



**NSAI**  
Standards

Irish Standard  
I.S. EN 60068-2-58:2015&A1:2018

Environmental testing - Part 2-58: Tests -  
Test Td: Test methods for solderability,  
resistance to dissolution of metallization and  
to soldering heat of surface mounting devices  
(SMD)

**I.S. EN 60068-2-58:2015&A1:2018**

*Incorporating amendments/corrigenda/National Annexes issued since publication:*

EN 60068-2-58:2015/A1:2018

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## National Foreword

I.S. EN 60068-2-58:2015&A1:2018 is the adopted Irish version of the European Document EN 60068-2-58:2015, Environmental testing - Part 2-58: Tests - Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)

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EUROPEAN STANDARD

**EN 60068-2-58:2015/A1**

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2018

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English Version

**Environmental testing - Part 2-58: Tests - Test Td: Test methods  
for solderability, resistance to dissolution of metallization and to  
soldering heat of surface mounting devices (SMD)  
(IEC 60068-2-58:2015/A1:2017)**

Essais d'environnement - Partie 2-58: Essais - Essai Td:  
Méthodes d'essai de la soudabilité, résistance de la  
métallisation à la dissolution et résistance à la chaleur de  
brasage des composants pour montage en surface (CMS)  
(IEC 60068-2-58:2015/A1:2017)

Umweltprüfungen - Teil 2-58: Prüfungen - Prüfung Td:  
Prüfverfahren für Lötbarkeit, Widerstandsfähigkeit  
gegenüber Auflösen der Metallisierung und  
Lötwärmebeständigkeit bei oberflächenmontierbaren  
Bauelementen (SMD)  
(IEC 60068-2-58:2015/A1:2017)

This amendment A1 modifies the European Standard EN 60068-2-58:2015; it was approved by CENELEC on 2017-09-01. CENELEC members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this amendment the status of a national standard without any alteration.

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**EN 60068-2-58:2015/A1:2018 (E)**

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EUROPEAN STANDARD

**EN 60068-2-58**

NORME EUROPÉENNE

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**Environmental testing - Part 2-58: Tests - Test Td: Test methods  
for solderability, resistance to dissolution of metallization and to  
soldering heat of surface mounting devices (SMD)  
(IEC 60068-2-58:2015)**

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métallisation à la dissolution et résistance à la chaleur de  
brasage des composants pour montage en surface (CMS)  
(IEC 60068-2-58:2015)

Umweltprüfungen - Teil 2-58: Prüfungen - Prüfung Td:  
Prüfverfahren für Lötbarkeit, Widerstandsfähigkeit  
gegenüber Auflösen der Metallisierung und  
Lötwärmebeständigkeit bei oberflächenmontierbaren  
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Comité Européen de Normalisation Electrotechnique  
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**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

## Foreword

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In the official version, for Bibliography, the following notes have to be added for the standards indicated:

IEC 60068-2-54	NOTE	Harmonized as EN 60068-2-54.
IEC 60068-2-69	NOTE	Harmonized as EN 60068-2-69.
IEC 60749-20	NOTE	Harmonized as EN 60749-20.
IEC 61760-3	NOTE	Harmonized as EN 61760-3.
IEC 61760-4	NOTE	Harmonized as EN 61760-4 <sup>1)</sup> .

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1) To be published.



## Annex ZA

### (normative)

### Normative references to international publications with their corresponding European publications

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

NOTE 1 When an International Publication has been modified by common modifications, indicated by (mod), the relevant EN/HD applies.

NOTE 2 Up-to-date information on the latest versions of the European Standards listed in this annex is available here: [www.cenelec.eu](http://www.cenelec.eu).

