

BS EN ISO 9455-10:2012



BSI Standards Publication

Soft soldering fluxes — Test methods

Part 10: Flux efficacy test, solder
spread method

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National foreword

This British Standard is the UK implementation of EN ISO 9455-10:2012. It supersedes BS EN ISO 9455-10:2001 which is withdrawn.

The UK participation in its preparation was entrusted by Technical Committee NFE/27, Tin and tin alloys, to Subcommittee NFE/27/4, Solders and soldering fluxes.

BSI, as a member of CEN, is obliged to publish EN ISO 9455-10 as a British Standard. However, attention is drawn to the fact that during the development of this European Standard, the UK voted against its approval as a European Standard.

The UK Technical subcommittee NFE/27/4, Solders and soldering fluxes, submitted a negative vote due to the following:

- The test method uses brass test plates, on which the solder spread is measured. However, note 2 to paragraph 7.1 states that “an alternative is 10 oxidized copper test plates, each of dimensions 40 mm × 40 mm, cut from phosphorus deoxidized sheet, 0,5 mm thick, complying with ISO 197-1,[1] for each flux being tested.” It is thus envisaged that the solder spread can be measured on oxidised copper instead of brass.
- Paragraph 8.1 describes the preparation of the test plates prior to testing the extent of solder spread. This involves, inter alia, dipping the plates into a strong solution comprising sulphuric and nitric acids. As copper oxide reacts with both sulphuric and nitric acids, the effect of this would be to remove any oxidation from the surface, therefore, it would no longer be an oxidised copper plate. The note to paragraph 8.1 states “This preparation method is applicable to both brass and copper test plates”.

There is a lack of clarity as whether testing is permitted to both brass and oxidised test plates, as per clause 8.1, or whether it is confined to brass test plates, as per clause 7.1.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Amendments issued since publication

Date	Text affected
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