

# SALDAG1

**SOLDERING  
ALLOY FOR  
SILVER**

## GENERAL INFORMATION

Color: silver white  
Specific usage: soldering alloy for silver

## DIRECTIONS FOR SUGGESTED USE

Ratio: 65% (soft) - 70% (medium) - 85% (hard)  
silver + SALDAG1  
depending on the flowing temperature needed

Casting temperature: 950° C

Flowing temperature: 65%: 690° C  
70%: 730° C  
85%: 800° C

Ingot-mould temperature: 150° C

Cooling of ingots: quick in lukewarm water (about 40° C)

Annealing: 520° C for 20 minutes

### **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 silver solders: TA (soft), MA (medium), FA (hard)

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.