



SOLDER FLUSH GOLD SHEET



Solder flush sheet is available in 10K or 14K yellow gold and 14K white gold, as a combined 88% substrate / 12% solder flat product up to 2" wide. Manufacturers can use this unique product to furnace solder jewellery assemblies without the need to manually apply solder to the parts. This results in considerable time saving and uniform soldering. The solder cladding is continuous across the 10K or 14K gold base and contains the same proportional amount of gold as the base, therefore not diluting the final karat quality. Solder flush sheet is available in standard alloy and heat treatable alloy.



Firing Information

Solder flush sheet items can be bonded using either a furnace or a torch. In both cases a reducing atmosphere and clean surfaces are recommended. When using a furnace, final parameters are based on the specifics of the furnace used (thermal profile), the mass of pieces loaded as well as the time (and temperature) of pieces loaded. To get the solder to run, parameters must be set to allow sufficient time at temperatures above the solder liquidus. To avoid excessive grain growth in the base, this same set of parameters should involve temperatures well below the base solidus.



	Base Solidus	Solder Liquidus
10K Yellow Std. Alloy	881°C / 1618°F	764°C / 1410°F
14K Yellow Std. Alloy	870°C / 1598°F	776°C / 1430°F
14K Yellow HTA®	845°C / 1553°F	776°C / 1430°F
14K White**	940°C / 1790°F	776°C / 1430°F

** 14K White has a yellow solder but a white base

Note: Imperial's solder are cadmium-free.

Imperial's Precious Metals
Inspiring Trust

We are always interested in hearing your opinion of how our products have performed for your application. Also, contact us should you have any questions, comments or require information regarding Imperial's wide range of gold, silver and platinum products.



IMPERIAL SMELTING AND REFINING CO. OF CANADA LTD. — WWW.IMPERIALPRODUCTS.COM

TORONTO HEAD OFFICE & PLANT: 451 Denison St., Markham, ON L3R 1B7 Canada
Phone 905-475-9566 • Toll-Free 1-800-263-1669

VANCOUVER: 602 West Hastings Street, Suite 614, Vancouver, BC V6B 1P2
Phone 604-685-2344 • Toll-Free 1-800-663-0455

RHODE ISLAND: 40 Bay State Ave., Warwick, RI 02888
Phone 401-739-5060 • Toll-Free 1-877-795-5060