AS 1834.2—1986
Reconfirmed 2018

Australian Standard®

MATERIAL FOR SOLDERING

Part 2—FLUX-CORED SOLDERS

This Australian standard was prepared by Committee MT/5, Lead and Lead Alloys. It was approved on behalf of the Council of the Standards Association of Australia on 14 January 1986 and published on 5 May 1986.

The following interests are represented on Committee MT/5:

Australian Atomic Energy Commission

Confederation of Australian Industry

Federated Master Plumbers of Australia

Housing Industry Association of Australia

Metropolitan Water, Sewerage and Drainage Board, NSW

Royal Australian Institute of Architects

Representatives of the following interests also participated in the drafting of this standard:

Australian Lead Development Association

Australian Tin Information Centre

Department of Defence

Telecom Australia

This standard was issued in draft form for comment as DR 84238.

STANDARDS AUSTRALIA

RECONFIRMATION

OF
AS 1834.2–1986
Material for soldering
Part 2–Flux-cored solders

RECONFIRMATION NOTICE

Major stakeholders of this publication have reviewed the content of this publication and in accordance with Standards Australia procedures for reconfirmation, it has been determined that the publication is still valid and does not require change.

Certain documents referenced in the publication may have been amended since the original date of publication. Users are advised to ensure that they are using the latest versions of such documents as appropriate, unless advised otherwise in this Reconfirmation Notice.

Approved for reconfirmation in accordance with Standards Australia procedures for reconfirmation on 29 August 2018.

NOTES

Australian Standard®

MATERIAL FOR SOLDERING

Part 2—FLUX-CORED SOLDER

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PREFACE

This edition of this standard was prepared by the Association's Committee on Lead and Lead alloys, by its Subcommittee on Solder, to supersede, in part, AS 1834—1979. It applies to tin-lead and other tin-containing flux-cored solders.

The Subcommittee considered that AS 1834—1979 could be applied more easily if it was formed into a series. The other standards in the series are as follows:

AS 1834.1— Solder Alloys

AS 1834.3— Fluxes.

During the preparation of the standard, cognizance was taken of the following:

BS 441 Purchasing Requirements for Flux-cored and Solid Soft-solder Wire

QQ-S-571 Solder, Tin Alloy; Tin-Lead Alloy; and Lead Alloy.

In this edition, an additional core mass grade has been introduced and tolerances on wire diameter have been reduced.

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Australian Standard
for
MATERIAL FOR SOLDERING

PART 2—FLUX-CORED SOLDERS

1 SCOPE. This standard specifies requirements for flux-cored solder wire of circular cross-section.

NOTE: Guidelines to purchasers on requirements to be specified by the purchaser and those to be agreed at the time of enquiry and/or order are given in Appendix A.

2 REFERENCED DOCUMENTS. The following standards are referred to in this standard:

AS 1834.1 Material for Soldering—Solder Alloys
AS 1834.3 Material for Soldering— Fluxes
BS 2071 Soxhlet Extractors.

3 SOLDER ALLOY. The solder alloy shall have the chemical composition of one of the grades specified in AS 1834.1.

4 FLUX.

4.1 General. The flux shall be one of the classes specified in AS 1834.3, and shall comply with the requirements specified therein.

4.2 Designation. The flux shall be designated by its nominal percent by mass.

4.3 Flux content. When determined in accordance with Appendix B, the flux content expressed as a percentage of the total mass of the cored solder shall be one of the following:

Grade 2 1.5 percent to 2.5 percent by mass
Grade 3 2.0 percent to 4.0 percent by mass.

5 TOLERANCE ON DIAMETER. Tolerance on diameter of circular wire shall be ±5 percent of the specified diameter, or 0.025 mm, whichever is greater.