भारतीय मानक ब्यूरो
(उपभोक्ता मामले, खाद्य एवं सार्वजनिक वितरण मंत्रालय, भारत सरकार)
BUREAU OF INDIAN STANDARDS
(Ministry of Consumer Affairs, Food & Public Distribution, Govt. of India)
मानक: पथप्रदर्शक:
मानक भवन, 9 बहादुरशाह जफर मार्ग नई, दिल्ली-110002
Manak Bhavan ,9 Bahadur Shah Zafar Marg, New Delhi-110002
Phones: 23230131 / 23233375 / 23239402
Website: www.bis.org.in , www.bis.gov.in

DRAFT INDIAN STANDARD IN WIDE CIRCULATION

Reference : MTD9/T-31 **Date : 08 August 2024**

TECHNICAL COMMITTEE : Ores and Feed Stock for Non-Ferrous (Excluding Aluminium and Copper) Industry, their Metals/ Alloys and Products Sectional Committee, MTD 09

To,

All concerned

Dear Madam/Sir,

The following document has been prepared by the Ores and Feed Stock for Non-Ferrous (Excluding Aluminium and Copper) Industry, their Metals/ Alloys and Products Sectional Committee Sectional Committee, MTD 09. Please click here to view the document.

Document Number : MTD 09 (25837) WC
Title of the document : SOLDER WIRE - SOLID AND FLUX CORED - SPECIFICATION (THIRD REVISION)
Document Type : Revision of Indian Standard (IS 1921 : 2005)

This document has following salient features which may require specific attention for your valuable comments:

1) The third revision of the standard includes non-fluxed solid wires, a wider range of solder alloys, and additional flux compositions/types beyond rosin fluxes. The revision aligns the flux classification with internationally accepted standards and recognized test methods.
2) Title Modification: Changed from "Flux cored solder wire — Specification" to "Solder wire — Solid and flux cored— Specification".
3) Expanded Scope: Now covers both solid and flux-cored solder wires, with classification and performance requirements for different flux types: Rosin (RO), Resin (RE), Organic (OR), and Inorganic (IN).
4) Chemical Composition Update: Includes both lead-containing and lead-free grades. Covers approximately 30 lead-containing alloys and 31 lead-free solder grades, with provisions for other alloys meeting impurity limits.
5) Terminology Clause: Added for clarity.
6) Flux Percentage Adjustment: Previously restricted to 2-4 percent; now flexible as per agreement, with specified tolerance limits.
7) Dimensions and Tolerances Update: Includes additional recommended sizes with tolerance limits.
8) Sampling Clause: Modified for current requirements.
9) Testing Frequencies Clause: Manufacturers must test at specified frequencies to ensure process control and product conformity.
10) Annex A: Specifies methods for extracting flux from flux cored solder wire for testing. Annex D: Details classification and requirements for fluxes used in solder wire manufacture. Annex E: Procedure for determining flux

content in flux cored solder wire.
11) Various Annexures for Test Methods Included as per Internationally Accepted Standards and norms: Include tests for spread, flux residue dryness, nominal diameter measurement, copper mirror, copper plate corrosion, non-volatile content, halide content, surface insulation resistance, electrochemical migration resistance, and acid value determination.
12) Optional Tests Included: Include spread test, Electrochemical Migration Resistance (ECM) test, and halogen content test

Please examine the document and share your comments regarding further improvement in the document.

Last date for sharing the comments is : 09 October 2024

The comments should be shared in the prescribed template through this portal only; and the comments so received shall be taken up by the Sectional Committee for necessary action. For any other query, please write an email at mtd@bis.gov.in to the undersigned at Bureau of Indian Standard, Manak Bhawan, 9, Bahadur Shah Zafar Marg, New Delhi.

In case no comments are received, we would presume your approval of the documents. However, in case we receive any comments on the document, the same shall be put up to the Sectional Committee for necessary action.

Thanking You,

Yours faithfully,
(SANJIV MAINI)
Head (Metallurgical Engineering Department)
Email: mtd@bis.gov.in

व्यापक परिचालन में मसौदा(दे)

हमारा सन्दर्भ : MTD9/T-31 दिनांक : 08-08-2024

तकनीकी समिति : Ores and Feed Stock for Non-Ferrous (Excluding Aluminium and Copper) Industry, their Metals/ Alloys and Products Sectional Committee Sectional Committee, MTD 09

प्राप्तकर्ता : रूचि रखने वाले सभी निकाय

महोदय/या,

निम्नलिखित मसौदा तैयार किया गया है :

प्रलेख संख्या : MTD 09 (25837) WC
शीर्षक :

कृपया इस/इन मानक(को)/संसोधन(नो) के मसौदे(दो) का अवलोकन करें और अपनी सम्मतियाँ यह बताते हुए भेजें कि यदि ये मानक(को) के संशोधन(नो) के रूप में प्रकाशित हो तो इन पर अमल करने में आपके व्यवसाय अथवा कारोबार में क्या कठिनाइयां आ सकती हैं।

सम्मत्तियाँ भेजने की अंतिम तिथि : 09 October 2024

सम्मतियाँ, यदि कोई हों तो, कृपया यहाँ क्लिक करके ऑनलाइन पोर्टल के माध्यम से ऊपर दी गयी अंतिम तिथि तक दर्ज कराएं।

यह/ये प्रलेख भारतीय मानक ब्यूरो की वेबसाइट www.bis.gov.in पर भी उपलब्ध है/हैं।

धन्यवाद।

भवदीय/भवदिया,

विभाग प्रमुख का नाम : SANJIV MAINI
(Metallurgical Engineering Department)
ई-मेल : mtd@bis.gov.in