

Soldering Info Sheet

METAL ALLOYS IN SILVER SOLDER

Solder Type	Silver (Ag)	Copper (Cu)	Zinc (Zn)	Tin (Sn)
Extra Easy	56%	22%	17%	5%
Easy	65%	20%	15%	-
Medium	70%	20%	10%	-
Hard	75%	22%	3%	-

SILVER SOLDER MELT & FLOW TEMPERATURES

Solder Type	Melt	Flow
Extra Easy	1145F/618C	1205F/652C
Easy	1240F/671C	1325F/718C
Medium	1275F/690C	1360F/738C
Hard	1365F/741C	1450F/788C

TEMPERATURES

Sterling Silver	Use For	Temperatures
Molten	Casting, beading	1761F/951C
Melting	Fusing, Reticulation	1640F/893C - 1600F/893C
Enamelling/Extra Hard Solder	repair, enamelling	1490F/810C
Hard Solder	First, general soldering	1450F/788C
Medium Solder	general, intermediate	1360F/738C
Easy Solder	general, intermediate & final	1325F/719C
Extra Easy Solder	final soldering	1207F/653C
Annealing	softening metal	1200F/649C - 1100F/593C



FURTHER READING:

[A guide to simple soldering](#)

[Common Soldering Problems & Solutions For Jewellers](#)