

Lastek 3102 IS

Flux cored soft solder for stainless steel

CLASSIFICATION

EN 29453 : S - Sn96Ag4

GENERAL DESCRIPTION

Soft solder without lead or cadmium, for joining stainless steel, steel, cadmium plated steel, copper and its alloys, tin and silver. The shear strength is almost twice the strength of tin lead solders.

Application temperature up to 100°C (212°F) (At this temperature the mechanical strength is almost 4 times the strength of a Sn Pb solder).

Due to the corrosive flux in the core, Lastek 3102IS shall not be used on electronic circuits or prints.

APPLICATIONS

Joining thin sheets and tubes in stainless steel.

Food industry, toys, refrigerating installation, soft drink equipment, organs.

Tensile strength Rm: 54 N/mm² (7.8ksi)

Temperature: 221°C (430°F)

Electrical resistivity 0.12 ohm.mm²/m (5.10⁻⁶ ohms/in/in²)

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

Ag : 3.50 - 5.00	Sn : 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)
	≥ 60 MPa		

GENERAL INFORMATION

Welding positions PA, PB

Shielding gas NA

Packing 0.5 kg spools

Polarity NA

Diameter (mm) 1.0 2.0 3.0

Tips & tricks

Joint gap 0.08 to 0.10 mm (0.003-0.004") for maximum strength.

Degrease the parts if strongly contaminated and preheat with soft flame.

Melt the rod on applying the rod along the joint.

Lastek 3102IS can be used with a soldering iron: do not apply the solder on the iron, this will deactivate the flux. Carefully apply the solder onto the preheated workpiece and simultaneously push the iron on the joint.

Remove flux residues with warm water.

Work in a 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.