

Wave Flux Guide



Flux	IPN	Classification		pH	Specific Gravity (@ 25°C)	Solids Content	Halide	Halogen Content	Rosin/Rosin	Acid Value	Tin/Lead Pb-Free	Cleaning	Thinner	Application	Shelf Life
		004A	004B												
Alcohol-Based No-Clean															
Low-Rosin/Rosin-Free															
WF-9942	FLUXWV-84376	ORLO		4.0	0.828	4.37	No		No	36.0	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
WF-9958	FLUXWV-84603		ORM0	4.2	0.798	4.99	No	<50ppm	No	28.5	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
NR-10D	FLUXWV-84307	ORLO		4.8	0.791	1.38	No		No	12.0	SnPb	Aqueous/Saponifier	16-3000	Spray	2 Years
3592	FLUXWV-84255	ORLO		4.0	0.820	2.64	No		No	22.0	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
3590-T	FLUXWV-84254	ORLO		3.2	0.803	1.85	No		No	16.0	SnPb	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
3590-TX	FLUXWV-84253	ORLO		3.2	0.809	2.50	No		No	22.0	SnPb	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
Rosin-Containing															
WF-9940	FLUXWV-84471	ROLO		4.6	0.795	3.63	No		Yes	18.0	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
WF-9945	FLUXWV-84465		ROLO	5.8	0.796	5.77	No	<50ppm	Yes	14.4	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
WF-9946-NP	FLUXWV-84650		ROLO	5.9	0.815	5.22	No	<50ppm	Yes	20.6	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
WF-9948	FLUXWV-84572		ROLO	5.5	0.792	3.27	No	<900ppm	Yes	14.9	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
WF-9955	FLUXWV-84563		ORLO	6.5	0.796	4.71	No	<50ppm	Yes	26.3	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
3541	FLUXWV-84273	ORLO		N/A	0.800	4.31	No		Yes	25.0	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
3545 (FP500)	FLUXWV-84293	ROLO	ROLO	6.0	0.812	11.25	No	<50ppm	Yes	29.5	Both	Aqueous/Saponifier	16-3000	Foam/Spray	3 Years
3577-TF	FLUXWV-84318	ORLO		7.0	0.797	4.00	No		Yes	17.0	Both	Aqueous/Saponifier	16-3000	Foam/Spray	2 Years
VOC-Free (Water-Based)															
WF-7742	FLUXWV-84375	ORLO		3.2	1.014	5.76	No		No	36.0	Both	DI (120–140°F)	DI	Spray	18 Months
WF-7745	FLUXWV-84514	ORLO		2.8	1.013	4.22	No		No	39.5	Both	DI (120–140°F)	DI	Spray	3 Years
1072	FLUXWV-84342	ORLO		7.0	1.018	6.62	No		Yes	25.0	Both	Aqueous/Saponifier	16-1072	Spray	2 Years
1075	FLUXWV-84257	ORLO		2.8	1.008	1.91	No		No	20.0	SnPb	DI (120–140°F)	DI	Spray	18 Months
1075-2	FLUXWV-84309	ORLO		2.6	1.015	3.80	No		No	40.0	Both	DI (120–140°F)	DI	Spray	18 Months
1075-EX	FLUXWV-84248	ORLO		2.8	1.011	2.40	No		No	20.0	Both	DI (120–140°F)	DI	Spray	18 Months
1075-EX 30	FLUXWV-84249	ORLO		2.8	1.014	2.70	No		No	30.0	Both	DI (120–140°F)	DI	Spray	18 Months
1075-EXR 30	FLUXWV-84263	ORLO		2.8	1.015	3.71	No		Yes	30.0	Both	DI (120–140°F)	DI	Spray	18 Months
1075-EXR 40	FLUXWV-84289	ORLO		2.8	1.021	6.23	No		Yes	40.0	Both	DI (120–140°F)	DI	Spray	18 Months
1075-EXR 44	FLUXWV-84294	ORLO		2.8	1.021	6.23	No		Yes	40.0	Both	DI (120–140°F)	DI	Spray	18 Months
1076-30	FLUXWV-84250	ORLO		2.8	1.014	2.85	No		No	30.0	Both	DI (120–140°F)	DI	Spray	18 Months
Water-Soluble (Alcohol-Based, Except 1010)															
1081	FLUXWV-84301	ORH0		5.0	0.957	28.44	No	<50ppm	No	Not Tested	Both	DI (120–140°F)	16-1081	Foam/Spray	2 Years
1081-T	FLUXWV-84333	ORH0		5.0	0.908	12.57	No	<50ppm	No	Not Tested	Both	DI (120–140°F)	16-1081T	Foam/Spray	2 Years
1082	FLUXWV-84658		ORH0	7.0	0.920	14.46	No	<50ppm	No	Not Tested	Both	DI (120–140°F)	16-1080T	Foam/Spray	2 Years
1085	FLUXWV-84287	ORH0		4.0	0.862	12.36	No	<50ppm	No	Not Tested	Both	DI (120–140°F)	16-1085	Foam/Spray	2 Years
1095NF	FLUXWV-84252	ORH1		6.5	0.839	19.52	Yes	<4.50%	No	34.0	Both	DI (120–140°F)	16-1000	Foam/Spray	3 Years
1010	FLUXWV-84372	ORH1		<2.0	1.055	20.96	Yes	~4.50%	No	130.0	Both	DI (120–140°F)	DI	Spray	2 Years
WF-1098	FLUXWV-84645		ORM1	6.83	0.889	10.33	Yes	>0.5%	No	14.9	Both	DI (120–140°F)	WF-1090-T	Foam/Spray	2 Years

