

Precious Metal Services Technical Data Soldering (Solder Paste)

Data Sheet # PMS1112SP

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Preparation

1. The piece to be soldered should have a clean surface and be free from oxides which can be achieved by emerying or pickling.
2. Clean the piece in an ultrasonic cleaner to remove all traces of grease, oils and polishing compounds.
3. Manipulate the piece so that it has a neat, aligned, close fitting seam. Preparing a seam with a small gap will produce the strongest joint.
4. The piece is ready for soldering.

Fluxes

Solder Paste has flux as part of its composition and generally it is not necessary to apply extra flux when soldering. It may however, be beneficial to apply a flux coating on large pieces where there is a need to apply heat for longer periods of time.

Needle Tips

These are screw on tips which fit the syringe applicators. As Solder Paste does not dry out, the tip can be removed from the syringe when empty and placed on the replacement syringe (same carat and type). Choose a needle tip by the diameter of the needle. This is dependent on either the type of paste to be used or the type of soldering to be done (fine or heavy work). The tips are ordered by colour and the different colours represent different diameter needles. **PK** = pink 0.60mm (all types of paste), **PU** = purple 0.50mm (all types of paste), **BL** = blue 0.40mm (all Gold pastes – too fine for Silver) and **OR** = orange 0.30mm (18ct only - very fine work).



PETER W BECK PTY LTD

14 Duncan Court, Ottoway Park, South Australia 5013 Telephone +61 8 8440 3399 Toll Free 1800 888 590 Fax +61 8 8447 1144

Email preciousmetals@pwbeck.com.au www.pwbeck.com.au

A.B.N 37 008 011 550

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Soldering

1. Apply Solder Paste to the seam to be soldered before it is heated. Never apply heat to the needle or approach a hot piece with the needle as it will cause the needle to clog. Practice will allow you to measure the appropriate quantity.
2. Heat the piece to be soldered applying heat to the general joint area. Avoid applying intense heat directly to the paste and the joint itself.
3. Remove the heat as soon as the solder flows.
4. Remove any flux residue. This can normally be achieved using water and a brush or emery
5. Pickle to remove any oxides.

* Handy Tip: Solder Paste is very user friendly and if used regularly it can be stored on your workbench. If you are an infrequent user we suggest that you store your syringe in the refrigerator. You can find more general information on Soldering on page 145 of the Peter W Beck Precious Metal Services Catalogue.

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