


AWS B2.3/B2.3M:2008
An American National Standard



Specification for Soldering Procedure and Performance Qualification



American Welding Society



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Approved by the
American National Standards Institute
December 20, 2007

Specification for
Soldering Procedure and
Performance Qualification

1st Edition

Prepared by the
American Welding Society (AWS) B2 Committee on Procedure and Performance Qualification

Under the Direction of the
AWS Technical Activities Committee

Approved by the
AWS Board of Directors

Abstract

This specification provides the requirements for qualification of soldering procedure specifications, solderers, and soldering operators for manual, mechanized, and automatic soldering. The soldering processes included are torch soldering, furnace soldering, resistance soldering, dip soldering, infrared soldering, and induction soldering. Base metals, soldering filler metals, soldering fluxes, soldering atmospheres, and soldering joint clearances are also included.



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Foreword

This foreword is not part of AWS B2.3/B2.3M:2008, *Specification for Soldering Procedure and Performance Qualification*, but is included for informational purposes only.

The AWS B2 Committee on Procedure and Performance Qualification was formed in 1979. The first edition of B2.1, *Specification for Welding Procedure and Performance Qualification*, was published in 1984. This standard introduced the concept of Standard Welding Procedure Specifications in addition to a set of rules for qualifying welding procedures, welders, and welding operators. The B2 Committee has published sixty-two Standard Welding Procedure Specifications, B2.2, *Standard for Brazing Procedure and Performance Qualification*, B2.4, *Specification for Welding Procedure and Performance Qualification for Thermoplastics*, and most recently B2.3/B2.3M, *Specification for Soldering Procedure and Performance Qualification*.

This is the first edition of AWS B2.3/B2.3M, *Specification for Soldering and Performance Qualification*. This standard originated in the B2E Subcommittee on Soldering Qualification. The B2E Subcommittee was formed in 2000 in order to explicitly address the unique requirements of soldering procedure and soldering performance qualification outside the spectrum of B2.1, *Specification for Welding Procedure and Performance Qualification*.

Comments and suggestions for the improvement of this standard are welcome. They should be sent to the Secretary, AWS B2 Committee on Procedure and Performance Qualification, American Welding Society, 550 N.W. LeJeune Road, Miami, FL 33126.

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Specification for Soldering Procedure and Performance Qualification

1. Scope

This specification provides the requirements for qualification of soldering procedure specifications. This specification also provides requirements for the performance qualification of solderers and soldering operators and is intended for use where referenced by a product standard or contract document.

Employers shall be responsible for the soldering done by their organization, including the use of qualified soldering procedures, qualified solderers, and qualified soldering operators. It is the Employer's responsibility to assure that soldering procedure specifications meet any additional requirements of the Referencing Document. Each Employer shall maintain the applicable soldering procedure specifications, soldering procedure qualification records, and soldering performance qualification records.

When not otherwise specified by the Referencing Document, the edition of the specification to be used shall be established in accordance with the following:

- (1) Editions may be used at any time after the effective date of issue.
- (2) Latest edition of this document should be used for new contracts.
- (3) Editions established by contract date may be used during the entire term of the contract, or the provisions of later editions may be used when agreed upon by the contracting parties.

This document is intended primarily for use with the following soldering processes:

- (1) Torch soldering (TS)
- (2) Furnace soldering (FS)
- (3) Induction soldering (IS)
- (4) Resistance soldering (RS)
- (5) Dip soldering (DS)

(6) Iron soldering (INS)

(7) Infrared soldering (IRS)

This standard makes use of both U.S. Customary Units and the International System of Units (SI). The latter are shown with brackets ([]) or in appropriate columns in tables and figures. The measurements may not be exact equivalents; therefore, each system must be used independently.

Safety and health issues and concerns are beyond the scope of this standard and therefore are not fully addressed herein. Safety and health information is available from other sources, including, but not limited to, ANSI Z49.1, *Safety in Welding, Cutting, and Allied Processes*, and applicable federal, state, and local regulations.

1.1 Base Metals. The grouping of base metals by Base Metal Number (BM No.) in Table B.1 has been made on the basis of metallurgical compatibility, chemical composition, and solderability to decrease the number of required soldering qualifications. The grouping does not imply that base metals may be indiscriminately substituted within the same BM No. without consideration of their applicability. For some materials or combinations of materials, additional tests may be required by the procuring activity or the design engineer.

Base metals are identified by their ASTM,¹ ABS,² or UNS³ designations. Cross reference specifications, listed in the Unified Numbering System for Metals and Alloys opposite a given UNS No., are included in the same BM No. group as the given UNS Number. An American Society of Mechanical Engineers (ASME) designation, which is the same as an ASTM designation preceded by the letter S, is included in the same BM No. group.

¹ ASTM—American Society for Testing and Materials.

² ABS—American Bureau of Shipping.

³ UNS—Unified Numbering System.