



# YELLOW KARAT GOLD SOLDER FILLED WIRE



Solder filled wire is specially designed for chain manufacturers who prefer the convenience of furnace soldering without the tedious process of "powdering". The solder filled wire is supplied at soft temper so that the chain can easily be formed before firing. The solder core is continuous within the 10K or 14K gold jacket and contains the same proportional amount of gold as the jacket, therefore not diluting the final karat quality of the chain.

## Firing Information

It is recommended that the formed chain is fired under reducing atmosphere. Final furnace parameters are based on specifics of the furnace used (i.e. its thermal profile), the amount of formed chain loaded as well as time (belt speed) and temperature. Trials may be needed to achieve the optimum firing parameters for your specific application.



To get the solder to run, parameters must be set to allow sufficient time at the temperature above the solder's liquidus. To avoid excessive grain growth in the jacket during firing, this same set of parameters should involve temperatures well below the jacket's solidus.



	<b>Base Solidus</b>	<b>Solder Liquidus</b>
10K Yellow	773°C / 1423°F	890°C / 1636°F
14K Yellow	778°C / 1432°F	880°C / 1616°F

**Note:** Imperial's solder are cadmium-free.

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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.



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