



IEC 60068-2-83

Edition 2.0 2025-05
REDLINE VERSION

INTERNATIONAL STANDARD

**Environmental testing –
Part 2-83: Tests – Test Tf: Solderability testing of electronic components for
surface mounting devices (SMD) by the wetting balance method using solder
paste**

CONTENTS

FOREWORD.....	5
INTRODUCTION.....	5
1 Scope.....	9
2 Normative references	9
3 Terms and definitions	10
4 Test.....	10
4.1 General description.....	10
4.2 Test methods	10
5 Preconditioning.....	11
6 Preparation.....	11
6.1 Solder paste	11
6.2 Test jig plate	12
6.3 Specimen holder	12
7 Quick heating method.....	12
7.1 Equipment	12
7.2 Test jig plate	14
7.3 Preparation	16
7.4 Test condition	16
7.4.1 Test temperature	16
7.4.2 Feed of solder paste and immersion condition	18
7.4.3 Immersion and withdrawal conditions for test specimen	19
7.5 Test procedure.....	19
7.6 Presentation of the result	20
7.7 Characterisation parameter examples	22
8 Synchronous method.....	22
8.1 Equipment	22
8.2 Test jig plate	24
8.3 Synchronous fixture	25
8.4 Preparation	25
8.5 Test condition	25
8.5.1 Test temperature	25
8.5.2 Feed of solder paste and immersion condition	25
8.5.3 Immersion and withdrawal conditions for the test specimen	25
8.6 Test procedure.....	25
8.7 Presentation of the results	26
8.8 Characterisation parameter examples	28
9 Temperature profile method.....	29
9.1 Equipment	29
9.2 Test jig plate	30
9.3 Preparation	31
9.4 Test condition	31
9.4.1 Test temperature	31
9.4.2 Feed of solder paste and immersion condition	32
9.4.3 Immersion and withdrawal conditions for test specimen	33
9.5 Test procedure.....	33
9.6 Presentation of the result	34

- 9.7 Characterization parameter examples 35
- Annex A (normative) Equipment for the quick heating and synchronous method 36
 - A.1 General..... 36
 - A.2 Test equipment 36
 - A.2.1 General 36
 - A.2.2 Measuring system..... 36
 - A.2.3 Heating system..... 36
 - A.2.4 Lift system 37
- Annex B (informative) Reading of the output data and correction of the result in the quick heating test..... 38
 - B.1 General..... 38
 - B.2 Reading of the output form in the quick heating test..... 38
 - B.3 Correction to the typical data attained by the quick heating method 39
- Annex C (normative) Test equipment for the temperature profile method 41
 - C.1 General..... 41
 - C.2 Test equipment 41
 - C.2.1 General 41
 - C.2.2 Measuring system..... 41
 - C.2.3 Heating system..... 41
 - C.2.4 Lift system 41
- Annex D (informative) Reading of the output data and correction of the result in the temperature profile test..... 42
 - D.1 General..... 42
 - D.2 Reading of the output form in the temperature profile test 42
 - D.3 Correction to the typical data attained by the temperature profile method 43
- Annex E (informative) Caveats and notes 45
 - E.1 General..... 45
 - E.2 Influences 45
 - E.2.1 Solder paste 45
 - E.2.2 Components 45
 - E.3 Interpreting results – Examples..... 45
 - E.3.1 Quick heating method 45
 - E.3.2 Synchronous method 46
 - E.3.3 Temperature profile method..... 47
- Bibliography..... 49

- Figure 1 – Example of quick heating method test equipment..... 13
- Figure 2 – Example of test jig plate for quick heating and synchronous method 16
- Figure 3 – Example of temperature profile 18
- Figure 4 – Example of application of solder paste to a test jig plate 19
- Figure 5 – Typical output shape of signal in the quick heating method 22
- Figure 6 – Example of synchronous method test equipment..... 24
- Figure 7 – Example of synchronous fixture..... 25
- Figure 8 – Typical output shape of signal in the synchronous method 28
- Figure 9 – Example of system for temperature profile method test equipment 30
- Figure 10 – Example of temperature profile..... 32
- Figure 11 – Example of applying solder paste to a test jig plate 33

