



650 Weaver Park Road, Unit D
Longmont, CO 80501
720-494-0835
www.electronicrecoveryservice.com

Solder Paste 101

Here are descriptions of the key elements you will need to understand about soldering:

- **Alloy**
 - **Flux Type**
 - **Metal Content**
 - **Particle Size**
1. **Alloy** denotes the metallurgy of the paste. A typical “eutectic” solder will be Sn63/Pb37... this is the lowest melting point Tin (Sn) Lead (Pb) solder.
 2. **Flux Type** can be one of three major categories. 1. Water Soluble, (also known as aqueous). 2. Rosin (RMA) (relies on vapor degreasing or water wash with saponifier. 3. No-Clean / low residue (typically an RMA derivative)
 3. **Metal Content:** This is the % of metal to flux in the paste. Table is available for pitch vs. metal content in “Reflow Soldering Processes” by Lee.
 4. **Particle size** is defined by Type and/or Mesh. The Larger the type # the finer the atomization of the solder (smaller particle size for finer pitch applications). Current “standard pitch” (.020” or >) is a type III.