Preparation:-

1. Solder tip is cleaned by rubbing and clean with wet sponge
2. Apply flux on the pads to be soldered to remove preformed oxides

Soldering Procedure

1. When the soldering iron bit is adequately hot, apply a little solder on the flattened tip and wipe it off with a piece of damp cloth or sponge. The solder will form a thin layer on the bit.
2. Heat up the joint with the bit, It is important that the surfaces to be soldered together are brought to the same temperature and continue heating while applying solder. (The molten solder flows quickly from the bit onto both parts to be joined. It is important to use the right amount of solder. )
3. Remove the iron and allow the joint to cool. (During the cooling period, if the joint is disturbed, it may become dry and create serious problems in the working of the circuit. Sometimes it becomes very difficult to trace out this defect.)

Desoldering Procedure:-

1. Using a desoldering braid or wick :- The desoldering braid, made from fine copper, draws molten solder up into the braid. To desolder using it, place a short length of the wick on the point to be desoldered.
2. Place the hot bit of the soldering iron over the wick and press.
3. The bit subsequently melts the solder and the molten lead is drawn up into the braid.