

Soldering

Practical skills

Heating the joint, not the solder, and the two common failures.

Educational reference. Electronics soldering; ventilate the area.

1

Clean everything

Solder does not bond to oxide or grease.

2

Tin the tip

A thin coat of solder on the iron transfers heat far better.

3

Heat the joint

Both parts, for a second or two. Not the solder.

4

Feed solder into the joint

It should flow and wet both surfaces.

5

Remove solder, then iron

In that order. Then let it cool undisturbed.

FAILURES

Cold joint — dull, lumpy, weak: not enough heat

Bridged joint — solder spanning two pads: too much solder

A good joint is shiny and concave

Educational reference. Ventilate: flux fumes are an irritant. Wash hands after handling leaded solder.