precautions should be exercised in using these products. Use with adequate ventilation. Avoid prolonged contact with skin or inhalation of any vapours emitted during use or heating of these compositions. The use of safety eye goggles, gloves or hand protection creams is recommended. Wash hands or skin thoroughly with soap and water after using these products. Do not eat or smoke in areas where these materials are used. Refer to appropriate MSDS sheet.

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