



National Standards Authority of Ireland

IRISH STANDARD

**I.S. EN 60068-2-54:2006**

ICS 19.040  
31.020

**ENVIRONMENTAL TESTING -- PART 2-54:  
TESTS - TEST TA: SOLDERABILITY  
TESTING OF ELECTRONIC COMPONENTS  
BY THE WETTING BALANCE METHOD (IEC  
60068-2-54:2006 (EQV))**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 60068-2-54**

August 2006

ICS 19.040; 31.020

Supersedes HD 323.2.54 S1:1987

English version

**Environmental testing**  
**Part 2-54: Tests -**  
**Test Ta: Solderability testing of electronic components**  
**by the wetting balance method**  
(IEC 60068-2-54:2006)

Essais d'environnement  
Partie 2-54 : Essais -  
Essai Ta : Essai de brasabilité des  
composants électroniques par  
la méthode de la balance de mouillage  
(CEI 60068-2-54:2006)

Umweltprüfungen  
Teil 2-54: Prüfungen -  
Prüfung Ta: Prüfung der Lötbarkeit  
elektronischer Bauelemente  
mit der Benetzungswaage  
(IEC 60068-2-54:2006)

This European Standard was approved by CENELEC on 2006-07-01. CENELEC 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 CENELEC 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 CENELEC member into its own language and notified to the Central Secretariat has the same status as the official versions.

CENELEC members are the national electrotechnical committees of Austria, Belgium, Cyprus, the Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, the Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

**CENELEC**

European Committee for Electrotechnical Standardization  
Comité Européen de Normalisation Electrotechnique  
Europäisches Komitee für Elektrotechnische Normung

**Central Secretariat: rue de Stassart 35, B - 1050 Brussels**

## Foreword

The text of document 91/576/FDIS, future edition 2 of IEC 60068-2-54, prepared by IEC TC 91, Electronics assembly technology, was submitted to the IEC-CENELEC parallel vote and was approved by CENELEC as EN 60068-2-54 on 2006-07-01.

This European Standard supersedes HD 323.2.54 S1:1987.

The major technical changes with regard to HD 323.2.54 S1:1987 concern:

- the addition of lead free solder alloy (see Clause 7, Materials);
- reversal of force-time curves to align with EN 60068-2-69 (see Figure 2 and Figure B.1);
- modification to the test requirement for progress of wetting (see Clause 9).

The following dates were fixed:

- |  |       |            |
|--|-------|------------|
| – latest date by which the EN has to be implemented at national level by publication of an identical national standard or by endorsement | (dop) | 2007-04-01 |
| – latest date by which the national standards conflicting with the EN have to be withdrawn   | (dow) | 2009-07-01 |

Annex ZA has been added by CENELEC.

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## Endorsement notice

The text of the International Standard IEC 60068-2-54:2006 was approved by CENELEC as a European Standard without any modification.

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

IEC 60068-2-44	NOTE	Harmonized as EN 60068-2-44:1995 (not modified).
IEC 60068-2-58	NOTE	Harmonized as EN 60068-2-58:2004 (not modified).
IEC 60068-2-69	NOTE	Harmonized as EN 60068-2-69:1996 (not modified).
IEC 61190-1-1	NOTE	Harmonized as EN 61190-1-1:2002 (not modified).
IEC 61190-1-3	NOTE	Harmonized as EN 61190-1-3:2002 (not modified).

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## Annex ZA (normative)

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

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

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

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
IEC 60068-1	1988	Environmental testing Part 1: General and guidance	EN 60068-1 <sup>1)</sup>	1994
IEC 60068-2-20	1979	Environmental testing Part 2: Tests - Test T: Soldering	HD 323.2.20 S3 <sup>2)</sup>	1988
IEC 61190-1-3	- <sup>3)</sup>	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	2002 <sup>4)</sup>

<sup>1)</sup> EN 60068-1 includes corrigendum October 1988 + A1:1992 to IEC 60068.

<sup>2)</sup> HD 323.2.20 S3 includes A2:1987 to IEC 60068-2-20.

<sup>3)</sup> Undated reference.

<sup>4)</sup> Valid edition at date of issue.



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