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**Subject: MY-All, Models All, Handling Lead-Free Filling Solder**

For several years body solder with lead has been banned from use.

### **Handling Unleaded Body Solder**

With the narrower temperature window of unleaded body solder, the possible applications compared to leaded body solder are limited. The use of unleaded body solder is suitable for approved repair methods, such as, the filling of transitions or seams in the case of welded-in or MIG soldered parts.

The time required for operations involving unleaded body solder is already taken into consideration in the respective operation items.

**Note:** The use of unleaded body solder is also intended for the repair of edges and the boundaries of components. Unleaded body solder is always suitable for large-scale filling to repair components. Component surfaces must be repaired properly by planishing and straightening. Any remaining surface irregularities must be smoothed out using approved spackle materials in accordance with the processing instructions from the supplier.

### **Approved Spackle Materials**

See latest version of **S-B-98.00/31** for instruction on Cleaning Tin-Plated Surfaces; latest version of **P-B-60.00/17** for Soldering Material for MIG soldering; and either the aftersales portal or latest version of **S-B-98.00/13** for Approved Refinishing Products.

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