



IPC-J-STD-004D

Requirements for Soldering Fluxes

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Developed by the 5-24A Flux Specifications Task Group
of the Assembly and Joining General Committee 5-20 of IPC

Users of this publication are encouraged to participate in the development of future revisions.

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Table of Contents

1	SCOPE	1	2.4.34.4	Paste Flux Viscosity - T-Bar Spindle Method	3
1.1	Purpose	1	2.6.1	Fungus Resistance Printed Wiring Materials	3
1.2	Classification	1	2.6.3.3	Surface Insulation Resistance (SIR), Fluxes	3
1.3	Measurement Units	1	2.6.3.7	Surface Insulation Resistance	3
1.4	Definition of Requirements.....	1	2.6.14.1	Electrochemical Migration Resistance Test..	3
1.5	Process Control Requirements.....	1	2.6.15	Corrosion, Flux.....	3
1.6	Order of Precedence.....	2	2.2	Joint Industry Standards.....	3
1.6.1	Conflict.....	2	2.2.1	J-STD-001	3
1.6.2	Clause References.....	2	2.2.2	J-STD-003	4
1.6.3	Appendices	2	2.2.3	J-STD-005	4
1.7	Use of “Lead”.....	2	2.2.4	J-STD-006	4
1.8	Abbreviations and Acronyms.....	2	2.3	American Society for Testing and Materials (ASTM)	4
1.8.1	ECM	2	2.3.1	ASTM D-465-15	4
1.8.2	SIR.....	2	2.4	British Standards	4
1.9	Terms and Definitions	2	2.4.1	EN 14582.....	4
1.9.1	Halide.....	2	2.5	International Organization for Standards.....	4
1.9.2	Halogen.....	2	2.5.1	ISO 9001-2000	4
1.9.3	Low Halogen Flux (Cl and Br).....	2	2.6	National Conference of Standards Laboratories (NCSL).....	4
1.9.4	Flux Composition.....	3	2.6.1	ANSI-NCSL-Z540-1.....	4
1.9.5	Supplier.....	3			
2	APPLICABLE DOCUMENTS	3	3	GENERAL REQUIREMENTS	4
2.1	IPC	3	3.1	Designation	4
IPC-T-50	Terms and Definitions for Interconnecting and Packaging Electronic Circuits.....	3	3.2	Flux Qualification.....	5
IPC-9191	General Guidelines for the Implementation of Statistical Process Control.....	3	3.2.1	Classification	6
IPC-TM-650	Test Methods Manual.....	3	3.2.1.1	Flux Composition.....	6
2.3.13	Determination of Acid Value of Liquid Solder Flux - Potentiometric and Visual Titration Methods	3	3.2.1.2	Flux Type.....	6
2.3.28.1	Halide Content of Soldering Fluxes and Pastes	3	3.2.1.2.1	Flux Activity	6
2.3.32	Flux Induced Corrosion (Copper Mirror Method)	3	3.2.1.2.2	Halide Content.....	6
2.3.33	Presence of Halides in Flux, Silver Chromate Method.....	3	3.2.2	Characterization.....	7
2.3.34	Solids Content, Flux.....	3	3.3.1	Classification Testing	7
2.3.35.1	Fluorides by Spot Test, Fluxes - Qualitative..	3	3.3.1.1	Copper Mirror Test.....	7
2.4.14.2	Liquid Flux Activity, Wetting Balance Method.....	3	3.3.1.2	Corrosion Test	7
			3.3.1.3	Quantitative Halide Content Tests.....	8
			3.3.1.4	SIR Test.	8
			3.3.1.4.2	SIR Test Criteria	8
			3.3.1.5	Resistance to ECM Testing	9
			3.3.1.5.1	Reporting ECM Test Results.....	9
			3.3.2	Characterization Testing.....	9

3.3.2.1	Flux Solids (Non-volatile) Determination	9	4.1.1.1	Quality Assurance Program	11
3.3.2.2	Acid Value Determination.....	9	4.1.2	Test Equipment and Inspection Facilities... ..	11
3.3.2.3	Specific Gravity Determination	9	4.1.3	Inspection Conditions.....	11
3.3.2.4	Viscosity of Paste (Tacky) Flux	9	4.2	Types of Inspections	11
3.3.2.5	Visual	9	4.3	Qualification Inspection	12
3.4	Optional Testing	9	4.3.1	Sample Size	12
3.4.1	Optional Qualitative Halide Tests	9	4.3.2	Inspection Routine.....	12
3.4.1.1	Optional Chlorides and Bromides by Silver Chromate Method.....	9	4.3.3	Requalification	12
3.4.1.2	Optional Fluorides By Spot Test.....	9	4.3.3.1	Formula Variations Constituting Material Change.....	12
3.4.2	Optional SIR Tests.....	10	4.3.3.2	Manufacturing Site Change	12
3.4.2.1	Reporting Values for Optional SIR Test Methods.....	10	4.4	Quality Conformance Inspection.....	12
3.4.3	Optional Fungus Resistance Test.....	10	4.4.1	Sampling Plan	12
3.4.4	Optional Halogen Content Test.....	10	4.4.2	Rejected Lots.....	12
3.4.5	Optional Resistance to Creep Corrosion Testing.....	10	4.5	Performance Inspection.....	12
3.5	Quality Conformance Testing	10	4.6	Statistical Process Control (SPC).....	12
3.5.1	Acid Value Determination.....	10	B-1	Cleaning and Test Methods.....	15
3.5.2	Specific Gravity Determination	10	B-2	Ordering Data	15
3.5.3	Viscosity of Paste (Tacky) Flux.....	10	B-3	Formic Acid.....	15
3.5.4	Visual	10	B-4	Wetting Balance Test Guidance	15
3.6	Performance Testing.....	10	B-5	Extension of Shelf Life for Liquid Flux	16
3.6.1	Wetting Balance Test.....	10	B-6	REACH.....	16
4	QUALIFICATION AND QUALITY ASSURANCE PROVISIONS.....	10	B-7	Halide versus Halogen Content	16
4.1	Responsibility for Inspection	11	B-8	Restriction of Hazardous Substances (RoHS).....	16
4.1.1	Responsibility for Compliance.....	11	B-9	SIR Testing: Chamber conditions' effect on SIR results.....	16

