

Lastek 3204 IS

Flux cored soft solder for general use

CLASSIFICATION

GENERAL DESCRIPTION

Very easy, thin flowing soft solder with low melting point.
 High tensile- and shear strength.
 Suitable for delicate work, using a soldering iron or soft flame.
 Applicable on stainless steel, steel, copper, zinc, lead, nickel, cast iron, galvanised steel.

APPLICATIONS

Joints in cooling installations, jewellery industry, musical instruments, bird cages, radiators.
 The aggressive flux in the core makes Lastek 3204IS not suitable for electronic applications.

Melting temperature: 183 - 188 °C (360 - 370 °F).

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

Sn : 59.00 - 60.00	Pb : Balance			
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 48 MPa		

GENERAL INFORMATION

Welding positions NA

Shielding gas NA

Packing 0.5 kg spool

Polarity NA

Diameter (mm) 2.0

Tips & tricks

To obtain maximal strength, soldering gap has to be between 0.08 to 0.15 mm.
 Degrease the pieces to be joined. Slightly preheat with a soft flame. Melt the solder by striking the solder along the gap.
 Can also be used with a soldering iron: when the solder is pressed on the iron to melt it, the flux could become inactive; so apply the solder on the parent metal and press the soldering iron on the solder and the joint.
 Remove flux residues with hot water.
 Work in a well-ventilated area.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.