

TECHNICAL SPECIFICATION

Master Alloy : S-520

Suitable karatage :	14K (Easy)	Colour :	Yellow
Nickel Content :	16.38 %	Silver Content :	32.10 %
Palladium Content :	0 %	Platinum Content :	0 %
Applications :	Making 14K Easy solder for yellow gold		
Advantages :	Ease to use, high fluidity, less porosity		

Recommended Application Parameters :

Suggested Gold Content in Solder : 58.33%

Alloy Melting Temperature : 14K / 740 °C

Technical Advice:

1. The melting temperature of the solder varies according to the alloy composition.
2. The recycled alloy should not be used for soldering purpose.
3. Appropriate amount of flux should be added during soldering.
4. The metal pieces should be well designed for soldering.
5. Two common methods of soldering are listed as reference:
 - a. Appropriate amount of solder was put on the joint, heat up to the joint until the solder melts and flows into the joint.
 - b. The fluxed joint is heated to appropriate temperature, then put the solder to the joint for soldering.

Remarks: The information is for your reference only. The parameters should be adjusted according to the particular casting conditions. If you have any technical questions, please do not hesitate to contact us.

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