

GENERAL INFORMATION
General information

Color	Red
Color shade	Pink
Typology	Master alloy for gold
Production process	Casting

Melting temperatures

Liquidus [°C]	885.0
Solidus [°C]	855.0
Melting range [°C]	30.0

Commercial composition

Zinc (%)	2,00
Copper (%)	82,00
Silver (%)	16,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	83.0
a*	7.4
b*	16.2
c*	17.8

General characteristics

As cast grain size [µm]	1400.0
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Mechanical characteristics

As cast hardness [HV 0.2]	180.0
Hardness after annealing [HV 0.2]	175.0
Hardness after 70% area red. [HV 0.2]	280.0
Single step age-hardening hardness [HV 0.2]	320.0
Tensile strength (Rm) [Mpa]	443.0
Yield strength (Rp0.2) [MPa]	318.0
Elongation at rupture (A) [%]	37.0

Product applications

Age-hardening
Casting in open systems

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1005.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1000.0	1030.0
0.5 - 1.2 mm	580.0	650.0	980.0	1000.0
> 1.2 mm	460.0	600.0	960.0	980.0

Trees without stones

Let the flask cool down for 10-15 minutes, then quench in water.

Stone-in-place casting trees

Remove the flask immediately from the machine. Dip only the bottom part of the tree in cold water and keep under ventilation for 15 minutes. Quench in warm water.

Pickling

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

AGE HARDENING PROCESSING PARAMETERS

SINGLE STEP AGE-HARDENING TREATMENT	Temperature [°C]	Time [min]	Quenching
Age-hardening	350.0	90.0	Air or in furnace