Figure 12 – Typical output shape of signal in the temperature profile method	35
Figure B.1 – Typical wetting force changes in quick heating method	39
Figure B.2 – Example of correction of the initial time of wetting (F_a is larger than $0,5 F_{1,max}$)	40
Figure B.3 – Example of correction of the initial time of wetting (F_a is $0,5 F_{1,max}$ or less)	40
Figure D.1 – Typical output forms for profile the temperature profile test.....	43
Figure D.2 – The case when an Extruding force ($1,1 F_{max}$ or larger) is being generated immediately after the beginning of wetting	44
Figure E.1 – Explanation diagram of test procedure for the quick heating method	46
Figure E.2 – Explanation diagram of test procedure for synchronous method.....	46
Figure E.3 – Showing the Wetting force (pull) of some solder pastes	47
Figure E.4 – Explanation diagram of the test procedure for the temperature profile method	48
Table 1 – Specification of the test jig plate for quick heating and synchronous method	14
Table 2 – Recommended test conditions of the quick heating and synchronous method for rectangular SMD	19
Table 3 – Specification of the test jig plate of the temperature profile method	31
Table 4 – Recommended test conditions of the temperature profile method for rectangular SMD	33

INTERNATIONAL ELECTROTECHNICAL COMMISSION

ENVIRONMENTAL TESTING –

Part 2-83: Tests – Test Tf: Solderability testing of electronic components for surface mounting devices (SMD) by the wetting balance method using solder paste

FOREWORD

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This redline version of the official IEC Standard allows the user to identify the changes made to the previous edition IEC 60068-2-83:2011. A vertical bar appears in the margin wherever a change has been made. Additions are in green text, deletions are in strikethrough red text.

IEC 60068-2-83 has been prepared by IEC technical committee 91: Electronics assembly technology. It is an International Standard.

This second edition cancels and replaces the first edition published in 2011. This edition constitutes a technical revision.

This edition includes the following significant technical change with respect to the previous edition:

a) Revise Clause 5 to align with that in IEC 60068-2-20:2021.

The text of this International Standard is based on the following documents:

Draft	Report on voting
91/2026/FDIS	91/2037/RVD

Full information on the voting for its approval can be found in the report on voting indicated in the above table.

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at www.iec.ch/members_experts/refdocs. The main document types developed by IEC are described in greater detail at www.iec.ch/publications.

A list of all parts in the IEC 60068 series, published under the general title *Environmental testing*, can be found on the IEC website.

The committee has decided that the contents of this document will remain unchanged until the stability date indicated on the IEC website under webstore.iec.ch in the data related to the specific document. At this date, the document will be

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- withdrawn, or
- revised.

INTRODUCTION

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~~The holders of the patent rights have assured the IEC that they are willing to negotiate licences either free of charge or under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holders of these patent rights are registered with IEC. Information may be obtained as indicated below.~~

~~a) EU patent 0920488.4 “Synchronous test method for assessing soldering pastes”⁴~~

~~Gen3 Systems LTD~~

~~Unit B2~~

~~Armstrong Mall~~

~~Farnborough GU14 0NR~~

~~United Kingdom~~

~~b) JP Patent 2630712 “Testing method of characteristics of solder paste and the equipment for the test”~~

~~Malcom Co., Ltd~~

~~4-15-10 Honmachi, Shibuya-ku~~

~~Tokyo, 151-0071~~

~~Japan~~

~~c) Patent JP 3789041 “Solderability measuring apparatus”~~

~~Patent JP 3552061 “Solderability tester and solderability test method”~~

~~Patent JP 3498100 “Method and device for testing solderability and microcrucible for testing”~~

~~Patent JP 3153884 “Measuring device for soldering performance of cream solder”~~

~~Tarutin Kester Co., Ltd.~~

~~2-20-11 Yokokawa,~~

~~Sumida-ku~~

~~Tokyo, 130-0003~~

~~Japan~~

~~d) Sony Corporation~~

~~1-7-1 Konan Minato-ku~~

~~Tokyo 108-0075~~

~~Japan~~

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⁴~~Status of patent: Pending.~~

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ENVIRONMENTAL TESTING –

Part 2-83: Tests – Test Tf: Solderability testing of electronic components for surface mounting devices (SMD) by the wetting balance method using solder paste

1 Scope

This part of IEC 60068 provides methods for comparative investigation of the wettability of the metallic terminations or metallized terminations of SMDs with solder paste.

