

Table of Content

Page No.

<i>Table of Content</i>	<i>i</i>
<i>List of Figures.....</i>	<i>v</i>
<i>List of Tables.....</i>	<i>viii</i>
<i>List of Symbols.....</i>	<i>x</i>
<i>List of Abbreviations</i>	<i>xi</i>
<i>Abstract.....</i>	<i>xii</i>
<i>Chapter-1.....</i>	<i>1</i>
<i>1.1.Introduction</i>	<i>2</i>
<i>1.2 History of Solder.....</i>	<i>4</i>
<i>1.3 Types of Soldering</i>	<i>7</i>
1.5.1 Reflow Soldering.....	8
1.5.2 Wave Soldering.....	9
1.5.3 Hand Soldering	11
<i>1.4 Soldering Material</i>	<i>8</i>
<i>1.5 Soldering Method.....</i>	<i>8</i>
1.5.1 Reflow Soldering.....	8
1.5.2 Wave Soldering.....	9
1.5.3 Hand Soldering	11
<i>1.6 Electronic Packing</i>	<i>11</i>
<i>1.7 Application.....</i>	<i>12</i>
<i>1.8 Issue with lead-based solder alloys.....</i>	<i>13</i>
1.8.1 Lead Poisoning.....	13
1.8.2 Adverse Effects of Pb On Human Life.....	14
1.8.3 Adverse Effects Of Pb on Environment And Other Species.....	15
<i>1.9 Source of exposure of lead.....</i>	<i>16</i>
<i>Chapter-2.....</i>	<i>18</i>
<i>2.1 Introduction</i>	<i>19</i>
<i>2.2 Properties of Sn-Pb Solder alloys.....</i>	<i>19</i>
<i>2.3 Role of Pb in Sn-Pb solder</i>	<i>20</i>
<i>2.4 Role of Sn in Sn-Pb solder</i>	<i>21</i>
2.4.1 Crystallographic Properties	21

List of Content

2.4.2 Mechanical Properties	21
2.4.3 Chemical Properties.....	21
2.5 Legislation on lead-based solder alloys.....	22
2.6 Issues with lead-free solder alloys	23
2.7 General criteria for selecting solder alloys	24
2.8 Lead-free solder alloys for electronic packing	24
2.9 True definition of lead-free solder alloys	25
2.10 Lead-free solder alloys as green material	25
2.11 Importance of lead-free solder alloys.....	26
2.11.1 Sn-0.7Cu solder alloys	26
2.11.2 Sn-Zn Solder alloys.....	29
2.11.3 Sn-Bi Solder alloys.....	33
2.11.4 Sn-Ag Solder alloys.....	34
2.11.5 Sn-Ag-Cu.....	36
2.12 Solderability and wettability	44
2.12 Formation of intermetallic	45
2.13 Corrosion of lead-free solder	45
2.13.1 The Fundamentals of the corrosion of lead-free solder alloys.....	45
2.13.2 Formation of corrosion products	46
2.13.3 Researches for corrosion resistance of lead-free solder	47
2.14 Motivation.....	48
2.15 Scope of the Present Work	49
2.16 Objective	50
Chapter-3	52
Experimental Setup & Methodology	52
3.1 Introduction.....	53
3.2 Preparation of lead-free solder alloys.....	53
3.2.1 Raw materials selection	53
3.2.2 Synthesis of Lead-free Solder alloys	53
3.2.3 Melting of Lead-free solder alloys	54
3.3 Microstructure Characterization.....	55
3.3.1 Optical Microstructure.....	55
3.3.2 Scanning Electron Microscope (SEM)	55

