



How To Test Outdated Flux

Please note that this method is to test performance of flux and it is in no way a method used to re-certify, by Kester, flux that had passed its shelf life.

Tools needed:

- Hot plate that can achieve a set temperature of 240°C
- 0.5" X 0.125" piece of solder or a 0.5" piece of solid wire
- 1" X 1" X 0.001" copper coupon which is treated with OSP or ENIG
- 1" X 1" ceramic or non-metallic coupon
- Cutters that can cut a length of solder wire or the chunk off the end of a bar

Process:

1. Turn hot plate on and set to 215°C degrees if testing Sn63Pb37 wire, or 240°C degrees if testing K100LD or SAC305 wire. Allow the hot plate to reach the set point.
2. Cut or 0.5" X 0.125" piece of solder or a 0.50" piece of solid wire
3. Place the piece of solder or solid wire on the copper coupon.
4. Deposit enough flux to cover the coupon or piece of wire.
5. Using a hot gloved hand, place the coupon on the hot plate.
6. Allow the solder to melt then remove the coupon from the hot plate and let it cool.
7. Observe the wet out area of solder. If there is no de-wetting or pull back then the flux is working correctly.
8. Cut a second piece of 0.5" X 0.125" of solder or 0.50" length of wire. Place this on the ceramic slide or non-metallic coupon.
9. Deposit enough flux to cover the coupon or piece of wire.
10. Place this coupon on the hot plate.
11. Remove the coupon once the solder has flowed.
12. The results should be a single ball of solder in the middle of the coupon. No metal particles should be found in the flux field around this ball.

For any questions, please contact:

Mike Kaminsky, Senior Field Support Engineer

Cell: 704-706-4026

mkaminsky@kester.com