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
IEC 60068-1	-	Environmental testing - Part 1: General and guidance	EN 60068-1	-
IEC 60068-2-20	2008	Environmental testing - Part 2-20: Tests - Test T: Test methods for solderability and resistance to soldering heat of devices with leads	EN 60068-2-20	2008
IEC 60194	-	Printed board design, manufacture and assembly - Terms and definitions	EN 60194	-
IEC 61190-1-1	-	Attachment materials for electronic assembly - Part 1-1: Requirements for soldering fluxes for high-quality interconnections in electronics assembly	EN 61190-1-1	-
IEC 61190-1-2	2014	Attachment materials for electronic assembly - Part 1-2: Requirements for soldering pastes for high-quality interconnects in electronics assembly	EN 61190-1-2	2014
IEC 61190-1-3 + A1	2007 2010	Attachment materials for electronic assembly - Part 1-3: Requirements for electronic grade solder alloys and fluxed and non-fluxed solid solders for electronic soldering applications	EN 61190-1-3 + A1	2007 2010
IEC 61191-2	-	Printed board assemblies - Part 2: Sectional specification - Requirements for surface mount soldered assemblies	EN 61191-2	-

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
IEC 61249-2-22	-	Materials for printed boards and other interconnecting structures - Part 2-22: Reinforced base materials, clad and unclad - Modified non-halogenated epoxide woven E-glass laminated sheets of defined flammability (vertical burning test), copper-clad	EN 61249-2-22	-
IEC 61249-2-35	-	Materials for printed boards and other interconnecting structures - Part 2-35: Reinforced base materials, clad and unclad - Modified epoxide woven E-glass laminate sheets of defined flammability (vertical burning test), copper-clad for lead-free assembly	EN 61249-2-35	-
IEC 61760-1	-	Surface mounting technology - Part 1: Standard method for the specification of surface mounting components (SMDs)	EN 61760-1	-
ISO 9454-2	1998	Soft soldering fluxes - Classification and requirements - Part 2: Performance requirements	EN ISO 9454-2	2000



**IEC 60068-2-58**

Edition 4.0 2015-03

# **INTERNATIONAL STANDARD**

# **NORME INTERNATIONALE**



**Environmental testing –  
Part 2-58: Tests – Test Td: Test methods for solderability, resistance to  
dissolution of metallization and to soldering heat of surface mounting devices  
(SMD)**

**Essais d'environnement –  
Partie 2-58: Essais – Essai Td: Méthodes d'essai de la soudabilité, résistance de  
la métallisation à la dissolution et résistance à la chaleur de brasage des  
composants pour montage en surface (CMS)**



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**IEC 60068-2-58**

Edition 4.0 2015-03

# **INTERNATIONAL STANDARD**

# **NORME INTERNATIONALE**



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## **Environmental testing –**

**Part 2-58: Tests – Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)**

## **Essais d'environnement –**

**Partie 2-58: Essais – Essai Td: Méthodes d'essai de la soudabilité, résistance de la métallisation à la dissolution et résistance à la chaleur de brasage des composants pour montage en surface (CMS)**

INTERNATIONAL  
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## CONTENTS

FOREWORD.....	5
1 Scope.....	7
2 Normative references.....	7
3 Terms and definitions .....	8
4 Grouping of soldering processes and related test severities.....	9
5 Test equipment.....	10
5.1 Solder bath .....	10
5.2 Reflow equipment .....	10
6 Test Td <sub>1</sub> : Solderability of terminations .....	11
6.1 Object and general description of the test .....	11
6.2 Specimen preparation .....	11
6.3 Accelerated ageing .....	11
6.4 Initial measurements .....	11
6.5 Method 1: Solder bath .....	11
6.5.1 Solder bath .....	11
6.5.2 Solder and flux.....	11
6.5.3 Test procedure and conditions.....	12
6.6 Method 2: Reflow .....	14
6.6.1 Reflow equipment .....	14
6.6.2 Solder paste .....	14
6.6.3 Test substrates .....	14
6.6.4 Test procedure.....	14
6.6.5 Reflow temperature profile for Test Td <sub>1</sub> .....	15
6.6.6 Test conditions .....	16
7 Test Td <sub>2</sub> : Resistance to soldering heat .....	16
7.1 Object and general description of the test .....	16
7.2 Specimen preparation .....	16
7.3 Preconditioning .....	16
7.4 Initial measurements .....	16
7.5 Method 1: Solder bath .....	17
7.5.1 Solder bath .....	17
7.5.2 Solder and flux.....	17
7.5.3 Test procedure and conditions.....	17
7.6 Method 2: Reflow .....	19
7.6.1 Reflow equipment .....	19
7.6.2 Solder paste .....	19
7.6.3 Test substrates .....	19
7.6.4 Test procedure and conditions.....	19
8 Test Td <sub>3</sub> : Dewetting and resistance to dissolution of metallization .....	21
8.1 Object and general description of the test .....	21
8.2 Specimen preparation .....	21
8.3 Initial measurements .....	22
8.4 Method 1: Solder bath .....	22
8.4.1 Solder bath .....	22
8.4.2 Solder and flux.....	22

