

Technical Specifications

Technical Specification / Cadmium-Free Solders				
CADIUM-FREE SOLDERS				
YELLOW SOLDERS				
<u>DESCRIPTION</u>	<u>ALLOY</u>	<u>ITEM #</u>	<u>MELTING TEMPERATURE</u>	<u>FLOW TEMPERATURE</u>
8 Karat Y Easy	137	A0037	1250°F (677°C)	1325°F (718°C)
8 Karat Y Medium	315	A0013	1315°F (713°C)	1360°F (738°C)
8 Karat Y Hard	3147	---	1375°F (746°C)	1400°F (760°C)
10 Karat Y Easy	529	A0262	1210°F (654°C)	1345°F (729°C)
10 Karat Y Medium	534	A0263	1360°F (738°C)	1390°F (754°C)
10 Karat Y Hard	315	A0114	1400°F (760°C)	1435°F (779°C)
14 Karat Y Easy	535	A0264	1295°F (702°C)	1350°F (732°C)
14 Karat Y Medium	142	A0428	1345°F (729°C)	1415°F (768°C)
14 Karat Y Hard	7133	A0744	1450°F (788°C)	1475°F (802°C)
18 Karat Y Easy	379	A0779	1320°F (716°C)	1385°F (752°C)
18 Karat Y Medium	335	A0846	1370°F (743°C)	1421°F (772°C)
18 Karat Y Hard	189	A0889	1445°F (785°C)	1500°F (816°C)
WHITE SOLDERS				
<u>DESCRIPTION</u>	<u>ALLOY</u>	<u>ITEM #</u>	<u>MELTING TEMPERATURE</u>	<u>FLOW TEMPERATURE</u>
6 Karat W Hard	7206	A0726	1340°F (727°C)	1440°F (782°C)
8 Karat W Easy	7148	A0727	1250°F (677°C)	1350°F (732°C)
8 Karat W Hard	344	A0044	1365°F (740°C)	1435°F (779°C)
10 Karat W Easy	7147	A0736	1250°F (677°C)	1350°F (732°C)
10 Karat W Hard	7146	A0738	1325°F (718°C)	1450°F (788°C)
14 Karat W Easy	6713	A0640	1225°F (663°C)	1325°F (718°C)
14 Karat W Medium	7259	A0745	1350°F (732°C)	1375°F (746°C)
14 Karat W Hard	7260	A0746	1450°F (788°C)	1500°F (816°C)
18 Karat W Medium	7261	A0747	1325°F (718°C)	1450°F (788°C)
18 Karat W Hard	7258	A0748	1500°F (816°C)	1600°F (871°C)
18 Karat W Hard	6691	A0750	1525°F (829°C)	1625°F (885°C)