

**HM Wire International, Inc.**  
 Ph: 330-244-8501 Fax: 330-244-8561  
[www.litz-wire.com](http://www.litz-wire.com) [info@litz-wire.com](mailto:info@litz-wire.com) [www.hmwire.com](http://www.hmwire.com)

## 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	<a href="#">Soldering of Litz Wire.pdf</a>
MW 77 Solderable Polyester-imide	420°C / 788°F	Solder Pot set at 800 - 900°F / 423 - 482°C	<a href="#">Soldering of Litz Wire.pdf</a>
MW 35 Polyester	Not Solderable	Easy Clean	<a href="#">Chemical Stripping Information</a>
MW 16 Polyamide-ML	Not Solderable	Easy Clean	<a href="#">Chemical Stripping Information</a>
<p><b>Use 60/40 Solder Lead unless RoHS comes in effect</b></p> <p><b>Cable Diameter Size will determine the amount of solder bath you need.</b></p> <p><b>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.</b></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. HM Wire accepts no responsibility in any harm that may result to your Litz wire or any other part of the operation.</p>			