



# Work Instruction

## IF14 No-Clean Cored Solder

January, 2008

### Soldering with IF14 No-Clean Cored Solder

IF14 No-Clean Cored Wire is available in the following diameter .015", .020", .030", .040" and .062". Select the appropriate diameter for your application, and check for the correct soldering tip according to the heat sinking capacity of the component to be soldered.

Preheat the pad and component lead with the tip of the iron for about one second. Then slowly feed the solder wire to the joint. As soon as the fillet is complete, remove the soldering tip and wire from the joint. The time it takes to perform a reliable solder joint depends on tip size selection, soldering surface and soldering skills of the operator.

### Useful Tips

- ◆ Feed the wire at a 45° angle contacting both the soldering tip and the fillet surface for efficient heat transfer and optimum productivity.
- ◆ Never leave the soldering tip in contact with the joint without the presence of active cored wire. This would degrade the physiochemical nature of the solder joint.
- ◆ Adapt the preheat time according to the heat sink potential of the soldering surface.
- ◆ Ventilation or fume extraction can reduce or eliminate residue created by vapors re-condensing around the solder joint area.
- ◆ Residue-free soldering requires a consistent tip cleaning discipline (keep the cleaning sponge moist and free of oxides and debris at all times.)

### RECOMMENDED AVERAGE TIP TEMPERATURE 700°F - 370°C

### Trouble Shooting

- ◆ **Spattering:** Physical sign that the wire is heated too quick, slow down the feed rate of the solder wire and/or lower the tip temperature.
- ◆ **Dull looking solder joint:** Contact time of the soldering tip with the molten solder too long after removal of the solder wire
- ◆ **Carbon like residues:** Clean Sponge and soldering tip or replace them
- ◆ **Residue around the solder joint:**
  - A. Diameter of the wire too large for the application, use a smaller diameter.
  - B. Excessive or fast feeding of the solder wire, slow down the feeding speed.
  - C. Substantial temperature drop of the solder tip when feeding solder to the tip, check wattage of the soldering iron, replace solder tip or adjust tip size.
  - D. Temperature recovery time of the tip too slow, use soldering iron with higher wattage or increase solder tip temperature.
  - E. Damaged solder tip (loss of conduction heat efficiency), use new solder tip.

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Interflux USA, Inc.  
2914 Ladybird Lane  
Dallas, TX 75220

Tel: 214-350-5565  
Toll Free: 800-843-3589  
Fax: 214-350-9713

[www.interfluxusa.com](http://www.interfluxusa.com)