3.4 Corrosion behaviour	56
3.4.1 Non-Electrochemical Method	56
3.4.2 Electrochemical corrosion behaviour.....	58
3.4.2.1 Potentiodynamic Polarization.....	59
3.4.2.2 AC Impedance Spectroscopy method.....	63
3.5 Surface Characterization	68
3.5.1 X-Ray Diffraction (XRD).....	68
3.5.2 X-Ray Photoelectron Spectroscopy (XPS).....	68
Chapter-4.....	70
4.1 Introduction	71
4.2 Results and discussion	72
4.2 Microstructure Characterization	72
4.2.2 Immersion Test.....	74
4.2.3 Potentiodynamic Polarization behaviour	77
4.2.3 Electrochemical impedance spectroscopy Analysis	80
4.3 Characterization of corrosion products	83
4.4 Conclusions	89
Chapter-5.....	90
5.1.Introduction.....	91
5.2 Results and Discussion.....	91
5.2.1 Metallographic Analysis of Sn-0.7Cu-xAl solder alloys.....	91
5.2.2 Immersion Test.....	95
5.2.3 Potentiodynamic Polarisation Behaviour	97
5.2.3 Electrochemical Impedance Spectroscopy Analysis.....	101
5.2.4 Characterization of Corrosion Products.	105
5.2.5 Corrosion Mechanism	108
5.3 Conclusions	110
Chapter-6.....	112
6.1 Introduction.....	113
6.2 Results and Discussion.....	114
6.2.1 Metallographic analysis of Sn-9Zn-xCu solder alloys	114
6.2.2 Immersion test	117
6.2.3 Open circuit potential and Potentiodynamic polarisation test	120
6.2.4 Electrochemical impedance spectroscopy Analysis	124

List of Content

6.2.5 Characterization of Corrosion product	129
6.2.6 Corrosion mechanism	136
6.3 Conclusions	138
Chapter-7	140
7.1 Introduction.....	141
7.2 Overall Conclusion	141
7.3 Suggestions for Future Work.....	143
Reference	145
List of Publications.....	172

List of Figures

List of Figure

Fig.3.9 Impedance profile for a simple electrochemical system in the form of Bode plot.....	66
Fig.3. 10 Benchtop X-ray diffraction (BT-XRD)	68
Fig.3. 11 X-ray photoelectron spectroscopy (XPS, Thermo Fisher Scientific)	69
Fig.4.1 Optical microstructures of solder alloys (a) Sn–0.7Cu, (b) Sn–0.7Cu–1In, (c) Sn–0.7Cu–2In, and (d) Sn–0.7Cu–3In.....	73
Fig.4.2 XRD pattern of Sn–0.7Cu–xIn solder alloys.....	74
Fig.4.3 Weight change of Sn-0.7Cu-xIn alloys after immersion in 3.5 wt.% NaCl at room temperature	76
Fig.4.4 Corrosion rate of Sn-0.7Cu-xIn alloys during static immersion in 3.5 wt.% NaCl at room temperature	77
Fig.4.5 Potentiodynamic polarization curves of Sn–0.7Cu–xIn solder alloys in 3.5wt.% NaCl solution.....	80
Fig.4.6 (a) Nyquist and (b) Bode plots of solder alloys in 0.5M NaCl solution.....	82
Fig.4.7 Electrical circuit models. (a) For Sn-0.7Cu alloy; (b) For Sn-0.7Cu alloys with Indium addition	83
Fig.4.8 Corrosion Mechanism of Solder alloys	86
Fig.4.9 Surface morphology of alloys after corrosion in 3.5wt.% NaCl. (a) Sn- 0.7Cu; (b) Sn-0.7Cu-1In; (c) Sn-0.7Cu-2In; (d) Sn-0.7Cu-3In	86
Fig.4.10 EDX patterns of corrosion products. (a) Sn-0.7Cu; (b) Sn-0.7Cu-In; (c) Sn-0.7Cu-2In; (d) Sn-0.7Cu-3In.	88
Fig.4.11 XRD patterns of corrosion products. (a) Sn-0.7Cu; (b) Sn-0.7Cu-1In;	88
Fig.5.1BSE Microstructure of non-corroded of Sn-0.7Cu-xAl solder alloys (a) x=0, (b) Sn-0.7Cu-Al (c) Sn–0.7Cu–2Al, and (d) Sn–0.7Cu–3Al.	93
Fig.5.2 XRD pattern of the non-corroded Sn–0.7Cu–xAl lead-free solder alloys.....	94
Fig.5.3 Weight change of Sn-0.7Cu-xAl alloys after immersion in 3.5wt % NaCl at ambient temperature	96
Fig.5.4 Corrosion rate of Sn-0.7Cu-xAl alloys static immersion in 3.5 wt.% NaCl at ambient temperature	97
Fig.5.5 Potentiodynamic polarization curve of lead-free Sn-0.7Cu-xAl solder alloys.....	100