8.4.3	Test procedure and conditions.....	22
8.5	Method 2: Reflow .....	22
8.5.1	Reflow equipment .....	22
8.5.2	Specimen.....	22
8.5.3	Solder paste .....	22
8.5.4	Flux .....	22
8.5.5	Reflow profile.....	22
8.5.6	Placement of the specimen .....	23
8.5.7	Application of the reflow profile.....	23
8.5.8	Evaluation.....	23
9	Final measurements .....	23
9.1	Flux removal .....	23
9.2	Recovery conditions .....	23
9.3	Evaluation.....	23
9.3.1	Wetting .....	23
9.3.2	Dewetting .....	24
9.3.3	Resistance to soldering heat .....	24
9.3.4	Resistance to dissolution of metallization.....	24
10	Information to be given in the relevant specification.....	25
10.1	General.....	25
10.2	Solderability.....	25
10.3	Resistance to soldering heat, dewetting and resistance to dissolution of metallization.....	25
Annex A	(normative) Criteria for visual examination .....	27
A.1	Wetting .....	27
A.2	Evaluation of wetting .....	27
A.3	Evaluation of method 2 (Td <sub>1</sub> ).....	28
A.4	Evaluation of method 2 (Td <sub>3</sub> ).....	29
Annex B	(informative) Guidance .....	30
B.1	General.....	30
B.2	Limitations .....	30
B.3	Choice of severity .....	30
B.3.1	Test Td <sub>1</sub> : Solderability by solder bath method.....	30
B.3.2	Test Td <sub>2</sub> : Resistance to soldering heat – Solder bath method .....	31
B.3.3	Test Td <sub>2</sub> : Resistance to soldering heat –Reflow method .....	31
B.3.4	Immersion attitude .....	32
B.3.5	Test Td <sub>3</sub> : Dewetting and resistance to dissolution of metallization for 30 s at 260 °C .....	32
Annex C	(normative) Application of the test methods to through hole reflow soldering components (THR).....	33
C.1	Solderability.....	33
C.2	Resistance to soldering heat .....	33
C.3	Dewetting.....	33
C.4	Criteria for evaluation .....	33
Annex X	(informative) Cross reference for references to the prior revision of this specification .....	34
Bibliography	.....	36

Figure 1 – Examples of immersion attitudes .....	13
Figure 2 – Reflow temperature profile for solderability .....	15
Figure 3 – Examples of immersion attitude .....	18
Figure 4 – Reflow temperature profile for resistance to soldering heat.....	20
Figure 5 – Example for placement of a specimen to a test substrate .....	23
Figure 6 – Identification of areas on metallic termination.....	24
Figure A.1 – Evaluation of wetting .....	28
Table 1 – Grouping of soldering processes and typical test severities – Overview .....	10
Table 2 – Solder alloy and flux for test Td <sub>1</sub> .....	12
Table 3 – Solderability – Test conditions and severity, solder bath method.....	14
Table 4 – Solder paste specification.....	14
Table 5 – Solderability – Test conditions – Method 2: Reflow .....	16
Table 6 – Resistance to soldering heat – Test conditions and severity, solder bath method.....	19
Table 7 – Resistance to soldering heat – Test conditions and severity, reflow method .....	21
Table 8 – Dewetting and resistance to dissolution of metallization – Test conditions and severity, solder bath method.....	22
Table B.1 – Test conditions.....	31
Table C.1 – Test conditions for solderability test.....	33



