

Soldering is easy

Additional comments

Temperature : the iron must reach a minimum of 350°C, even 400°C for large dimension solder. A model of soldering iron of 60 to 80 W is preferred. The soldering tip should not be too thin, preferably of conical shape to obtain a good heat transfer. If the iron has not been used for a few minutes, it is advised to reduce the temperature to about 370°C to avoid premature wear of the soldering iron tip.

Alloys : RoHS European directives impose to use lead-free solder for new circuits. These alloys have fusion temperature of about 30 to 40°C lower than alloys containing lead, and thus need a higher operating temperature.

Cleaning of the tip : we recommend not to use a wet sponge to clean the iron tip, as this method may cause an oxidation of the tip. Instead, clean the tip with a dry metallic sponge. Such a sponge is common in recent models of soldering irons, as illustrated in the following figures.



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