Data obtained by these methods are not intended to be used as absolute quantitative data for pass/fail purposes.

NOTE Different solderability test methods for SMD are described in IEC 60068-2-58 and IEC 60068-2-69. IEC 60068-2-58 ~~prescribes~~ specifies visual evaluation using solder bath and reflow method, IEC 60068-2-69 ~~prescribes~~ specifies wetting balance evaluation using solder bath and solder globule method.

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.

IEC 60068-1, *Environmental testing – Part 1: General and guidance*

IEC 60068-2-20:2008/2021, *Environmental testing – Part 2-20: Tests – Test ~~T~~ Ta and Tb: Test methods for solderability and resistance to soldering heat of devices with leads*

IEC 60068-2-58, *Environmental testing – Part 2-58: Tests – Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)*

~~IEC 60194, *Printed board design, manufacture and assembly – Terms and definitions*~~

IEC 60194-2, *Printed boards design, manufacture and assembly – Vocabulary – Part 2: Common usage in electronic technologies as well as printed board and electronic assembly technologies*

IEC 61190-1-3, *Attachment materials for electronic assembly – Part 1-3: Requirements for electronic grade solder alloys and fluxed and non-fluxed solid solder for electronic soldering applications*

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Environmental testing –
Part 2-83: Tests – Test Tf: Solderability testing of electronic components for
surface mounting devices (SMD) by the wetting balance method using solder
paste**

**Essais d'environnement –
Partie 2-83: Essais – Essai Tf: Essai de brasabilité des composants
électroniques pour les composants montés en surface (CMS) par la méthode de
la balance de mouillage utilisant de la pâte à braser**

CONTENTS

FOREWORD.....	5
1 Scope.....	7
2 Normative references	7
3 Terms and definitions	7
4 Test.....	8
4.1 General description.....	8
4.2 Test methods	8
5 Preconditioning.....	9
6 Preparation.....	9
6.1 Solder paste	9
6.2 Test jig plate	9
6.3 Specimen holder	9
7 Quick heating method.....	9
7.1 Equipment	9
7.2 Test jig plate	10
7.3 Preparation	11
7.4 Test condition	12
7.4.1 Test temperature	12
7.4.2 Feed of solder paste and immersion condition	12
7.4.3 Immersion and withdrawal conditions for test specimen	13
7.5 Test procedure.....	13
7.6 Presentation of the result.....	14
7.7 Characterisation parameter examples	15
8 Synchronous method.....	15
8.1 Equipment	15
8.2 Test jig plate	16
8.3 Synchronous fixture	16
8.4 Preparation	17
8.5 Test condition	17
8.5.1 Test temperature	17
8.5.2 Feed of solder paste and immersion condition	17
8.5.3 Immersion and withdrawal conditions for the test specimen	17
8.6 Test procedure.....	17
8.7 Presentation of the results	17
8.8 Characterisation parameter examples	18
9 Temperature profile method.....	19
9.1 Equipment	19
9.2 Test jig plate	19
9.3 Preparation	20
9.4 Test condition	20
9.4.1 Test temperature	20
9.4.2 Feed of solder paste and immersion condition	20
9.4.3 Immersion and withdrawal conditions for test specimen	21
9.5 Test procedure.....	21
9.6 Presentation of the result.....	22
9.7 Characterization parameter examples	23

