



## IS 1921 : 2005

# FLUX CORED SOLDER WIRE

The Indian Standard IS 1921:2005 specifies requirements for **flux-cored solder wire**, used primarily in **electronic, electrical, and instrumentation applications**. This standard outlines specifications for both **activated and non-activated (non-corrosive) flux cored solder wires** with circular cross section, having a single or multiple continuous core of flux for efficient soldering. The standard specifies 5 Grades with distinct and precise **chemical compositions limits** for alloying elements like **Lead, Tin** and other impurities ensuring safe and effective soldering. The flux shall be homogeneously and uniformly distributed, resistant to corrosive actions, and meet hardness and dimensional requirements as specified. The standard also specifies melting characteristics and typical applications for each grade offering guidance for optimal solder selection. In addition, it outlines detailed test methods to distinguish between **activated and non-activated rosin-cored solders** and **Freedom from corrosive action of flux residue**.