

# Solders

Choose the perfect combination

SOLDER CATEGORY	description of solder	working temperature °C	flow characteristics	recommended flux
<b>COLOURED GOLD SOLDERS (YELLOW)</b>				
containing cadmium	333 L1	700	hard	h
	333 L3	640	easy	h
	375 L2	690	medium	h
	375 L3	650	easy	h
	585 L1	780	hard	t/B
	585 L2	720	medium	h/t
	585 L3	670	easy	h
	750 L1	820	hard	B
	750 L2	750	medium	t/B
	750 L3	700	easy	h/t
	750 L1s	810	hard	B
<b>COLOURED GOLD SOLDERS (RED)</b>				
containing cadmium	585 L3r	740	easy	t/B
	750 L1r	800	hard	B
	750 L2r	760	medium	t/B
<b>COLOURED GOLD SOLDERS (YELLOW)</b>				
cadmium free	333 L1 cdf	720	hard	t
	333 L3 cdf	680	easy	h/t
	375 L1 cdf	750	hard	t
	585 L1 cdf	800	hard	B
	585 L2 cdf	760	medium	t
	585 L3 cdf	730	easy	t
	750 L1 cdf	815	hard	B
	750 L2 cdf	780	medium	t/B
	750 L3 cdf	750	easy	t
	917 L1 cdf	880	hard	B
	<b>COLOURED GOLD SOLDERS (RED)</b>			
cadmium free	585 L1r cdf	800	hard	B
<b>WHITE GOLD SOLDERS</b>				
cadmium free/containing nickel	585 WL1 Ni	800	hard	B
	750 WL1 Ni	840	hard	B
	830 WL1 Ni	850	hard	B
<b>WHITE GOLD SOLDERS</b>				
cadmium free/nickel free	585 WL3 Pd	780	easy	B
	750 WL3 Pd	800	easy	B
<b>PLATINUM SOLDERS</b>				
cadmium free	Pt Lot L1	1400	hard	Pt-Clean
	Pt Lot L2	1240	medium	Pt-Clean
	Pt Lot L3	1110	easy	Pt-Clean
<b>PALLADIUM SOLDERS</b>				
cadmium free	Pd Lot L1	1110	hard	Pt-Clean
	Pd Lot L2	980	medium	Pt-Clean
	Pd Lot L3	730	easy	Pt-Clean
<b>DECORATIVE SILVER SOLDERS</b>				
cadmium free	750 Ag L1	770	hard	t
	675 Ag L1	730	hard	h/t
	600 Ag L2	710	medium	h
	600 Ag L3	680	easy	h
	550 Ag L3	660	easy	Oxynon

Please refer to our safety data sheets when using these products.