Annex A (normative) Equipment for the quick heating and synchronous method	24
A.1 General.....	24
A.2 Test equipment	24
A.2.1 General	24
A.2.2 Measuring system.....	24
A.2.3 Heating system.....	24
A.2.4 Lift system	25
Annex B (informative) Reading of the output data and correction of the result in the quick heating test.....	26
B.1 General.....	26
B.2 Reading of the output form in the quick heating test.....	26
B.3 Correction to the typical data attained by the quick heating method	27
Annex C (normative) Test equipment for the temperature profile method	29
C.1 General.....	29
C.2 Test equipment	29
C.2.1 General	29
C.2.2 Measuring system.....	29
C.2.3 Heating system.....	29
C.2.4 Lift system	29
Annex D (informative) Reading of the output data and correction of the result in the temperature profile test.....	30
D.1 General.....	30
D.2 Reading of the output form in the temperature profile test.....	30
D.3 Correction to the typical data attained by the temperature profile method	31
Annex E (informative) Caveats and notes	33
E.1 General.....	33
E.2 Influences	33
E.2.1 Solder paste	33
E.2.2 Components	33
E.3 Interpreting results – Examples.....	33
E.3.1 Quick heating method.....	33
E.3.2 Synchronous method	34
E.3.3 Temperature profile method.....	35
Bibliography.....	37
Figure 1 – Example of quick heating method test equipment.....	10
Figure 2 – Example of test jig plate for quick heating and synchronous method	11
Figure 3 – Example of temperature profile	12
Figure 4 – Example of application of solder paste to a test jig plate	13
Figure 5 – Typical output shape of signal in the quick heating method	14
Figure 6 – Example of synchronous method test equipment.....	16
Figure 7 – Example of synchronous fixture.....	16
Figure 8 – Typical output shape of signal in the synchronous method	18
Figure 9 – Example of system for temperature profile method test equipment	19
Figure 10 – Example of temperature profile.....	20
Figure 11 – Example of applying solder paste to a test jig plate	21
Figure 12 – Typical output shape of signal in the temperature profile method	23

Figure B.1 – Typical wetting force changes in quick heating method 27

Figure B.2 – Example of correction of the initial time of wetting (F_a is larger than $0,5 F_{1,max}$) 28

Figure B.3 – Example of correction of the initial time of wetting (F_a is $0,5 F_{1,max}$ or less) 28

Figure D.1 – Typical output forms for the temperature profile test 31

Figure D.2 – Extruding force ($1,1 F_{max}$ or larger) being generated immediately after the beginning of wetting 32

Figure E.1 – Explanation diagram of test procedure for the quick heating method 34

Figure E.2 – Explanation diagram of test procedure for synchronous method 34

Figure E.3 – Wetting force (pull) of solder pastes 35

Figure E.4 – Explanation diagram of the test procedure for the temperature profile method 36

Table 1 – Specification of the test jig plate for quick heating and synchronous method 10

Table 2 – Recommended test conditions of the quick heating and synchronous method for rectangular SMD 13

Table 3 – Specification of the test jig plate of the temperature profile method 19

Table 4 – Recommended test conditions of the temperature profile method for rectangular SMD 21

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SOMMAIRE

AVANT-PROPOS	41
1 Domaine d'application	43
2 Références normatives	43
3 Termes et définitions	44
4 Essai	44
4.1 Description générale	44
4.2 Méthodes d'essai	44
5 Préconditionnement	45
6 Préparation	45
6.1 Pâte à braser	45
6.2 Plaque du gabarit d'essai	45
6.3 Support de spécimen	46
7 Méthode par chauffage rapide	46
7.1 Équipement	46
7.2 Plaque du gabarit d'essai	47
7.3 Préparation	48
7.4 Conditions d'essai	48
7.4.1 Température d'essai	48
7.4.2 Alimentation de la pâte à braser et conditions d'immersion	49
7.4.3 Conditions d'immersion et de retrait pour le spécimen d'essai	50
7.5 Procédure d'essai	50
7.6 Présentation des résultats	51
7.7 Exemples de paramètres de caractérisation	52
8 Méthode synchrone	53
8.1 Équipement	53
8.2 Plaque du gabarit d'essai	53
8.3 Fixation synchrone	54
8.4 Préparation	54
8.5 Conditions d'essai	54
8.5.1 Température d'essai	54
8.5.2 Alimentation de la pâte à braser et conditions d'immersion	54
8.5.3 Conditions d'immersion et de retrait pour le spécimen d'essai	54
8.6 Procédure d'essai	54
8.7 Présentation des résultats	55
8.8 Exemples de paramètres de caractérisation	56
9 Méthode par profil de température	57
9.1 Équipement	57
9.2 Plaque du gabarit d'essai	57
9.3 Préparation	58
9.4 Conditions d'essai	58
9.4.1 Température d'essai	58
9.4.2 Alimentation de la pâte à braser et conditions d'immersion	58
9.4.3 Conditions d'immersion et de retrait pour le spécimen d'essai	59
9.5 Procédure d'essai	59
9.6 Présentation des résultats	60
9.7 Exemples de paramètres de caractérisation	61

