



焊接技术

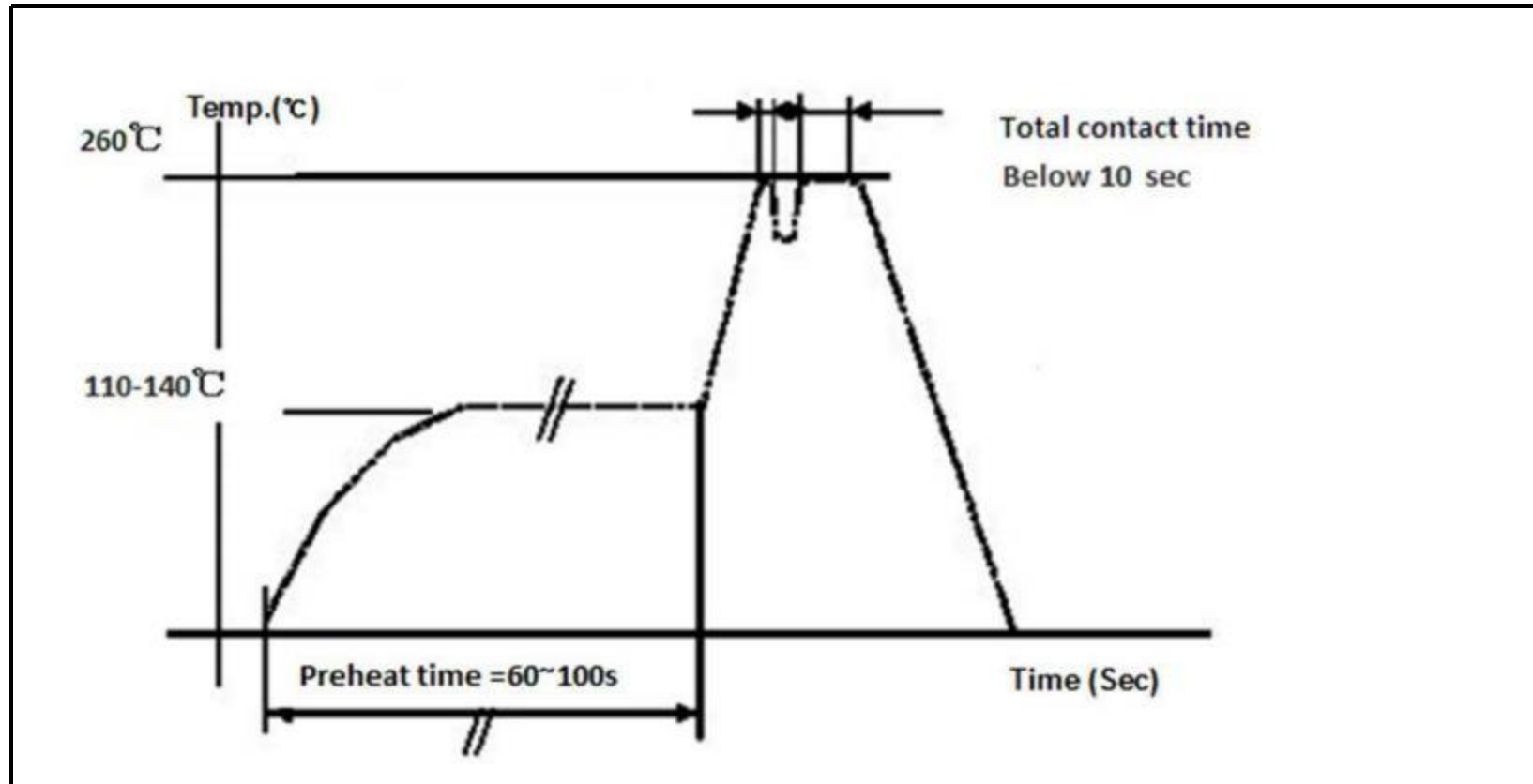
Welding Technique

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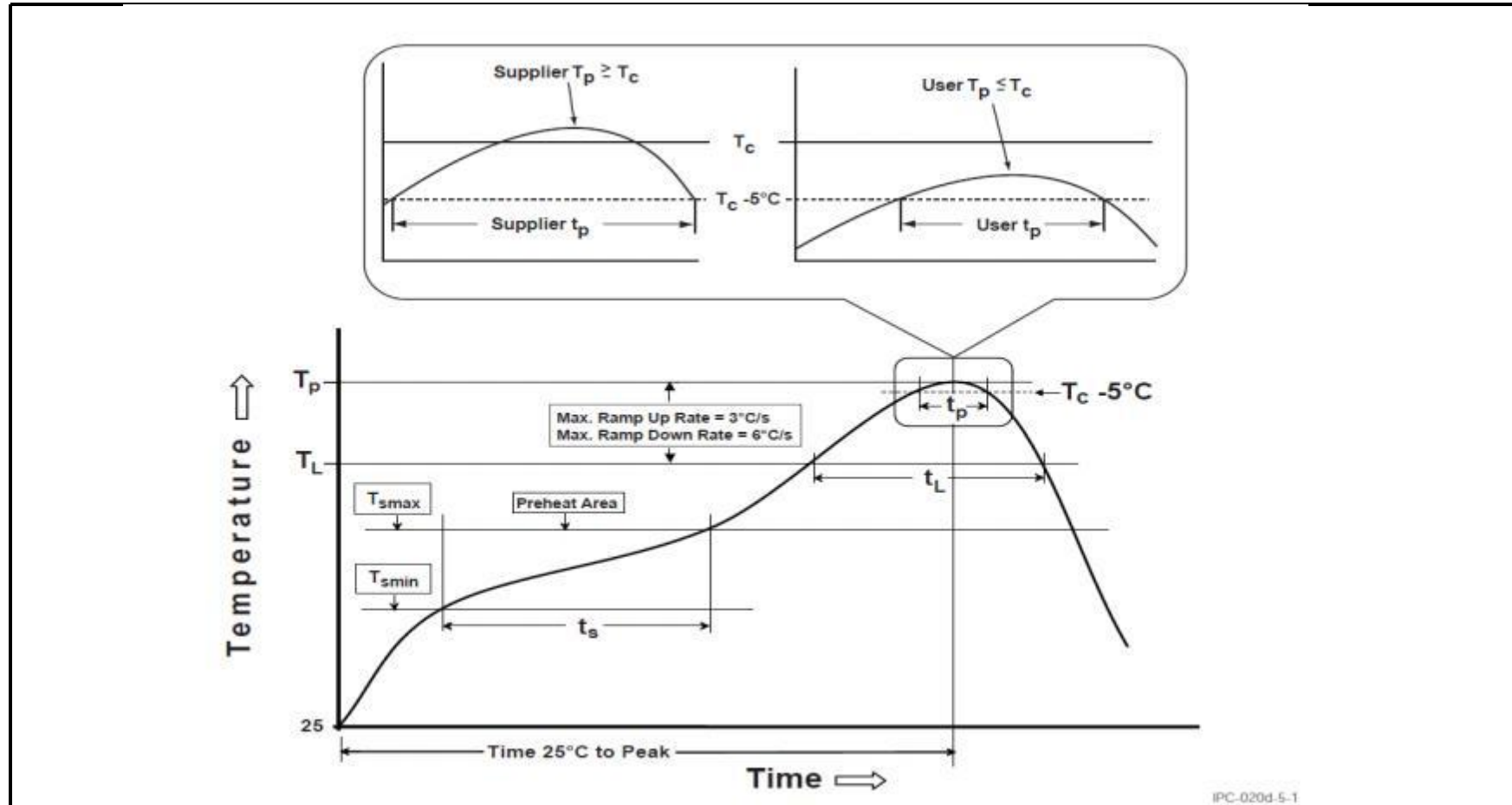
Recommended Soldering Profile for Rectifier Diodes (Pb Free)

a) Wave Soldering Profile



Recommended Soldering Profile for Rectifier Diodes (Pb Free)

b) Reflow Soldering Profile (Pb free Application), refer to IPC/JEDEC J-STD-020



Recommended Soldering Profile for Rectifier Diodes (Pb Free)

Preheat/Soak Temperature Min (T _{smin}) Temperature Max (T _{smax}) Time (ts) from (T _{smin} to T _{smax})	50 . C 200 . C 60-120 seconds
Melting Point of Solder (Sn Ag Cu)	217°C
Ramp-up Rate to 217°C(Melting Point of Solder)	3°C/sec
Time at Temp.>217°C (Melting Point of Solder)	60~150 Sec
Peak Temperature	255±5°C
Time within 5°Cbelow Peak Temp.	20~40 Sec
Cooling Rate	6°C/sec (max)
Time from 25°C to Peak Temp.	8min (max)



Thanks

感谢您的聆听