Afrisol Range of Soft Solder Alloys

		Metal Composition (% metal by weight)							
Alloy No	**Typical Uses**	**Sn**	**Sb**	**Cu**	**Ag**	**Bi**	**Cd**	**Pb**	**Sol/Liq Temp.**
S1	Commutator work. Fine jointing where minimal heat is required.	64,0 – 66,0	1,0	0,05	-	0,10	0,002	Rem	183-186
S2	General purpose for long seams	49,0 – 51,0	2,5-3,0	0,05	-	0,10	0,005	Rem	185-204
S3	General purpose solder. Not for Zn	39,0 – 41,0	2,0-2,4	0,08	-	0,25	0,005	Rem	185-228
S4	Soldering of electrical parts. Suitable for use on Zinc	39,0 – 41,0	0,30	0,08	-	0,25	0,005	Rem	183-235
S5	Wiping Solder. Lead cable sheating	29,0 – 31,0	1,0-1,7	0,08	-	0,25	0,005	Rem	185-250
S6	Copper, Brass, Zinc	49,0 – 51,0	0,50	0,05	-	0,10	0,002	Rem	183-215
S7	Lead Cable sheaths. Radiator repairs	34,0 – 36,0	0,30	0,08	-	0,25	0,005	Rem	183-245
S8	Electrical and electronic applications. Stained glass work	59,0 – 61,0	0,50	0,05	-	0,10	0,002	Rem	183-190
S9	Low grade solder for hand work, wiped joints, lead cable, etc	29,0 – 31,0	0,30	0,08	-	0,25	0,005	Rem	183-255
S10	Automotive Body solder	25,0 – 27,0	1,0-1,7	0,08	-	0,25	0,005	Rem	185-260
S11	Automotive Body solder-less critical work	25,0 – 27,0	0,30	0,08	-	0,25	0,005	Rem	183-265
S12	Automotive Body solder-shallow areas	2,5 – 2,75	5,0-5,25	0,08	-	0,25	0,005	Rem	240-285
S13	Tubular radiator manufacture	5,0 – 5,5	3,8-4,2	0,08	-	0,25	0,005	Rem	240-280
S14	Automotive Body filler. Radiator mnf	19,0 – 21,0	0,9-1,2	0,08	-	0,25	0,005	Rem	185-270
S15	Lamp soldering. Dip soldering	14,0 – 15,0	0,50	0,08	-	0,25	0,005	Rem	226-289
S16	Ferrous and non-ferrous materials	44,0 – 45,0	2,2-2,7	0,08	-	0,25	0,005	Rem	185-215
S17	Electronic printed circuit board mnf	62,5 – 63,5	0,05	0,05	-	0,05	0,002	Rem	183-185
S18	Electric motors/refrigeration	REM	4,5-5,5	0,10	0,05	0,10	0,002	0,1	232-240
S19	Copper piping	REM	0,05	2,5-3,5	0,05	0,10	0,005	0,1	230-250
S20	Food processing, refrigeration, etc	REM	0,10	0,05	3,5-4,0	0,10	0,002	0,1	221
S21	Low melting point-general purpose	74,0 – 76,0	-	-	-	-	-	-	190-210