

## KESTER K100LD Info & part numbers

- Solder -

Melting Temperature: ~227°C/441°F

### Solder Wires for Lead-Free Assembly

Formula	275	48	331
	No-Clean	Activated Rosin	Water-Soluble
Halide Percentage	<0.05%	1.0%	1.25%
Flux Content Availability	See Below	66 core (3.3%)	66 core (3.3%)
Compliant Specifications	Telcordia Issue 1 GR-78-CORE 7 IPC/J-STD-004 Flux Designator ROL0	IPC/J-STD-004 Flux Designator ROM1	IPC/J-STD-004 Flux designator ORH1

#### "275" No-Clean Core 1 lb. with K100LD

Part #	Alloy	Diameter	Core Size
24-9574-7609	K100LD	.015	66
24-9574-7610	K100LD	.020	66
24-9574-7619	K100LD	.025	66
24-9574-7618	K100LD	.031	66
24-9574-7613	K100LD	.050	66
24-9574-7615	K100LD	.062	66

#### "48" Activated Rosin 1 lb. with K100LD

Part #	Alloy	Diameter	Core Size
24-9574-1401	K100LD	.020	66
24-9574-1406	K100LD	.025	66
24-9574-1402	K100LD	.031	66
24-9574-1404	K100LD	.050	66
24-9574-1400	K100LD	.062	66

#### "331" Water-Soluble Core 1 lb. with K100LD

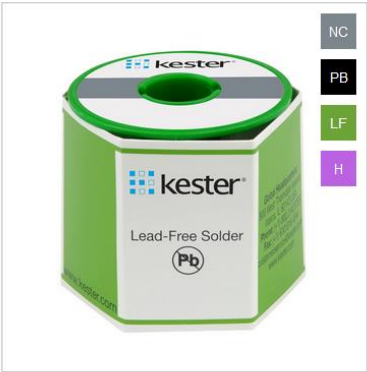
Part #	Alloy	Diameter	Core Size
24-9574-6401	K100LD	.020	66
24-9574-6417	K100LD	.025	66
24-9574-6403	K100LD	.031	66
24-9574-6409	K100LD	.050	66
24-9574-6411	K100LD	.062	66

275 Link: <https://www.kester.com/products/product/275-flux-cored-wire>

331 Link: <https://www.kester.com/products/product/331-flux-cored-wire>

48 Link: <https://www.kester.com/products/product/48-flux-cored-wire>

Solid Wire Link: <https://www.kester.com/products/product/solid-wire>



## 275 Flux-Cored Wire

Kester 275 No-Clean Flux for cored solder wire was developed to provide superior wetting performance for hand soldering in the electronics industry. The chemistry is based on some of the same principles that have been safely used for years in mildly activated rosin fluxes. The use of 275 No-Clean Flux results in an extremely clear post-soldering residue without cleaning. The unique chemistry in 275 was also designed to reduce spattering common to most core fluxes. 275 can be used for both lead-free and leaded soldering. 275 is classified as ROL0 per J-STD-004.

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Alloy	Flux	Diameter (in)	Diameter (mm)	Core	Flux %	Lead Content	Halogen Content	Description	Part #	Type
K100LD	275	0.015	0.40	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .015 1 LB SPL	2495747609	No-Clean
K100LD	275	0.020	0.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .020 1 LB SPL	2495747610	No-Clean
K100LD	275	0.050	1.27	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .050 1 LB SPL	2495747613	No-Clean
K100LD	275	0.062	1.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .062 1 LB SPL	2495747615	No-Clean
K100LD	275	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .031 1 LB SPL	2495747618	No-Clean
K100LD	275	0.025	0.60	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .025 1 LB SPL	2495747619	No-Clean
K100LD	275	0.010	0.25	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .010 1 LB SPL	2495747631	No-Clean
K100LD	275	0.093	2.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 .093 4 LB SPL	2595747634	No-Clean
K100LD	275	0.040	1.00	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 0.04 500 GRAM SPL	9295747611	No-Clean
K100LD	275	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 0.031 500 GRAM SPL	9295747618	No-Clean
K100LD	275	0.025	0.60	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 0.025 500 GRAM SPL	9295747619	No-Clean
K100LD	275	0.047	1.20	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/275 0.047 500 GRAM SPL	9295747650	No-Clean
K100LD	275	0.062	1.6	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/66/275 .062/1.5mm 1LB Spl	40501043	No-Clean
K100LD	275	0.025	0.6	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/66/275 .062/1.5mm 1LB Spl	40501049	No-Clean



