

FG18

**SOLDERING
ALLOY
HARD 18kt**

GENERAL INFORMATION

Carats:	18 kt
Colour:	yellow
Specific usage:	soldering alloy for yellow gold

DIRECTIONS FOR SUGGESTED USE

Melting temperature in 18kt:	1020° C, pouring at 960°C
Ingot-mould temperature:	70° C
Cooling of ingots:	quick in lukewarm water (about 40° C)
Annealing:	520° C for 20 minutes followed by a quick cooling in hot water (40° C min.)
Flowing temperature:	780° C

IMPORTANT NOTICE:

Use vertical ingot molds closed on all sides. Open ingot molds should not be used, to avoid cracking during rolling.

HINTS

- ❖ Recommended Pandora Alloys ready-to-use solders 18kt soft, medium and hard available in plates and sticks for yellow gold, red gold and white gold

The above directions are only indicative. Strong variations to the above data are possible, depending on personal experience. Please, do not hesitate to contact us for further information.