

**AMENDMENT NO. 1 DECEMBER 2024**  
**TO**  
**IS 13730 (Part 20) : 2018/IEC 60317-20 : 2013 Specifications for Particular**  
**Types of Winding Wires Part 20 Solderable Polyurethane Enamelled Round**  
**Copper Wire, Class 155**  
*( Second Revision )*

This amendment of Indian Standard IS 13730 (Part 20) : 2018 is identical to Amendment No. 1 (2019) of IEC 60317-20 : 2013 issued by International Electrotechnical Commission (IEC).

**Price Group 1**

## **17 Solderability**

*Replace the content of this clause by the following:*

### **17.1 General**

The temperature of the solder bath shall be  $(390 \pm 5)$  °C. The surface of the tinned wire shall be smooth and free from holes and enamel residues.

### **17.2 Nominal conductor diameters up to and including 0,100 mm**

The maximum immersion time shall be 2 s.

### **17.3 Nominal conductor diameters over 0,100 mm**

The maximum immersion time (in seconds) shall be the following multiple of the nominal conductor diameter (in millimetres) with a minimum of 2 s.

Grade 1	Grade 2
8 s/mm	12 s/mm