Figures		Tables			
Figure 3-1	Flux Corrosivity by Copper Mirror Test.....	7	Table 3-1	Flux Identification System and Test Requirements for Flux Classification....	5
Figure 3-2	Example of No Corrosion	8	Table 3-2	Preparation of Flux Forms for Testing.....	6
Figure 3-3	Example of Minor Corrosion.....	8	Table 3-3.	Quantitative Halide and Activity Classification	7
Figure 3-4	Example of Major Corrosion	8	Table 3-4	Halogen Content in Low Halogen Materials	10
Figure B-1	Typical Wetting Balance Curve.....	15	Table 4-1	Qualification, Quality Conformance and Performance Testing for Flux	11
Figure D-1A and D-1B	ImmAg board from a consumer product after 5 days Mixed Flowing Gas exposure [1]....	18		Required Cleaning Information if the Flux was Removed.	14
			Table D-1.	Comparison Between MFG and FoS Tests for Creep Corrosion.....	20

IPC-J-STD-004D

Requirements for Soldering Fluxes

1 SCOPE

This standard prescribes general requirements for the classification and characterization of fluxes for high quality solder interconnections. This standard may be used for quality control and procurement purposes.

1.1 Purpose The purpose of this standard is to classify and characterize Sn/Pb and Pb-free soldering flux materials for use in electronic metallurgical interconnections for printed board assembly. Soldering flux materials include the following: liquid flux, paste flux, solder paste, solder cream as well as flux-coated and flux-cored solder wires and preforms. The fluxes involved relate to all aspects of application, such as: printed board fabrication, lead tinning, wave soldering, reflow and rework. Fluxes covered by this standard are intended for use in various applications in industry. It is not the intent of this standard to exclude any acceptable flux or soldering material; however, these materials must produce the desired electrical and metallurgical interconnection.

1.2 Classification

CLASS 1 General Electronic Products Includes products suitable for applications where the major requirement is function of the completed assembly.

CLASS 2 Dedicated Service Electronic Products Includes products where continued performance and extended life is required, and for which uninterrupted service is desired but not critical. Typically, the end-use environment would not cause failures.

CLASS 3 High Performance/Harsh Environment Electronic Products Includes products where continued high performance or performance-on-demand is critical, equipment downtime cannot be tolerated, end-use environment may be uncommonly harsh, and the equipment must function when required, such as life support or other critical systems.

1.3 Measurement Units All dimensions and tolerances in this specification are expressed in hard SI (metric) units and bracketed soft imperial [inch] units. Users of this specification are expected to use metric dimensions. All dimensions ≥ 1 mm [0.0394 in] will be expressed in millimeters and inches. All dimensions < 1 mm [0.0394 in] will be expressed in micrometers and microinches.

1.4 Definition of Requirements The words **shall** or **shall not** are used in the text of this document wherever there is a requirement for materials, preparation, process control or acceptance.

The word “should” reflects recommendations and is used to reflect general industry practices and procedures for guidance only.

Line drawings and illustrations are depicted herein to assist in the interpretation of the written requirements of this Standard. The text takes precedence over the figures.

1.5 Process Control Requirements The primary goal of process control is to continually reduce variation in the processes, products, or services to provide products or processes meeting or exceeding User requirements. Process control tools such as IPC-9191, JESD557 or other User-approved system may be used as guidelines for implementing process control.

Manufacturers of Class 3 products **shall** develop and implement a documented process control system.

A documented process control system, if established, **shall** define process control and corrective action limits.

This may or may not be a statistical process control system. The use of “statistical process control” (SPC) is optional and should be based on factors such as design stability, lot size, production quantities, and the needs of the Manufacturer, see 4.6.

Process control methodologies **shall** be used in the planning, implementation and evaluation of the manufacturing processes used to produce soldered electrical and electronic assemblies. The philosophy, implementation strategies, tools and techniques may be applied in different sequences depending on the specific company, operation, or variable under consideration to relate process control and capability to end product requirements.

When a decision or requirement is to use a documented process control system, failure to implement process corrective action and/or the use of continually ineffective corrective actions would be grounds for disapproval of the process and associated documentation.