

Weller®

Renewing An Oxidized Soldering Tip

The oxidation of the soldering tip is a growing issue due to the increased use of lead free solders. The fluxes typically used with lead free will aggressively attack the iron plating of a tip, resulting in decreased tip life. Follow these steps to help extend the life of your tips:

- Use a [Weller WPB1 polishing bar](#) to remove surface oxides. You may need to follow this procedure frequently if you are using fine point tips. While the tip is cold (never use the WPB1 while the tip is heated), lightly rub the polishing bar on the tip until clean. If the surface oxide is heavy, more pressure may be needed.
- The tip should be immediately re-tinned as soon as it reaches the melting point of the alloy being used in the application.
- Tip Tinner's may also be used to restore the tip, especially when surface contamination (darkened appearance) is present.

Key Points to Remember:

1. Always keep the tip coated with a thin layer of solder.
2. Use fluxes that are as mild as possible but are still capable of properly cleaning the tip and the metals being soldered.
3. Keep the soldering iron temperature as low as possible while maintaining enough temperature to quickly solder a joint (5 seconds maximum for Eutectic or low melting point alloys / 8 seconds maximum for Lead Free alloys)
4. Use as large of a tip as possible to perform the application for maximum heat transfer.
5. Use a tip with the shortest reach possible for the best thermal performance.

Weller WPB1 Polishing Bar for Cleaning Soldering Tips



Product Features:

- Polishing bar cleans and renews soldering tips
- Removes plastic resins, oxidation, silicone grease from tip
- Re-tin tip after use to prevent oxidation