



HSM Wire International, Inc

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Soldering Tips and Methods for Copper Wire

Temp Class	Temp Solderable	Solder Type	Informative Links
MW 80/79/82/83 Polyurethane	390°C / 734°F	Solder Pot set at 800 - 900°F / 423 - 482°C	Soldering of Litz Wire.pdf
MW 77 Solderable Polyester-imide	420* C/ 788°F	Solder Pot set at 800 - 900°F / 423 - 482°C	Soldering of Litz Wire.pdf
MW 35 Polyester	Not Solderable	Easy Clean	Chemical Stripping Information
MW 16 Polyamide-ML	Not Solderable	Easy Clean	Chemical Stripping Information
<p>Use 60/40 Solder Lead unless RoHS comes in effect</p> <p>Cable Diameter Size will determine the amount of solder bath you need.</p> <p>To perform a proper wicking you will need to decide if the cable is small enough for 1.4 5 lb solder pot, or big enough for a 5 lb solder pot.</p>			
<p>****DISCLAIMER****</p> <p>When Soldering, Welding, Hot Staking, Burning, Wire Brushing, Melting, or Processing Magnet Wire, Hazardous fumes or dust may cause irritation to eyes, skin, and/or respiratory system.</p> <p>Wear proper protective eye, skin, and breathing equipment, use adequate ventilation and avoid breathing the fumes.</p>			
<p>All information supplied is to be used as a guideline only. HSM Wire accepts no responsibility in any harm that may result to your Litz wire or any other part of the operation.</p>			