DIN EN ISO 12224-1:2024-09 (E)

Solder wire, solid and flux-cored - Specification and test methods - Part 1: Classification and performance requirements (ISO 12224-1:2024)

Contents

Page

European foreword ... **3**

Foreword ... **4**

1 Scope ... **5**

2 Normative references ... **5**

3 Terms and definitions ... **5**

4 Classification and designation ... **5**
4.1 Solder alloy designation ... 5
4.2 Flux classification ... 6
4.3 Designation of flux-cored solder wire ... 6

5 Requirements ... **6**
5.1 Solder alloy composition of solid and flux-cored solder wire ... 6
5.2 Flux composition of flux-cored solder wire ... 6
5.3 Flux content ... 6
5.4 Dimensions and tolerances ... 7
5.5 Copper corrosion test ... 7
5.6 Influence of flux vapours on insulation resistance (applicable only to flux-cored solder wires containing type 1 and type 22 fluxes) ... 8

6 Sampling ... **8**
6.1 Sampling for chemical analysis of the solder ... 8
6.2 Sampling for tests to determine the properties of the flux core (i.e. tests as described in the ISO 9455 series) ... 8
6.3 Sampling for tests to determine the flux content and the diameter of the flux-cored solder wire ... 8

7 Marking, labelling and packaging ... **8**

Annex A (normative) **Method for the solvent extraction of the flux from flux-cored solder wire** ... **9**

Annex B (normative) **Measurement of mean diameter of wire** ... **12**

Annex C (informative) **Guidance on the use of test methods** ... **13**

Bibliography ... **14**