Fig.5.6 Nyquist (a) and Bode plots (b,c) of Sn-0.7Cu-xAl solder alloys in 0.5M NaCl Solution.....	104
Fig.5.7 Electric circuit models for fitting solder alloys (a) Sn-0.7Cu and (b) Sn-0.7Cu-xAl.....	104
Fig.5.8 Surface morphology (SEM) of corroded surfaces of solder alloys (a) x=0, (b) x=1, (c) x=2 and (d) x=3	106
Fig.5.9 EDX of corrosion products of Sn-0.7Cu-xAl solder alloys (a) x=0, (b) x=1, (c) x=2 and (d) x=3.....	107
Fig.5.10 XRD pattern of corroded Sn-0.7Cu-xAl.....	108
Fig.5.11 Corrosion Mechanism of Solder alloys	110
Fig.6.1 Optical Microstructure of non-corroded Sn-9Zn-xCu alloys: (a) x=0, (b) x=1, (c) x=2 and (d) x=3	116
Fig.6.2 SEM Microstructure of non-corroded Sn-9Zn-xCu alloys: (a) x=0, (b) x=1, (c) x=2 and (d) x=3	116
Fig.6.3 XRD patterns of non-corroded Sn-9Zn-xCu alloys.....	117
Fig.6.4 Weight change of Sn-9Zn-xCu alloys after immersion in 0.5M NaCl at ambient temperature	119
Fig.6.5 Corrosion rate of Sn-9Zn-xCu alloys static immersion in 0.5M NaCl at ambient temperature	120
Fig.6.6 OCP of Sn-9Zn-xCu alloys at 3600 seconds.....	123
Fig.6.7 Potentiodynamic polarization curves of Sn-9Zn-xCu alloys in 3.5 wt.% simulated NaCl.....	124
Fig.6.8 Nyquist of Sn-9Zn-xCu solder alloys in 3.5 wt.% simulated NaCl.	127
Fig.6.9 Bode plots (b,c) of Sn-9Zn-xCu solder alloys in 3.5 wt.% simulated NaCl.....	128
Fig.6.10 Electrical circuit models of Sn-9Zn-xCu (a)x=0,(b) x=1,2&3 wt.%.....	128
Fig.6.11 SEM-EDX analysis of the corroded surface of Sn-9Zn-xCu solder alloys.....	131
Fig.6.12 XRD pattern of the corroded surface of Sn-9Zn-xCu solder alloys.	133
Fig.6.13 The XPS profiles of Sn-9Zn-xCu alloys after corrosion tests.	136
Fig.6.14Corrosion Mechanism of Sn-9Zn-xCu alloys(a)passive film breakage, (b) Initiation pits (c) growth of pits	138

List of Tables

	Page No.
Table 2.1 Corrosion performances of multi-component lead-free solder alloys in various corrosive mediums.....	41
Table2.2 Binary lead-free solder alloys eutectic composition and temperature.....	44
Table3.1 Purity and Supplier of the solder alloys.....	53
Table3.2 Corrosion penetration rate parameters unit.....	57
Table 4.1 Weight change of Sn-0.7Cu-xIn alloys after immersion in 3.5wt.% NaCl Solution.....	75
Table 4.2 Corrosion rate of Sn-0.7Cu-xIn solder alloys immersion in 0.5M NaCl Solution.....	76
Table 4.3 Polarization parameters for Sn-0.7Cu-xIn alloys in 0.5M NaCl solution	80
Table 4.4 Fitting parameters of EEC for Sn-0.7Cu-xIn alloys in 0.5M NaCl solution	83
Table 5.1 EDS analysis Results of areas 1-10 in fig. 5.1	94
Table 5.2 Weight change of Sn-0.7Cu-xAl alloys after immersion in 3.5wt.% NaCl Solution.....	96
Table 5.3 Corrosion rate of Sn-0.7Cu-xAl solder alloy immersion in 0.5M NaCl.....	97
Table 5.4 Summary of Polazition parameters for Sn-0.7Cu-xAl lead-free solders alloys	101
Table 5.5 Parameters of the Equivalent electrical circuit (EEC) model.....	104
Table 6.1 Weight change of Sn-9Zn-xCu alloys after immersion in 0.5M NaCl solution.....	118
Table 6.2 Corrosion Rate of Sn-9Zn-xCu after immersion in 0.5M NaCl solution	119

Table 6.3 Polarization parameteries for Sn-9Zn-xCu alloys in 3.5 wt.% simulated NaCl	124
Table 6.4 Fitting parameter of EEC for Sn-9Zn-xCu solder alloys in 3.5 wt.% simulated NaCl	129