

**AURIDENT CASTING GOLDS**

**COMPOSITION, PHYSICAL AND MECHANICAL PROPERTIES**

**SOLDERS**

Alloy	ADA Type	Color	Class.*	Weight %				Hardness, Brinell / Vickers	Yield Strength, psi	Ultimate Tensile Strength, psi	Elongation, %	Fusion Temperature, °F / °C	Casting Temperature, °F / °C	Specific Gravity, gm / cm <sup>3</sup>	Recommended Solders
				Au	Pt	Pd	Ag								
AM	II	Yellow		77.5	1.74	0	12.25	95 Q / 100 Q	22,000 Q	40,000 Q	25	1750 / 950	1875-1925 / 1025-1050	15.8	650
RM	II	Yellow		65.0	0.1	1.9	24.5	95 Q / 100 Q	23,000 Q	39,000 Q	24	1750 / 950	1875-1925 / 1025-1050	14.4	650
RH	III	Yellow		75.5	1.15	2.25	10.24	120 Q / 125 Q	27,000 Q	45,000 Q	21	1725 / 940	1875-1925 / 1025-1050	15.4	650
BH	III	Yellow		64.0	0.1	3.0	23.4	120 Q / 125 Q	25,000 Q	49,000 Q	18	1725 / 940	1825-1875 / 1000-1025	14.3	615
WH	III	Yellow		60.0	0.1	3.0	18.5	145 Q / 150 Q	34,000 Q	65,000 Q	15	1625 / 885	1825-1875 / 1000-1025	14.0	615
QH	III	Yellow		56.0	0.1	4.0	28.2	140 Q / 145 Q	53,000 Q	72,000 Q	35	1575 / 860	1775-1825 / 970-1000	13.6	585
EH	III	Yellow		52.8	0.1	4.8	31.6	140 Q / 145 Q	31,000 Q	53,000 Q	12	1700 / 925	1850-1900 / 1010-1040	13.5	585
GH	III	Yellow		52.0	0.1	8.0	21.5	140 Q / 225 H	62,000 H	95,000 H	12	1525 / 830	1750-1800 / 950-980	13.6	585
KH	III	Yellow		50.0	0.1	4.0	35.0	135 Q / 140 Q	43,000 Q	70,000 Q	25	1575 / 860	1775-1825 / 970-1000	13.2	585
MH	III	Yellow		46.0	0.1	6.0	40.0	125 Q / 130 Q	33,000 Q	60,000 Q	25	1575 / 860	1775-1825 / 970-1000	12.8	585
HH	III	Yellow		41.7	0	4.4	29.0	145 Q / 150 Q	32,500 Q	54,000 Q	12	1675 / 915	1825-1875 / 1025-1050	12.5	585
IH	III	Yellow		40.0	0.1	20.0	20.5	145 Q / 150 Q	50,000 Q	90,000 Q	10	1700 / 925	1850-1900 / 1010-1040	11.9	585
LH	III	Yellow		20.0	0	20.0	41.0	135 Q / 140 Q 180 H / 190 H	33,000 Q	62,000 Q	9	1575 / 860	1750-1800 / 950-980	11.3	585
PX	IV	Yellow		68.5	2.0	4.5	11.5	170 Q / 180 Q 225 H / 240 H	56,000 H	105,000 H	17 Q 5 H	1725 / 940	1850-1900 / 1010-1040	15.0	585
WX	III, IV	Yellow		57.5	0.1	2.5	28.1	145 Q / 150 Q 230 H / 245 H	60,000 H	115,000 H	19 Q 4 H	1725 / 940	1800-1850 / 980-1010	13.8	585
EX	III, IV	Yellow		57.0	0.1	2.5	28.6	145 Q / 150 Q 230 H / 245 H	60,000 H	115,000 H	19 Q 4 H	1700 / 925	1800-1850 / 980-1010	13.8	585
JX	IV	White		2.0	0	27.0	55.0	140 Q / 145 Q 170 H / 180 H	40,000 H	71,000 H	23 Q 12 H	1725 / 940	1850-1925 / 1010-1050	10.5	585, 1400
YX	IV	Yellow		2.0	0.1	40.0	25.4	205 Q / 215 Q 205 H / 215 H	48,000 Q	55,000 Q	2 Q 2 H	1975 / 1080	2125-2175 / 1160-1190	9.6	585

Type	Melting Range, °F/°C
585	1355-1440 / 735-785
615	1385-1475 / 750-800
650	1420-1490 / 770-810
1400	1335-1400 / 725-760
YC-97	1825-1930 / 995-1055
Yellow Ceramic (YCS)	1975-2010 / 1080-1100
Porcelain White (PWS)	2020-2050 / 1104-1120
Porcelain Silver Free (PSF)	1960-1985 / 1071-1085
White Noble Solder (WNS)	2005-2100 / 1095-1150

All solders are furnished as 1/8" inch wide, one dwt. strips.

