## CEKA SOL

**CEKA SOL - CEKA SOL FILIGRAN - CEKA SOL W - CEKA SOL L - CEKA SOL G - CEKA SOL CR**

The incorporation of flux in the solder allows the soldering of the most difficult connections between fixed and removable constructions.

1. Select the appropriate **CEKA SOL** solder for the alloys to be connected.
2. The surfaces to be bonded must be clean and the distance between the parts to be soldered must be **minimum 0.05 mm** and **maximum 0.20 mm**.
3. Use materials that will **burn out** clearly to fix the parts to be soldered.
4. Apply anti-flux to those areas where you do not want the solder to flow.
5. Cover the parts that should not oxidize with de-oxidizing flux (e.g. the inside of the milled parts).
6. Heat up the parts to be soldered according to the following criteria:
   - melting point of the different parts (parts with higher melting point first);
   - areas making contact with accessories or investment;
   - areas into which the solder must flow;
   - oxidation of the alloys (highly oxidizing alloys last).
7. Use a small soldering flame.
8. Remove the flame from the soldered part when it is red-hot and apply **CEKA SOL** diagonally to the soldering joint.
9. Let the solder melt. Sufficient flux will now flow from the tube to remove the oxide from the soldering joint.
10. By moving the flame (controlled heating), the flow of the solder may be controlled.
11. Allow the soldered construction to bench cool after soldering.
12. Remove the flux in an ultrasonic bath.
13. The oxide can be removed by mechanical polishing or electrolytically.