

Laser weld / Solders

		Composition									Melting Range
Laser Welding Wires	Colour	Au	Pt	Pd	Ag	Cu	In	Zn	Others	°C	
W Portadur IN	Yellow	87.9	4.0	–	5.0	–	–	3.0	Ir<1.0	940–1020	
Laser Ceramic Yellow PdF	Yellow	85.9	12.09	–	–	–	<1.0	1.5	Fe, Mn, Ir, Ta<1.0	1055–1170	
W BioPorta G	Yellow	85.5	11.5	–	–	–	<1.0	1.5	Fe, Rh, W<1.0	1040–1110	
Laser Ceramic Yellow	Yellow	85.0	7.5	3.0	3.0	–	1.5	–	Ir<1.0	1085–1215	
W Porta P6	White	78.0	9.8	8.0	–	–	4.0	–	Ir, Sn<1.0	1110–1200	
W Porta Geo Ti	Yellow	77.4	18.0	–	2.0	–	–	1.8	Ti, Rh<1.0	1060–1140	
Laser C&B Yellow	Yellow	75.0	3.0	–	13.5	7.0	1.5	–	Ir<1.0	900–960	
W Porta Norm	Yellow	73.8	9.0	–	9.2	4.4	1.5	2.0	Ir<1.0	910–990	
W Portadur P2	Yellow	71.0	2.5	1.5	12.2	12.2	–	<1.0	Ir<1.0	890–930	
W Portadur P4	Yellow	68.5	6.9	–	12.0	12.0	–	<1.0	Ir<1.0	920–970	
Laser Ceramic White	White	50.0	–	24.4	21.5	–	4.0	–	Ru<1.0	1200–1290	
Laser C&B White	White	18.5	–	6.0	72.5	–	3.0	–	Ir<1.0	985–1025	
		Co	Cr	Mo	Mn	Si					
W Porta Smart	White	65.1	28.0	5.9	<1.0	<1.0	–	–	–	1370–1390	

		Composition											Melting Range	Flow Point	
Pre-Solder	Colour	Au	Pt	Pd	Ag	Cu	In	Li	Mn	Ni	Ru	Zn	others	°C	°C
W Porta Optimum Lot 940	Yellow	89.0	5.0	–	–	–	–	–	–	–	–	5.7	Ir<1.0	850–930	940
W Porta IP Lot V-1	Yellow	80.0	1.9	–	17.5	–	<1.0	–	–	–	–	–	Sn<1.0	1015–1055	1070
High Fusing Yellow Ceramic Solder (HFYC)	Yellow	80.0	–	4.2	15.4	–	<1.0	<1.0	–	–	–	1.0	Fe<1.0, Ca, Ti	1085–1115	1100
Y-2 Ceramic Solder	Yellow	80.0	–	3.1	16.5	–	<1.0	<1.0	–	–	<1.0	–	Fe<1.0	1070–1100	1090
W Porta Optimum Lot 880	Yellow	75.5	–	–	12.4	9.5	–	–	–	–	–	2.5	Ir<1.0	860–880	880
W BioPorta Lot 1020	Yellow	73.5	–	–	25.0	–	–	–	–	–	–	1.5	–	960–1010	1020
W Porta IP Lot V-2	Yellow	64.0	<1.0	–	34.9	–	<1.0	–	–	–	–	–	Ir<1.0	1015–1030	1040
HGPKF 1030 Y (High Gold Palladium Copper free)	Yellow	63.2	–	–	35.0	–	–	–	<1.0	–	–	<1.0	Pt<1.0, Ir<1.0	1015–1040	1030
W Auropal Lot M-1	Yellow	62.0	–	3.0	17.0	7.0	5.0	–	–	–	–	6.0	–	710–770	800
HGPKF 1015 Y (High Gold Palladium Copper free)	Yellow	60.0	–	–	36.5	–	<1.0	–	–	–	–	<1.0	Pt<1.0, Ir<1.0, Sn<1.0	975–1035	1015
Aquarius Ceramic Solder	Yellow	56.0	–	1.9	39.7	–	<1.0	<1.0	1.0	–	–	1.0	Re<1.0	970–1020	990
Golden Ceramic Solder (GC)	Yellow	54.0	–	3.9	40.0	–	–	1.0	–	–	–	1.0	B<1.0, Re<1.0	995–1045	1020
Spartan Ceramic Solder	White	50.0	–	24.0	–	25.0	–	–	–	–	–	1.0	Ir<1.0	1080–1105	1065
W Porta Lot 1090 W	White	49.7	–	13.0	32.5	–	–	–	–	–	–	4.5	Ir<1.0	980–1090	1090
Special High Fusing White Ceramic Solder (SHFWC)	White	47.0	–	10.3	41.0	–	1.4	–	–	–	<1.0	–	B<1.0, Ca<1.0, Ti<1.0	1045–1105	1105
High Fusing White Ceramic Solder (HFWC)	White	45.0	–	12.4	41.5	–	1.0	<1.0	–	–	<1.0	–	–	1100–1165	1135
Super Solder Ceramic Solder	White	–	–	53.5	7.0	–	–	<1.0	–	35.6	–	–	Sn 3.8	1085–1180	1135

		Composition									Melting Range	Flow Point
Universal Solder	Colour	Au	Pt	Pd	Ag	Zn	In	others	°C	°C		
W Porta OP Lot M-1	Yellow	71.5	1.0	–	17.5	10.0	–	–	750–810	820		
Universal Solder PKF	Yellow	48.8	2.8	–	40.5	7.3	<1.0	–	Ir<1.0	800–900	850	
Universal Solder 1015 W	White	18.5	–	6.0	72.5	–	3.0	–	Ir<1.0	985–1025	1015	

		Composition											Melting Range	Flow Point	
Post Solder	Colour	Au	Pt	Pd	Ag	Cu	In	Li	Mn	Ni	Ru	others	°C	°C	
High Fusing White Gold Solder (HFWG)	Yellow	79.8	–	–	–	–	–	<1.0	11.8	–	8.3	–	880-910	895	
W Porta Optimum Lot 710	Yellow	73.0	–	12.4	–	–	–	–	–	–	14.5	Ir<1.0	680-700	710	
W Porta OP Lot W-2	Yellow	68.0	1.0	19.0	–	–	–	–	–	–	12.0	–	710-765	770	
.650 Fine Gold Solder	Yellow	65.0	–	13.0	19.6	2.0	–	–	–	–	<1.0	–	785-835	830	
W Auropal Lot W-2	Yellow	62.0	–	22.0	4.0	–	–	–	–	–	12.0	–	720-750	750	
.615 Fine Gold Solder	Yellow	61.5	–	13.1	17.4	–	7.6	–	–	–	<1.0	–	690-775	775	
.585 Fine Gold Solder	Yellow	58.5	–	16.0	18.0	7.2	–	–	–	–	<1.0	–	610-725	725	
Low Fusing White Gold Solder (LFWG)	Yellow	56.1	–	27.4	–	–	<1.0	–	–	–	<1.0	15.8	–	665-710	730

		Composition									Melting Range	Flow Point
Solder for soldering precious alloys with CoCr-alloys	Colour	Au	Pt	Pd	Ag	Cu	In	Li	others	°C	°C	
W Stahlgoldlot Nr. 80 M-1	White	80.0	–	–	–	–	–	5.0	Ni 15.0	860-920	920	
W Stahlgoldlot Nr. 80 W-2	White	80.0	–	–	1.0	–	–	7.0	Ni 10.0, Co 2.0	800-860	870	

W Original WIELAND Dental Alloy