

ARGENTIUM PASTE SOLDER

INSTRUCTIONS FOR USE



Dated: November 22

Uses for Argentium Paste Solder

Argentium Paste Solder is available in three grades (Easy, Medium and Hard) and is a homogeneous blend of micro-fine spherical solder powder, flux and binder. The unique properties of paste solder makes it perfect for use on jump rings, in chain manufacture, on hollow items, attaching clasps and earring posts, repair work, and more.

Helpful tips

- Remove the tip cap. (*Save the cap.*)
- Press and twist the needle onto the syringe.
- When not using the syringe on the bench for several days, remove the needle and replace the tip cap on the syringe.
- Store syringe in a cool place.



Instructions for use

1. Prepare the joint by removing all oil, grease, polishing compound and excessive oxides from the joint area.
2. The joint clearance (gap) should be as small as possible. The joint should be flat, smooth and free of burrs. The two pieces being soldered should touch as paste solder will not fill large gaps.
3. Apply paste to the top of the joint. To prevent excess flow of solder from the needle after applying solder to the joint, pull back on the hand plunger to relieve pressure.
4. Please **do not** directly heat the paste solder, as this will cause the paste to 'slump' and move away from the joint. You must allow the piece to heat the paste solder by applying heat to the article (away from the joint) - moving the torch from side to side across the joint to avoid overheating the solder. As the binder 'burns off' and the paste dries you will see the flux spread around the solder. Now move the flame in on the joint area, continuing to move the torch from side to side.
5. Remove the flame immediately after the solder flows.
6. Rinse with water, then pickle with an Argentium recommended pickle solution:
 - Argentium Safety Pickle
 - Sodium Bisulphate
 - Weak Sparex
 - Dilute Sulphuric Acid
 - White vinegar and salt pickle solution (2 cups vinegar : 1 tea spoon salt in hot water)