

Table of Flux and Solder Combinations

Solder has a starting point and a temperature span while in use. It can vary according to composition and supplier. Please take my Approximate Work Temperature as a good guess where the melting sets in. If you are in doubt, please contact your Refiner or Supplier. More and more suppliers are changing their composition away from cadmium as a flow temperature reducing component of the solder. These solders are made with Zinc and their

flow behaviour and colour is not as advantageous as the cadmium varieties.

Generally you need to remember, Fluxes based on white pasty Borax mixes are used for the lower work temperatures below (730 Celsius or 1350 Fahrenheit) whereas the green Fluorite flux is used for temperatures higher than these numbers up to 820 C or 1510 F.

Solders	Fine Gold Content 1/1000	Approximate Work Temperature in Celsius or Fahrenheit	Recommended Flux
14k Yellow Gold Hard Solder	585/1000	780 C / 1436 F	Fluorite – green liquid flux
14k Yellow Gold Medium Solder	585/1000	720 C / 1328 F	Borax based pasty compositions
14k Yellow Gold Easy Solder	585/1000	670 C / 1238 F	Borax based pasty compositions
18k Yellow Gold Hard Solder	750/1000	820 C / 1508 F	Fluorite – green liquid flux
18k Yellow Gold Medium Solder	750/1000	750 C / 1382 F	Fluorite – green liquid flux
18k Yellow Gold Easy Solder	750/1000	700 C / 1292 F	Borax based pasty compositions
14k White Gold Hard Solder	585/1000	800 C / 1472 F	Fluorite – green liquid flux
14k White Gold Medium Solder	585/1000	770 C / 1418 F	Fluorite – green liquid flux
14k White Gold Easy Solder	585/1000	740 C / 1364 F	Fluorite – green liquid flux
18k White Gold Hard Solder	750/1000	840 C / 1554 F	Fluorite – green liquid flux
18k White Gold Medium Solder	750/1000	820 C / 1508 F	Fluorite – green liquid flux
18k White Gold Easy Solder	750/1000	800 C / 1472 F	Fluorite – green liquid flux
	Fine Silver Content approximate!		
Silver Hard Solder	680/1000	730 C / 1346 F	Borax based pasty compositions
Silver Medium Solder	640/1000	700 C / 1292 F	Borax based pasty compositions
Silver Easy Solder	600/1000	670 C / 1238 F	Borax based pasty compositions