**PLATINUM FOIL**

Available in .001" thickness

**PALLADIUM FOIL**

Available in .001" thickness

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**\* CLASSIFICATIONS**

IDENTALLOY® Council Classifications

60% or more noble metal content; 40% or more gold.

25% or more noble metal content.

Less than 25% noble metal content

**AURIDENT PORCELAIN ALLOYS**

**COMPOSITION, PHYSICAL AND MECHANICAL PROPERTIES**

Alloy	Color	Class.*	Weight %				Hardness, Brinell / Vickers	Yield Strength, psi	Ultimate Tensile Strength, psi	Elongation, %	Fusion Temperature, °F / °C	Casting Temperature, °F / °C	Specific Gravity, gm / cm <sup>3</sup>	Thermal Expansion Coefficient, x 10 <sup>-6</sup> / °C (20° - 600° C)	Recommended Solders
			Au	Pt	Pd	Ag									
Auribond 97	Yellow		97.7	2.0	0	0	37 / 40	5,000	21,000	50	1900 / 1038	2150-2200 / 1175-1200	19.2	15.5	YC-97
Auribond 90	Yellow		90.0	5.8	1.6	1.2	115 / 120	27,000	40,000	20	1930 / 1055	2275-2400 / 1246-1315	18.9	14.9	YCS
Elite II	Yellow		88.0	9.5	0	0.75	160 / 170	51,000	67,000	12	2020 / 1105	2350-2425 / 1290-1330	19.4	14.4	YCS
Auribond-GP	Yellow		86.5	5.2	4.55	2.65	195 / 205	59,000	72,000	6	2150 / 1175	2450-2500 / 1340-1370	18.4	14.8	YCS
Windsor	Yellow		75.0	0.1	12.0	10.1	185 / 195	70,000	85,000	12	2130 / 1165	2375-2425 / 1300-1329	16.2	14.8	YCS
Summit	Yellow		74.2	4.1	7.3	11.0	170 / 180	55,000	80,000	12	2060 / 1130	2375-2425 / 1300-1330	16.3	15.1	YCS
Auritex-66	White		66.0	1.1	24.0	0	225 / 240	75,000	95,000	15	2070 / 1135	2375-2425 / 1300-1330	15.3	14.3	PWS, PSF, WNS
Auritex-WP	White		62.2	0.1	23.4	8.25	175 / 185	53,000	81,000	8	2320 / 1270	2550-2600 / 1400-1425	15.0	14.4	PWS, PSF, WNS
Auritex-XP	White		51.8	0.1	38.0	0	195 / 205	72,000	106,000	13	2320 / 1270	2550-2600 / 1400-1425	14.6	14.0	PWS, PSF, WNS
Auritex-HP	White		45.0	0.1	40.0	5.0	190 / 200	78,000	110,000	18	2175 / 1190	2450-2500 / 1345-1370	14.3	14.2	PWS, PSF, WNS
Auritex-40	White		40.0	0.1	40.0	10.0	220 / 230	78,000	110,000	16	2175 / 1190	2450-2500 / 1345-1370	13.2	14.2	PWS, PSF, WNS
Auritex-LP	White		40.0	0	32.0	20.5	210 / 220	75,000	90,000	8	2100 / 1150	2500-2550 / 1370-1400	13.2	14.4	PWS, PSF, WNS
Focus	White		2.5	0.1	70.3	9.7	280 / 265	82,000	85,000	4	2175 / 1190	2450-2500 / 1340-1370	10.7	14.5	PWS, YCS, PSF, WNS
Vision	White		2.0	0.1	80.0	0	250 / 265	143,000	160,000	10	2150 / 1175	2450-2500 / 1340-1370	11.1	14.0	PWS, YCS, PSF, WNS
Auritex-KP	White		2.0	0.1	51.5	37.5	235 / 250	55,000	81,000	5	2160 / 1180	2450-2500 / 1340-1370	11.1	14.8	PWS, PSF, WNS
Marathon	White		2.0	0	76.8	0	320 / 340	103,000	160,000	18	2060 / 1125	2450-2500 / 1340-1370	10.7	13.9	PWS, PSF, WNS
Auritex-ZP	White		0	0	60.0	29.0	175 / 185	65,000	95,000	20	2250 / 1230	2450-2550 / 1340-1400	11.1	14.8	PWS, PSF, WNS
Triumph	White		0	0.1	53.5	37.5	230 / 245	86,000	112,000	17	2175 / 1190	2400-2500 / 1315-1370	11.0	14.8	PWS, WNS
Clarity	White		0	0	49.7	40.0	265 / 280	85,000	95,000	4	2125 / 1160	2425-2475 / 1330-1355	10.8	15.4	PWS, WNS
Vanguard	White		0	0	51.2	48.0	75 / 80	37,000	47,000	9	2350 / 1285	2550-2600 / 1400-1425	11.5	15.0	PWS, WNS



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