

GENERAL INFORMATION
General information

Typology	Master alloy for gold
Color	Yellow
Color shade	Greenish yellow
Production process	All-purpose
Grain refinement level	Medium
Deoxidation level	Minimum

Commercial composition (%)

AG	68.5
CU	31.5

Melting Temperatures

Solidus [°C]	890.0
Liquidus [°C]	940.0
Melting range [°C]	50.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
88.2	1.9	25.2	25.3	

Mechanical characteristics

As cast hardness [HV 0.2]	100.0
Hardness after 70% area red. [HV 0.2]	155.0
Hardness after annealing [HV 0.2]	110.0
Single step age-hardening hardness [HV 0.2]	100.0
Tensile strength (Rm) [Mpa]	366.0
Yield strength (Rp0.2) [MPa]	223.0
Elongation at rupture (A) [%]	43.0

Physical characteristics

Density [g/cm ³]	15.5
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Product applications

Continuous casting
 Ingot casting
 Casting in closed systems
 Casting without stones
 Handmade production
 Massive chain production
 Wire production
 Sheet production
 Stamping production

A18VN 750‰

ALL-PURPOSE MASTER ALLOY FOR 375-585-750‰ (9-14-18 KT) YELLOW GOLD

CASTING PROCESSING PARAMETERS
Pre-melting temperature

Temperature [°C] 1060

POURING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1040	1070
0.5 - 1.2 mm	580	650	1020	1040
> 1.2 mm	460	600	1000	1020

Trees without stones

Let the flask cool down for 5 minutes, then quench it in water.

Pickling

Dip in RADIAL solution (50 g/l conc. at 60°C) for 2 minutes, or in sulphuric acid (10% concentration at 50°C) for 5 minutes.

MECHANICAL WORKING PARAMETERS
Pre-melting temperature

Temperature [°C] 1060

Reductions

Wire - diameter (%)	45.0
Sheet - area or thickness (%)	75.0

POURING TEMPERATURES	Countinous from [°C]	Countinous to [°C]	Ingot to [°C]	Ingot from [°C]
Temperatures	1040	1120	1020	1060

MECHANICAL WORKING ANNEALING	Temp. from [°C]	Temp. to [°C]	Time [min]
< 1 mm	620	660	25
1 - 5 mm	620	660	30
> 5 mm	620	660	35

Mechanical working quenching

Quench directly in water.

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ALL-PURPOSE MASTER ALLOY FOR 375-585-750‰ (9-14-18 KT) YELLOW GOLD

AGE HARDENING PROCESSING PARAMETERS

SINGLE STEP	Temperature [°C]	Time [min]	Quenching
AGE HARDENING	300	90	In air or in furnace