

TECHNICAL DATA SHEET

W925M04 - 600 ‰

Soldering wire alloy ready to use for the production of 930 ‰ silver jewellery. This alloy is categorized as a medium soldering.

TAB.1 - Mechanical data

Hardness as cast	n.d.
Hardness hardened	n.d.
Tensile strength	n.d.
Yield strength	n.d.
Elongation	n.d.

TAB.2 - Physical data

Color	Silver
Colour Coordinates	n.d.
Density	9.61 g/cm ³
Melting Range	Solidus: 680 °C Liquidus: 710 °C

TAB.3 - Heat treatments

Solution annealing	n.d.
Recrystallization Annealing	n.d.
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature		1000	°C
Casting Temperature	Min:	950	°C
	Max:	1050	°C
First thickness reduction	Lamination:	50	%
	Drawing:	25	%
Following thickness reductions	Lamination:	75	%
	Drawing:	50	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min