International Standard

ISO 12224-2

Solder wire, solid and flux-cored — Specification and test methods —

Part 2: Determination of flux content

Fils d'apport de brasage tendre, pleins et à flux incorporé — Spécifications et méthodes d'essai —

Partie 2: Détermination de la teneur en flux

Second edition
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Foreword

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This document was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 12, *Soldering materials*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 121, *Welding and allied processes*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 12224-2:1997), which has been technically revised.

The main changes are as follows:

— 5.2: quartz glass crucible added;

— 5.6: Bunsen burner with tripod added;

— 7.4: method C with Bunsen burner added.

A list of all parts in the ISO 12224 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html. Official interpretations of ISO/TC 44 documents, where they exist, are available from this page: https://committee.iso.org/sites/tc44/home/interpretation.html.

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Solder wire, solid and flux-cored — Specification and test methods —

Part 2: Determination of flux content

1 Scope

This document specifies two methods for the determination of the flux content of a sample flux-cored solder wire.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 9453, *Soft solder alloys — Chemical compositions and forms*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

4 Principle

A known mass of the sample of flux-cored solder wire is melted, separated from the flux medium and weighed. The flux content is calculated and expressed as a percentage by mass of the original wire.

5 Apparatus

The usual laboratory apparatus and, in particular, the following shall be used.

5.1 Balance, having a measurement uncertainty of ±0,001 g.

5.2 Porcelain or quartz glass crucible, capacity 30 ml.

5.3 Scraper, stainless steel.

5.4 Crucible tongs.

5.5 Solder bath, containing solder according to ISO 9453 maintained at a temperature of (50 ± 5) °C above the liquidus temperature of the wire under test.

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