## 331 Flux-Cored Wire

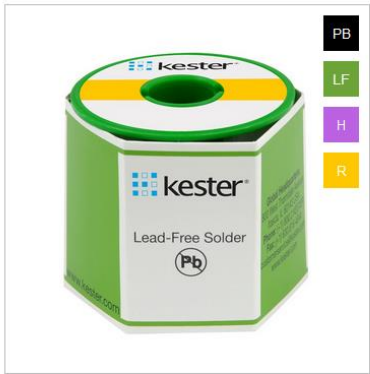
Kester 331 Organic Flux is a water-soluble formula for use in flux-cored solder wire. This cored solder version of the popular 2331-ZX Neutral Organic Water Soluble Liquid Flux is more effective than rosin fluxes in soldering difficult metals. The same fast action and mild properties are exhibited with 331 Organic Flux as with the liquid 2331-ZX. 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 heated water rinse. Deionized water is suggested to prevent introduction of chemistries from unknown water sources. 331 is classified as ORH1 per J-STD-004.

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Alloy	Flux	Diameter (in)	Diameter (mm)	Core	Flux %	Lead Content	Halogen Content	Description	Part #	Type
K100LD	331	0.020	0.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .020 1 LB SPL	2495746401	Water-Soluble
K100LD	331	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .031 1 LB SPL	2495746403	Water-Soluble
K100LD	331	0.062	1.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .062 1 LB SPL	2495746411	Water-Soluble
K100LD	331	0.025	0.60	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .025 1 LB SPL	2495746417	Water-Soluble
K100LD	331	0.015	0.40	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/331 .015 1 LB SPL	2495746422	Water-Soluble



## 48 Flux-Cored Wire

Kester 48 Activated Rosin Flux for cored solder wire was developed for lead-free applications to enable soldering of most common metals. 48 has performance characteristics far exceeding standard RA fluxes. 48 builds on the performance of its predecessor Kester 44 with "instant-action" wetting to provide fast and reliable solder joints. 48 is classified as ROM1 per J-STD-004.

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Alloy	Flux	Diameter (in)	Diameter (mm)	Core	Flux %	Lead Content	Halogen Content	Description	Part #	Type
K100LD	48	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	48 3.3% K100LD 0.8mm 1lb Spl	40501020	Rosin
K100LD	48	0.062	1.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 .062 1 LB SPL	2495741400	Rosin
K100LD	48	0.020	0.50	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 .020 1 LB SPL	2495741401	Rosin
K100LD	48	0.031	0.80	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 .031 1 LB SPL	2495741402	Rosin
K100LD	48	0.050	1.27	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 .050 1 LB SPL	2495741404	Rosin
K100LD	48	0.025	0.60	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 .025 1 LB SPL	2495741406	Rosin
K100LD	48	0.015	0.40	66	3.3%	Lead-Free	Contains Halogen	K100LD 3.3%/48 0.015 1 LB SPL	2495741407	Rosin



## Solid Wire

For soldering applications that require maximum reliability of solder joints, especially for surface mounted components, through hole and final assembly, only solder of the highest purity is acceptable. Kester does not make any vague claims of understanding solder purity. Only the highest quality metals are used to make Kester Solder Wire. Complete analysis of Kester Solder Wire prove that every batch conforms to the strictest quality controls in the solder industry.

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Alloy	Flux	Diameter (in)	Diameter (mm)	Flux %	Lead Content	Halogen Content	Description	Part #	Type
K100LD	Solid	0.08	2.03	Solid	Lead-Free	Halogen-Free	K100LD SLD .079 (2.00 mm) 20 LB SPL	40501050	Solid
K100LD	Solid	0.079	2.00	Solid	Lead-Free	Halogen-Free	K100LD SLD .079 5 LB SPL	1695740079	Solid
K100LD	Solid	0.079	2.00	Solid	Lead-Free	Halogen-Free	K100LD SLD .079 20 LB SPL	1895740079	Solid