For more Wave Flux information, visit the [CMD Wave Flux Materials Home Page](#)

 = Primary Formulas
 = Price Increase

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Wave Flux Guide – Cross Reference Table



INDIUM CORPORATION				ALPHA				KESTER				AIM			
Rosin-Containing, Alcohol-Based, No-Clean															
Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %
WF-9940	ROLO		3.63	EF6850HF	ROLO		4.00								
				EF6103	ROMO		3.80								
				RF800	ROLO		4.10	985M	ROLO		3.60				
WF-9948		ROLO	3.27												
WF-9945		ROLO	5.57	EF6808HF		ROLO	4.00	NF372-TB		ROLO	3.90				
Rosin-Free/Low-Rosin															
Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %
WF-9955 WF-9958		ORLO ORMO	4.71 4.99					959T	ORLO		2.90				
				EF8800HF		ORLO	6.00	920CXF	ORLO		4.50			NC263UR	
WF-9942	ORLO		4.37	EF6000	ORLO		2.20								
				EF6100	ORLO		3.80						NC265		ORLO
3592	ORLO		2.64	SLS-65C	ORLO		2.20					NC265LR		ORLO	1.94
3590-T	ORLO		1.85	NR205	ORLO		2.15	951	ORLO		2.00				
VOC-Free, No-Clean															
Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %
WF-7742	ORLO		5.76					979	ORLO		4.50				
								977	ORLO		3.25				
				NR330	ORLO	Bellcore	4.00	979VT	ORLO		5.00	NC277		ORLO	5.86
WF-7745	ORLO		4.22	EF2210	ORLO	Bellcore	Unknown	NF-1060VF	ORMO		5.00	NC275LR	ORLO	1.35	
1072	ORLO		5.00	EF3001	ORLO		4.20								
				EF3215	ORLO		6.20								
Water-Wash															
Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %
1095-NF	ORH1		19.50	WS856	ORH1		15.00	2331-ZX	ORH1		33.00	WS715M	ORH1		11.96
				WS857	ORH1		18.00	2235	ORH1		11.00	WS735	ORH1		23.10
1081-T	ORH0		12.57					2120	ORH0		5.00	WS716	ORH0		16.79
1085	ORH0		12.36												
1010	ORH1		20.00	WS375	ORH1		19.50								
				WS3355VF	ORH1		22.40	2220-VF	ORH1		7.00	WS730	ORH1		28.20
Rosin MIL															
Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %	Formula	004/004A	004B	Solids %
2036	"R"	ROLO	36.42												
2212	"RMA"	ROL1	25.00	615-25	RMA	ROLO	25.00					RMA202-25	RMA	ROLO	25.00
2212-35	"RMA"	ROL1	35.00					186	RMA		35.00				
784	"RA"	RLM1	15.00												
14	"RA"	ROM1	50.00					1544	RA		50.00	RA301	RA	ROM1	35.00

