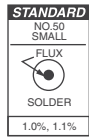
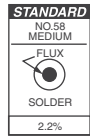
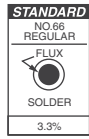




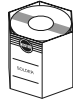
# Flux-Core Solders



Alloy	Melting Range (°F)
Sn63Pb37	361
Sn60Pb40	361-374
Sn62Pb36Ag02	354-372
Sn43Pb43Bi14	291-325
Sn96.5Ag3.0Cu0.5	423
Sn99.3Cu0.7	440

## "44" RA Solders

Kester "44" has virtually dominated the field of activated rosin core solders for well over four decades. An outstanding performance feature of this flux is the "instant wetting" action. The high mobility and fast spreading action of this flux results in more reliable production line soldering. Gold Label.



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>RA Solder "44", 63/37, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1100-ND	24.63	22.17	19.70
18 Gauge Solder, 3.3% Flux, .050" (1.27mm) dia.....	KE1108-ND	25.38	22.84	20.30
19 Gauge Solder, 3.3% Flux, .040" (1.02mm) dia.....	KE1101-ND	27.63	24.87	22.10
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1102-ND	29.13	26.22	23.30
23 Gauge Solder, 3.3% Flux, .025" (.63mm) dia.....	KE1109-ND	30.23	27.21	24.18
25 Gauge Solder, 3.3% Flux, .020" (.51mm) dia.....	KE1103-ND	40.25	36.23	32.20
28 Gauge Solder, 3.3% Flux, .015" (.38mm) dia.....	KE1110-ND	47.13	42.42	37.70
<b>RA Solder "44", 60/40, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1104-ND	24.00	21.60	19.20
18 Gauge Solder, 3.3% Flux, .050" (1.27mm) dia.....	KE1115-ND	24.75	22.28	19.80
19 Gauge Solder, 3.3% Flux, .040" (1.02mm) dia.....	KE1105-ND	27.00	24.30	21.60
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1106-ND	28.50	25.65	22.80
23 Gauge Solder, 3.3% Flux, .025" (.63mm) dia.....	KE1116-ND	29.60	26.64	23.68
25 Gauge Solder, 3.3% Flux, .020" (.51mm) dia.....	KE1107-ND	39.63	35.67	31.70

## "48" RA Lead-Free Solder



Kester "48" activated rosin flux for cored solder wire was developed for lead-free applications to enable soldering of most common metals. Performance characteristics far exceed standard RA fluxes. Kester "48" builds on the performance of its predecessor Kester "44" with "instant-action" wetting to provide fast and reliable solder joints. Kester "48" is classified as ROL1 per J-STD-004.



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>Sn96.5Ag3.0Cu0.5, 1 Lb Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1125-ND	51.65	46.49	41.32
18 Gauge Solder, 3.3% Flux, .050" (1.27mm) dia.....	KE1124-ND	52.40	47.16	41.92
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1123-ND	56.15	50.54	44.92
23 Gauge Solder, 3.3% Flux, .025" (0.64mm) dia.....	KE1122-ND	57.25	51.53	45.80
25 Gauge Solder, 3.3% Flux, .020" (0.51mm) dia.....	KE1121-ND	67.28	60.55	53.82

## "245" No-Clean Solders

Kester "245" Low Residue Solder was developed to complement the newer generations of Low Residue Fluxes being used in the electronics industry. The use of "245" Low Residue Flux results in visually acceptable assemblies without the need for cleaning. Soldering quality and efficiency is comparable to that of a RMA flux. 1.1% flux standard, 2.2% and 3.3% for faster wetting action. Cream label.



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>No Clean Solder "245", 63/37, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 1.1% Flux, .062" (1.57mm) dia.....	KE1399-ND	24.63	22.17	19.70
18 Gauge Solder, 1.1% Flux, .050" (1.27mm) dia.....	KE1402-ND	25.38	22.84	20.30
19 Gauge Solder, 1.1% Flux, .040" (1.02mm) dia.....	KE1403-ND	27.63	24.87	22.10
21 Gauge Solder, 1.1% Flux, .031" (.79mm) dia.....	KE1400-ND	29.13	26.22	23.30
23 Gauge Solder, 1.1% Flux, .025" (.63mm) dia.....	KE1404-ND	30.23	27.21	24.18
25 Gauge Solder, 1.1% Flux, .020" (.51mm) dia.....	KE1401-ND	40.25	36.23	32.20
28 Gauge Solder, 1.1% Flux, .015" (.38mm) dia.....	KE1405-ND	47.13	42.42	37.70
<b>No-Clean Solder "245", 63/37 1 Lb. (.45 kg) Spool</b>				
21 Gauge Solder, 2.2% Flux, .031" (.79mm) dia.....	KE1408-ND	29.13	26.22	23.30
25 Gauge Solder, 2.2% Flux, .020" (.51mm) dia.....	KE1409-ND	40.25	36.23	32.20
<b>No-Clean Solder "245", 63/37 1 Lb. (.45 kg) Spool</b>				
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1410-ND	29.13	26.22	23.30

## "275" No-Clean Lead-Free Solder



Kester "275" No-Clean Flux for cored solder wire was developed to provide superior wetting performance for hand soldering in the electronics industry. The use of "275" No-Clean Flux results in an extremely clear post-soldering residue without cleaning. The unique chemistry in Kester "275" was also designed to reduce spattering common to most core fluxes. Kester "275" is Classified as ROL0 per J-STD-004.

Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>Sn96.5Ag3.0Cu0.5, 1 Lb Spool</b>				
16 Gauge Solder, 2.2% Flux, .062" (1.57mm) dia.....	KE1134-ND	51.65	46.49	41.32
18 Gauge Solder, 2.2% Flux, .050" (1.27mm) dia.....	KE1133-ND	52.40	47.16	41.92
21 Gauge Solder, 2.2% Flux, .031" (.79mm) dia.....	KE1137-ND	56.15	50.54	44.92
23 Gauge Solder, 2.2% Flux, .025" (0.64mm) dia.....	KE1132-ND	57.25	51.53	45.80
25 Gauge Solder, 2.2% Flux, .020" (.51mm) dia.....	KE1131-ND	67.28	60.55	53.82

## "285" RMA Solders

Kester "285" has been developed for the use in the electronics industry where difficult assemblies are to be soldered, but process requirements stipulate use of a mildly activated rosin flux. Kester "285" mildly activated rosin flux is classified as Type ROL1 flux under IPC ANSI/J-STD-004 Standards. Green Label.



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>RMA Solder "285", 63/37, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 2.2% Flux, .062" (1.57mm) dia.....	KE1199-ND	24.63	22.17	19.70
21 Gauge Solder, 2.2% Flux, .031" (.79mm) dia.....	KE1201-ND	29.13	26.22	23.30
25 Gauge Solder, 2.2% Flux, .020" (.51mm) dia.....	KE1200-ND	40.25	36.23	32.20
28 Gauge Solder, 2.2% Flux, .015" (.38mm) dia.....	KE1203-ND	47.13	42.42	37.70

## "331" Organic Water Soluble Solder

Kester "331" Organic Flux is a water soluble formula for use in flux-cored solder wire. Kester "331" flux is more effective than rosin fluxes in soldering difficult metals and allows a simple water wash for flux cleanup. The flux is more heat stable than most organic fluxes, resulting in minimal smoke and odor. The residue can be completely removed with a simple water rinse. Kester "331" is classified as type ORH1 per IPC ANSI/J-STD-004. Red Label.



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>Water Soluble Solder "331", 63/37, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1299-ND	24.63	22.17	19.70
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1300-ND	28.50	25.65	22.80
23 Gauge Solder, 3.3% Flux, .025" (.63mm) dia.....	KE1302-ND	30.23	27.21	24.18
25 Gauge Solder, 3.3% Flux, .020" (.51mm) dia.....	KE1301-ND	40.25	36.23	32.20
28 Gauge Solder, 3.3% Flux, .015" (.38mm) dia.....	KE1303-ND	47.13	42.42	37.70
<b>Water Soluble Solder "331", 60/40, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1304-ND	24.63	22.17	19.70
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1305-ND	29.13	26.22	23.30

## "331" Organic Water Soluble Lead-Free Solder



Kester "331" Organic Flux is a water soluble formula for use in flux-cored solder wire. The flux is more heat stable than most organic fluxes, resulting in minimal smoke and odor. The residue can be completely removed with a simple water rinse. Kester "331" is classified as ORH1 per J-STD-004.

Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>Sn96.5Ag3.0Cu0.5, 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder, 3.3% Flux, .062" (1.57mm) dia.....	KE1130-ND	51.65	46.49	41.32
18 Gauge Solder, 3.3% Flux, .050" (1.27mm) dia.....	KE1129-ND	52.40	47.16	41.92
21 Gauge Solder, 3.3% Flux, .031" (.79mm) dia.....	KE1128-ND	56.15	50.54	44.92
23 Gauge Solder, 3.3% Flux, .025" (0.64mm) dia.....	KE1127-ND	57.25	51.53	45.80
25 Gauge Solder, 3.3% Flux, .020" (0.51mm) dia.....	KE1126-ND	67.28	60.55	53.82

## Specialty Solders and Accessories



Description	Digi-Key Part No.	Price Each		
		1	5	10
<b>Solid Wire Solder (No Flux), 1 Lb. (.45 kg) Spool</b>				
16 Gauge Solder 63/37, .062" (1.57mm) dia.....	KE1603-ND	24.63	22.17	19.70
21 Gauge Solder 63/37, .031" (.79mm) dia.....	KE1606-ND	29.13	26.22	23.30
21 Gauge Solder 60/40, .031" (.79mm) dia.....	KE1604-ND	28.50	25.65	22.80
25 Gauge Solder 60/40, .020" (.51mm) dia.....	KE1605-ND	39.63	35.67	31.70
<b>Bar Solder</b>				
Lead Free Sn96.5Ag3.0Cu0.5, 1.6 Lbs. (.73 kg).....	KE1135-ND	79.30	71.37	63.44
Oxide Free Solder (E-Bar), 63/37, 1.66 Lb. (.45 kg).....	KE1600-ND	26.28	23.65	21.02
Oxide Free Solder (E-Bar), 60/40, 1.66 Lb. (.45 kg).....	KE1601-ND	25.35	22.82	20.28
Premium Oxide Free Solder (Ultrapure), 63/37, 1.66 Lbs. (.45 kg).....	KE1602-ND	26.48	23.83	21.18

◆ RoHS Compliant

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