Annexe A (normative) Équipement pour la méthode synchrone et la méthode par chauffage rapide	62
A.1 Généralités	62
A.2 Équipement d'essai.....	62
A.2.1 Généralités	62
A.2.2 Système de mesure	62
A.2.3 Système de chauffage	62
A.2.4 Système de levage	63
Annexe B (informative) Lecture des données de sortie et correction des résultats dans l'essai par chauffage rapide	64
B.1 Généralités	64
B.2 Lecture de la forme de sortie dans l'essai par chauffage rapide	64
B.3 Correction des données typiques obtenues par la méthode par chauffage rapide	65
Annexe C (normative) Équipement d'essai pour la méthode par profil de température	67
C.1 Généralités	67
C.2 Équipement d'essai.....	67
C.2.1 Généralités	67
C.2.2 Système de mesure	67
C.2.3 Système de chauffage	67
C.2.4 Système de levage	67
Annexe D (informative) Lecture des données de sortie et correction des résultats dans l'essai par profil de température.....	68
D.1 Généralités	68
D.2 Lecture de la forme de sortie dans l'essai par profil de température.....	68
D.3 Correction des données typiques obtenues par la méthode par profil de température	69
Annexe E (informative) Notes et mises en garde.....	71
E.1 Généralités	71
E.2 Facteurs influents	71
E.2.1 Pâte à braser.....	71
E.2.2 Composants	71
E.3 Interprétations des résultats – Exemples.....	71
E.3.1 Méthode par chauffage rapide	71
E.3.2 Méthode synchrone	72
E.3.3 Méthode par profil de température	73
Bibliographie.....	75
Figure 1 – Exemple d'équipement d'essai pour la méthode par chauffage rapide	46
Figure 2 – Exemple de la plaque du gabarit d'essai pour la méthode synchrone et la méthode par chauffage rapide	48
Figure 3 – Exemple de profil de température.....	49
Figure 4 – Exemple d'application de pâte à braser à une plaque du gabarit d'essai	50
Figure 5 – Forme de sortie typique d'un signal dans la méthode par chauffage rapide	52
Figure 6 – Exemple d'équipement d'essai pour la méthode synchrone	53
Figure 7 – Exemple de fixation synchrone.....	54
Figure 8 – Forme de sortie typique d'un signal dans la méthode synchrone	56

Figure 9 – Exemple de système pour l'équipement d'essai de la méthode par profil de température	57
Figure 10 – Exemple de profil de température.....	58
Figure 11 – Exemple d'application de pâte à braser à une plaque du gabarit d'essai	60
Figure 12 – Forme de sortie typique d'un signal dans la méthode par profil de température	61
Figure B.1 – Variations typiques de la force de mouillage dans la méthode par chauffage rapide	65
Figure B.2 – Exemple de correction de l'instant initial de mouillage (F_a est supérieure à $0,5 F_{1,max}$)	66
Figure B.3 – Exemple de correction de l'instant initial de mouillage (F_a est inférieure ou égale à $0,5 F_{1,max}$)	66
Figure D.1 – Formes de sortie typiques pour l'essai par profil de température	69
Figure D.2 – Force d'extrusion (supérieure ou égale à $1,1 F_{max}$) générée immédiatement après le début du mouillage	70
Figure E.1 – Schéma explicatif de la procédure d'essai pour la méthode par chauffage rapide	72
Figure E.2 – Schéma explicatif de la procédure d'essai pour la méthode synchrone	72
Figure E.3 – Force de mouillage (traction) des pâtes à braser	73
Figure E.4 – Schéma explicatif de la procédure d'essai pour la méthode par profil de température	74
Tableau 1 – Spécification de la plaque du gabarit d'essai pour la méthode synchrone et la méthode par chauffage rapide	47
Tableau 2 – Conditions d'essai recommandées de la méthode par chauffage rapide et de la méthode synchrone pour des composants montés en surface (CMS) rectangulaires	50
Tableau 3 – Spécification de la plaque du gabarit d'essai pour la méthode par profil de température	57
Tableau 4 – Conditions d'essai recommandées de la méthode par profil de température pour des composants montés en surface (CMS) rectangulaires.....	59