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Wave Flux Guide – Non-Standard Fluxes



Flux	IPN	Classification		pH	Specific Gravity (@ 25°C)	Solids Content	Halide	Halogen Content	Rosin/Resin	Acid Value	Tin/Lead Pb-Free	Cleaning	Thinner	Application	Shelf Life	Used For
		004A	004B													
Non-Standard Fluxes																
14	FLUXWV-84320	ROM1		4.0	0.91	50.0%	Yes		Yes				16-1000	Wave, Dip		Ideal for soldering difficult-to-solder metals.
343	FLUXWV-84328		ROL0	4.2	0.889	40.0%			Yes					Foaming, Dipping, Dispensing, Brushing	2 Years	Designed to meet current no-clean and historic MIL-F-14256 specifications. This flux does not contain any activator additives for improving fluxing action.
710	FLUXWV-84321	ROM1	ROM1	4.8		12.0%				25						Activated rosin for excellent wetting power. Lower solids for reduced solder skips on bottom-side SMT components.
784	FLUXWV-84371	ROH1		4.0		15.0%	Yes		Yes				16-784		2 Years	Specially formulated activated rosin flux exhibiting excellent wetting power.
2205	FLUXWV-84435	ROL1		3.2	0.843	26.4%	Yes		Yes	39			16-1000		2 Years	Can be used to test solderability according to IPC J-STD-003 and IPC J-STD-002. Meets J-STD-003/002 specifications for Flux Type 1.
2206	FLUXWV-84587	ROL1		3.2	0.843	26.5%	Yes		Yes	39			16-1000	Wave, Dip		Can be used to test solderability according to IPC J-STD-003 and IPC J-STD-002. Meets J-STD-003/002 specifications for Flux Type 2.
2212	FLUXWV-84322	ROL1			0.859	25.0%	Yes		Yes	38			16-2212		3 Years	These fluxes are particularly effective for soldering large and thick circuit boards or for selective soldering operations where long heat profiles are required.
2212-15	FLUXWV-84437	ROL1			0.827	15.0%	Yes		Yes	24			16-2212		2 Years	
2212-35	FLUXWV-84415	ROL1			0.885	35.0%	Yes		Yes	50			16-2212		2 Years	
3559	FLUXWV-84323	ROL0	N/A			12.3%				38.5					2 Years	Formulated for high reliability. Reduced solids leaves lower residue on assembly and less machine maintenance.
115 Anti-Foam	FLUXWV-84343	N/A	N/A			N/A				N/A					2 Years	Effective defoamer formulated for use with electronics assemblies.
25 Biocleaner	FLUXWV-84316	N/A	N/A												3 Years	Used in aqueous cleaning systems as a saponifier for removal of rosin flux residue.
3592-35	FLUXWV-84297	ORL0	N/A			4.4%				36					2 Years	ORL0 no-clean effective for use on all surface finishes. Leaves the assembly with low levels of residue that do not interfere with ICT testing.
42-SS	FLUXWV-84380	INH1			1.52	57.0%									3 Years	Stainless steel and difficult-to-solder metals.

For more Wave Flux information, visit the [CMD Wave Flux Materials Home Page](#)