

TECHNICAL SPECIFICATION

Master Alloy : S-589

Suitable karatage : 14K (Easy)	Colour : Pink
Nickel Content : 0 %	Silver Content : 4.0 %
Palladium Content : 0 %	Platinum Content : 0 %
Applications : Making 14-18K Easy solder for pink gold	
Advantages : Ease to use, high fluidity, less porosity	

Recommended Application Parameters :

Suggested Gold Content in Solder : 14K, 58.33%; 18K, 75%

Alloy Melting Temperature : 14K / 843 – 849 °C; 18K / 845-849 °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.

Main Office:
Heraeus Ltd.
 Heraeus Technology Centre
 30 On Chuen Street, On Lok Tsuen
 Fanling, N.T., Hong Kong
 Tel : (852) 2675 1200
 Fax: (852) 2682 3220

總公司:
賀利氏有限公司
 香港新界粉嶺安樂村
 安全街 30 號
 賀利氏科技中心
 電話 : (852) 2675 1200
 傳真 : (852) 2682 3200

Hunghom Sales Office:
Heraeus Ltd.
 Rm. 2111-3, Peninsula Square
 18 Sung On Street, Hunghom
 Kowloon, Hong Kong
 Tel : (852) 2159 5960
 Fax: (852) 2773 1090

紅磡營業部:
賀利氏有限公司
 香港九龍紅磡
 崇安街 18 號
 半島廣場 2111-3 室
 電話 : (852) 2159 5960
 傳真 : (852) 2773 1090