

ISO 12224-1:2024-05 (E)

Solder wire, solid and flux-cored - Specification and test methods - Part 1: Classification and performance requirements

Contents		Page
Foreword		iv
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Classification and designation	1
4.1	Solder alloy designation	1
4.2	Flux classification	2
4.3	Designation of flux-cored solder wire	2
5	Requirements	2
5.1	Solder alloy composition of solid and flux-cored solder wire	2
5.2	Flux composition of flux-cored solder wire	2
5.3	Flux content	2
5.4	Dimensions and tolerances	3
5.5	Copper corrosion test	3
5.6	Influence of flux vapours on insulation resistance (applicable only to flux-cored solder wires containing type 1 and type 22 fluxes)	4
6	Sampling	4
6.1	Sampling for chemical analysis of the solder	4
6.2	Sampling for tests to determine the properties of the flux core (i.e. tests as described in the ISO 9455 series)	4
6.3	Sampling for tests to determine the flux content and the diameter of the flux-cored solder wire	4
7	Marking, labelling and packaging	4
Annex A (normative) Method for the solvent extraction of the flux from flux-cored solder wire		6
Annex B (normative) Measurement of mean diameter of wire		9
Annex C (informative) Guidance on the use of test methods		10
Bibliography		11