COMMISSION ÉLECTROTECHNIQUE INTERNATIONALE

ESSAIS D'ENVIRONNEMENT –

Partie 2-83: Essais – Essai Tf: Essai de brasabilité des composants électroniques pour les composants montés en surface (CMS) par la méthode de la balance de mouillage utilisant de la pâte à braser

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L'IEC 60068-2-83 a été établie par le comité d'études 91 de l'IEC: Techniques d'assemblage des composants électroniques Il s'agit d'une Norme internationale.

Cette deuxième édition annule et remplace la première édition parue en 2011. Cette édition constitue une révision technique.

Cette édition inclut la modification technique majeure suivante par rapport à l'édition précédente:

a) révision de l'Article 5 pour l'aligner sur celui de l'IEC 60068-2-20:2021.

Le texte de cette Norme internationale est issu des documents suivants:

Projet	Rapport de vote
91/2026/FDIS	91/2037/RVD

Le rapport de vote indiqué dans le tableau ci-dessus donne toute information sur le vote ayant abouti à son approbation.

La langue employée pour l'élaboration de cette Norme internationale est l'anglais.

Ce document a été rédigé selon les Directives ISO/IEC, Partie 2, il a été développé selon les Directives ISO/IEC, Partie 1 et les Directives ISO/IEC, Supplément IEC, disponibles sous www.iec.ch/members_experts/refdocs. Les principaux types de documents développés par l'IEC sont décrits plus en détail sous www.iec.ch/publications.

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ESSAIS D'ENVIRONNEMENT –

Partie 2-83: Essais – Essai Tf: Essai de brasabilité des composants électroniques pour les composants montés en surface (CMS) par la méthode de la balance de mouillage utilisant de la pâte à braser

1 Domaine d'application

La présente partie de l'IEC 60068 fournit des méthodes d'enquêtes comparatives sur la mouillabilité des terminaisons métalliques ou métallisées des composants montés en surface (CMS) avec de la pâte à braser.

Ces méthodes ne servent pas à fournir des données quantitatives absolues utilisées dans le cadre d'acceptations ou de rejets.

NOTE Différentes méthodes d'essai de brasabilité pour composants montés en surface (CMS) sont décrites dans l'IEC 60068-2-58 et dans l'IEC 60068-2-69. L'IEC 60068-2-58 spécifie une évaluation visuelle utilisant un bain de brasage et la méthode de refusion, l'IEC 60068-2-69 spécifie une évaluation par balance de mouillage utilisant la méthode du bain de brasage et des gouttelettes/globules de brasure.

2 Références normatives

Les documents suivants sont cités dans le texte de sorte qu'ils constituent, pour tout ou partie de leur contenu, des exigences du présent document. Pour les références datées, seule l'édition citée s'applique. Pour les références non datées, la dernière édition du document de référence s'applique (y compris les éventuels amendements).

IEC 60068-1, *Essais d'environnement – Partie 1: Généralités et lignes directrices*

IEC 60068-2-20:2021, *Essais d'environnement – Partie 2-20: Essais – Essais Ta et Tb: Méthodes d'essai de la brasabilité et de la résistance à la chaleur de brasage des dispositifs à broches*

IEC 60068-2-58, *Essais d'environnement – Partie 2-58: Essais – Essai Td: Méthodes d'essai de la soudabilité, résistance de la métallisation à la dissolution et résistance à la chaleur de brasage des composants pour montage en surface (CMS)*

IEC 60194-2, *Printed boards design, manufacture and assembly – Vocabulary – Part 2: Common usage in electronic technologies as well as printed board and electronic assembly technologies (disponible en anglais seulement)*

IEC 61190-1-3, *Matériaux de fixation pour les assemblages électroniques – Partie 1-3: Exigences relatives aux alliages à braser de catégorie électronique et brasure solide fluxée et non fluxée pour les applications de brasage électronique*