

GENERAL INFORMATION
General information

Color shade	Red
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Typology	Master alloy for gold
Production process	Casting

Melting temperatures

Liquidus [°C]	935.0
Solidus [°C]	900.0
Melting range [°C]	35.0

Commercial composition

Silver (%)	6,00
Copper (%)	91,00
Zinc (%)	3,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	85.0
a*	9.4
b*	15.3

Mechanical characteristics

As cast hardness [HV 0.2]	125.0
Hardness after annealing [HV 0.2]	140.0
Hardness after 70% area red. [HV 0.2]	245.0

Product applications

Casting in closed systems
Casting in open systems
Casting without stones
Stone-in-place casting

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1055.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1035.0	1065.0
0.5 - 1.2 mm	580.0	650.0	1015.0	1035.0
> 1.2 mm	460.0	600.0	995.0	1015.0

Trees without stones

Remove the flask within 1 minute after pouring, then quench immediately 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.)