

CONTENTS

Title Page	i
Certificate of Approval	ii
Certificate	iii
Acknowledgements	iv
Declaration	v
List of Symbols	vi
List of Abbreviations	ix
Abstract	xi
Contents	xii
List of Tables	xvi
List of Figures	xviii
Chapter 1 Introduction	1-5
1.1 Background	1
1.2 Environmental Concerns	1
1.3 Current Scenario	2
1.4 Objectives	4
1.5 Contributions	5
1.5 Research Plan and Thesis Outline	5
Chapter 2 Literature Review	6-43
2.1 Introduction	6
2.2 Microelectronic packaging	6
2.2.1 Packaging materials and electrochemical technology	8
2.2.2 Classification of packaging devices	8
2.2.2.1 Chip level packaging - Level 1	9
2.2.2.2 Board level packaging - Level 2	10
2.3 Soldering science and technology in microelectronics	11
2.3.1 Solder	11
2.3.1.1 Conventional solders	11
2.3.1.2 Replacement of Pb	12
2.3.1.3 The lead free definition and regulations	13
2.4 Metallurgical overview of Sn	14
2.4.1 Lead free Sn alloys	14
2.4.2 Requirements for lead free solder alloys	14
2.4.3 Solder reactions	15
2.4.4 Intermetallic compounds and whisker growth	16
2.4.5 Reactions to copper substrates	16
2.5 Synthesis routes and technologies for solder fabrication	18
2.5.1 Electrodeposition	18
2.5.2 General aspect of electrodeposition	18
2.5.3 Cathodic and anodic reactions	20

	2.5.4 Electrode reactions	20
	2.5.5 Polarization and overpotential	20
	2.5.6 Pulse current electrodeposition	23
	2.5.7 Electrolyte conductivity	24
2.6	Electrodeposition of Sn and Sn alloys	25
	2.6.1 Electrodeposition of Sn	25
	2.6.1.1 Sodium stannate baths	25
	2.6.1.2 Stannous sulfate baths	26
	2.6.1.3 Stannous chloride baths	26
	2.6.1.4 Methanesulfonic acid baths	27
	2.6.1.5 Pyrophosphate baths	27
	2.6.2 Electrodeposition of Sn alloys	27
2.7	Electrodeposition process parameters	28
	2.7.1 Current density	29
	2.7.2 pH	29
	2.7.3 Temperature	30
	2.7.4 Additives	30
	2.7.5 Duty cycle and frequency	32
	2.7.6 Effect of agitation	33
2.8	Pulse co-electrodeposition	33
	2.8.1 Composite co-electroplating of solders	34
	2.8.2 CeO ₂ as a reinforcement	35
2.9	The co-electrodeposition mechanisms	36
2.10	The key properties in the development of nanocomposite solders	38
	2.10.1 Density	39
	2.10.2 Electrical conductivity	39
	2.10.3 Melting point	39
	2.10.4 Wettability/solderability	40
	2.10.5 Microhardness	40
	2.10.6 Wear and friction behavior	41
	2.10.7 Electrochemical Corrosion	41
	2.10.8 Residual stress measurement	42
Chapter 3	Experimental Procedure	44-60
3.1	Materials and methods	44
	3.1.1 Plating bath preparation	44
	3.1.2 Substrate preparation	46
	3.1.3 Synthesis of reinforcement	47
	3.1.4 Pulse electrodeposition	48
3.2	Characterization details	50
	3.2.1 X-ray diffraction (XRD)	50
	3.2.2 Scanning electron microscopy (SEM)	51
	3.2.3 Transmission electron microscopy (TEM)	51
3.3	Property evaluation	52
	3.3.1 Microhardness	52
	3.3.2 Surface profilometry	52

3.3.3	Ball on disc wear and friction monitor	53
3.3.4	Electrochemical corrosion behaviour	55
3.3.5	Electrical resistivity measurements	56
3.3.6	Differential scanning calorimetry	58
3.3.7	Density	58
3.3.8	Residual stress measurement	59
3.4	Sample designations	60
3.5	Plating baths designations	60
Chapter 4	Results and Discussion	61-165
4.1	A study on pulse electrodeposition of pure tin from aqueous plating baths	61
4.1.1	Plating baths	61
4.1.2	Cathodic current efficiency	64
4.1.3	Microstructural characterization of the as deposited tin coatings	65
4.1.3.1	SEM	65
4.1.3.2	XRD	67
4.1.4	Microstructure of the aged coatings	70
4.1.5	Summary	71
4.2	Effect of pulse electrodeposition parameters on the surface morphology of tin coatings plated from sulfate baths	72
4.2.1	Effect of current density on Sn electrodeposition	72
4.2.1.1	XRD	72
4.2.1.2	SEM	73
4.2.2	Effect of bath pH on Sn electrodeposition	75
4.2.2.1	XRD	75
4.2.2.2	SEM	79
4.2.3	Effect of concentration of additive (Triton X-100)	80
4.2.3.1	XRD	80
4.2.3.2	SEM	84
4.2.4	Effect of duty cycle on Sn electrodeposition	86
4.2.4.1	XRD	87
4.2.4.2	SEM	89
4.2.5	Effect of pulse frequency on Sn electrodeposition	91
4.2.5.1	XRD	92
4.2.5.2	SEM	93
4.2.6	Effect of bath temperature	95
4.2.6.1	XRD	95
4.2.6.2	SEM	97
4.2.7	Effect of stirring rate (Magnetic Stirring)	98
4.2.7.1	XRD	98
4.2.7.2	SEM	100
4.2.8	Sensitivity of the variables - Grain size distribution	102
4.2.9	Summary	102
4.3	Development of lead free pulse electrodeposited Sn/CeO ₂ and near eutectic Sn-Ag/CeO ₂ lead free solder nanocomposites	105

4.3.1	Synthesis of the CeO ₂ nanopowders	105
4.3.2	Characterisation of CeO ₂ nanopowders	107
4.3.2.1	XRD	108
4.3.2.2	Particle size distribution	110
4.3.2.3	SEM	111
4.3.2.4	TEM	111
4.3.2.5	Summary	112
4.3.3	Synthesis of Sn/CeO ₂ nanocomposite	113
4.3.4	Characterisation of Sn/CeO ₂ composite	116
4.3.4.1	XRD	116
4.3.4.2	SEM	117
4.3.4.3	TEM	120
4.3.5	Synthesis of Sn-Ag/CeO ₂ nanocomposite	121
4.3.6	Characterisation of Sn-Ag/CeO ₂ composite	125
4.3.6.1	XRD	125
4.3.6.2	SEM	125
4.3.6.3	TEM	130
4.3.6.4	Summary	131
4.4	Property evaluation of the developed lead free pulse electrodeposited Sn/CeO ₂ and near eutectic Sn-Ag/CeO ₂ lead free solders nanocomposites	133
4.4.1	Microhardness	133
4.4.2	Density measurements	134
4.4.3	Melting behavior	135
4.4.4	Resistivity measurements	138
4.4.5	Electrochemical corrosion behavior	141
4.4.5.1	Tafel plot	142
4.4.5.2	Microstructures of corroded samples	146
4.4.6	Wear	150
4.4.6.1	Surface roughness and microhardness	151
4.4.6.2	Wear penetration depth	151
4.4.6.3	Volume loss and wear rate	153
4.4.6.4	COF	154
4.4.6.5	Worn surface morphology	156
4.4.7	Residual stress measurement	161
Chapter 5	Summary and Conclusions	165-169
	References	170-185
	Recommendations for Future Work	186
	Curriculum Vitae, Publications and Conference Presentations	187