



Wave soldering profile

Rev. 1 — 22 November 2017

Soldering information
COMPANY PUBLIC

1 Recommended wave soldering profile

Table 1. Limiting values

Profile feature	SnPb eutectic assembly	Pb-free assembly
Average ramp-up rate	~ 200 °C/s	~ 200 °C/s
Heating rate during preheat	1 °C/s to 2 °C/s typical; 4 °C/S maximum	1 °C/s to 2 °C/s typical; 4 °C/S maximum
Final preheat temperature T_s	~ 130 °C	~ 130 °C
Peak temperature T_p	235 °C	260 °C
Time within peak temperature t_p	10 s	10 s
Ramp-down rate	5 °C/s maximum	5 °C/s maximum

