SLOVENSKI STANDARD
SIST EN ISO 12224-1:2001

01-februar-2001

Mehke spajke v obliki žice, palice in strženske žice - Specifikacije in preskusne metode - 1. del: Razvrstitev in zahteve (ISO 12224-1:1997)

Solder wire, solid and flux cored - Specification and test methods - Part 1: Classification and performance requirements (ISO 12224-1:1997)

Massive Lotdrähte und flußmittelgefüllte Röhrenlote - Festlegung und Prüfverfahren - Teil 1: Einteilung und Anforderungen (ISO 12224-1:1997)

Fils d'apport de brasage tendre, pleins et à flux incorporé - Spécifications et méthodes d'essai - Partie 1: Classification et exigences de performance (ISO 12224-1:1997)

Ta slovenski standard je istoveten z: **EN ISO 12224-1:1998**

ICS:

25.160.50	Trdo in mehko lotanje	Brazing and soldering

SIST EN ISO 12224-1:2001 **en**

EUROPEAN STANDARD

NORME EUROPÉENNE

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EN ISO 12224-1

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ICS 25.160.20

Descriptors: see ISO document

English version

Solder wire, solid and flux cored - Specification and test methods - Part 1: Classification and performance requirements (ISO 12224-1:1997)

Fils d'apport de brasage tendre, pleins et à flux incorporé - Spécifications et méthodes d'essai - Partie 1: Classification et exigences de performance (ISO 12224-1:1997)

Massive Lotdrähte und flußmittelgefüllte Röhrenlote - Festlegung und Prüfverfahren - Teil 1: Einteilung und Anforderungen (ISO 12224-1:1997)

This European Standard was approved by CEN on 19 June 1998.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

The text of the International Standard from Technical Committee ISO/TC 44 "Welding and allied processes" of the International Organization for Standardization (ISO) has been taken over as an European Standard by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 1999, and conflicting national standards shall be withdrawn at the latest by January 1999.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 12224-1:1997 has been approved by CEN as a European Standard without any modification.

NOTE: Normative references to International Standards are listed in annex ZA (normative).

Annex ZA (normative)
Normative references to international publications with their relevant European publications

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

Publication	Year	Title	EN	Year
ISO 9453	1990	Soft soldering fluxes - Chemical compositions and forms	EN 29453	1993
ISO 9454-1	1990	Soft soldering fluxes - Classification and requirements - Part 1: Classification, labelling and packaging	EN 29454-1	1993
ISO 9455-12	1992	Soft soldering fluxes - Test methods - Part 12: Steel tube corrosion test	EN ISO 9455-12	1994
ISO 10564	1993	Soldering and brazing materials - Methods for the sampling of soft solders for analysis	EN ISO 10564	1997

INTERNATIONAL STANDARD

ISO 12224-1

First edition
1997-06-01

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

Part 1:
Classification and performance requirements

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

Partie 1: Classification et exigences de performance

Reference number
ISO 12224-1:1997(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 12224-1 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*, Subcommittee SC 12, *Soldering and brazing materials*.

ISO 12224 consists of the following parts, under the general title *Solder wire, solid and flux cored — Specification and test methods*:

— *Part 1: Classification and performance requirements*

— *Part 2: Determination of flux content*

— *Part 3: Wetting balance test*

Annexes A and B form an integral part of this International Standard. Annexes C and D are for information only.

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

Part 1:
Classification and performance requirements

1 Scope

This part of ISO 12224 specifies a coding system for the classification and designation of solid and flux cored solder wire, and the performance requirements to be met by flux cored wire and its constituents. Requirements for sampling, labelling and packaging are also specified.

Annex A specifies a method for the solvent extraction of flux incorporated in flux cored solder wire. The solution so obtained may be used for testing purposes.

Annex B specifies the method for measuring the mean diameter of flux cored solder wire.

Annex C gives guidance on the test methods appropriate for the flux types incorporated in flux cored solder wire.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 12224. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 12224 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 9453:1990, *Soft solder alloys — Chemical compositions and forms.*

ISO 9454-1:1990, *Soft soldering fluxes — Classification and requirements — Part 1: Classification, labelling and packaging.*

ISO 9455-10:—[1)], *Soft soldering fluxes — Test methods — Part 10: Flux efficacy test, solder spread method.*

ISO 9455-12:1992, *Soft soldering fluxes — Test methods — Part 12: Steel tube corrosion test.*

ISO 9455-15:1996, *Soft soldering fluxes — Test methods — Part 15: Copper corrosion test.*

ISO 9455-17:—[1)], *Soft soldering fluxes — Test methods — Part 17: Surface insulation resistance comb test and electrical migration test of flux residues.*

ISO 10564:1993, *Soldering and brazing materials — Methods for the sampling of soft solders for analysis.*

ISO 12224-2:—[1)], *Solder wire, solid and flux cored — Specification and test methods — Part 2: Determination of flux content.*

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1) To be published.