## INTERNATIONAL ELECTROTECHNICAL COMMISSION

## ENVIRONMENTAL TESTING –

**Part 2-58: Tests –  
Test Td: Test methods for solderability, resistance  
to dissolution of metallization and to soldering heat  
of surface mounting devices (SMD)**

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International Standard IEC 60068-2-58 has been prepared by IEC technical committee 91: Electronics assembly technology.

This fourth edition cancels and replaces the third edition, published in 2004 and constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- the addition of Sn-Bi low temperature solder alloy;
- the addition of several reflow test conditions in Table 7 – Resistance to soldering heat – Test conditions and severity, reflow method;
- introduction of reflow test method for Test Td<sub>3</sub>: Dewetting and resistance to dissolution of metallization;

– implementation of guidance for the choice of a test severity in Clause B.3.

The text of this standard is based on the following documents:

FDIS	Report on voting
91/1222/FDIS	91/1250/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all parts in the IEC 60068, published under the general title *Environmental testing*, can be found on the IEC website.

The committee has decided that the contents of this publication will remain unchanged until the stability date indicated on the IEC web site under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

- reconfirmed,
- withdrawn,
- replaced by a revised edition, or
- amended.

**IMPORTANT – The 'colour inside' logo on the cover page of this publication indicates that it contains colours which are considered to be useful for the correct understanding of its contents. Users should therefore print this document using a colour printer.**

## ENVIRONMENTAL TESTING –

### Part 2-58: Tests –

#### Test Td: Test methods for solderability, resistance to dissolution of metallization and to soldering heat of surface mounting devices (SMD)

## 1 Scope

This part of IEC 60068 outlines test Td, applicable to surface mounting devices (SMD).

This standard provides procedures for determining the solderability and resistance to soldering heat of devices in applications using solder alloys, which are eutectic or near eutectic tin lead (Pb), or lead-free alloys.

The procedures use either a solder bath or reflow method and are applicable only to specimens or products designed to withstand short term immersion in molten solder or limited exposure to reflow systems.

The solder bath method is applicable to SMDs designed for flow soldering and SMDs designed for reflow soldering when the solder bath (dipping) method is appropriate.

The reflow method is applicable to the SMD designed for reflow soldering, to determine the suitability of SMDs for reflow soldering and when the solder bath (dipping) method is not appropriate.

The objective of this standard is to ensure solderability of component lead or termination. In addition, test methods are provided to ensure that the component body can resist against the heat load to which it is exposed during soldering.

This standard covers tests Td<sub>1</sub>, Td<sub>2</sub> and Td<sub>3</sub> as listed below:

Number of Td	Test	Method
Td <sub>1</sub>	Solderability of terminations	Method 1: Solder bath Method 2: Reflow
Td <sub>2</sub>	Resistance to soldering heat	Method 1: Solder bath Method 2: Reflow
Td <sub>3</sub>	Dewetting and resistance to dissolution of metallization	Method 1: Solder bath Method 2: Reflow

NOTE 1 For specific components other test methods may exist.

NOTE 2 Test Td does not apply to printed wiring board (PWB), see IEC 61189-3.

NOTE 3 Specific through-hole devices (where the device supplier has specifically documented support for reflow soldering) are also included in this standard.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60068-1, *Environmental testing – Part 1: General and guidance*

IEC 60068-2-20:2008, *Environmental testing – Part 2-20: Tests – Test T: Test methods for solderability and resistance to soldering heat of devices with leads*

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