

**LSG412 585‰**

MASTER ALLOY FOR SOLDERING OF 585-750‰ (14-18 KT) YELLOW GOLD

**GENERAL INFORMATION**
**General information**

Typology	Gold solder
Color	Yellow
Color shade	Greenish yellow
Production process	Brazing
Grain refinement level	Minimum
Deoxidation level	Minimum

**Commercial composition (%)**

AG	34.0
CU	34.0
ZN	24.0
IN	8.0

**Melting Temperatures**

Solidus [°C]	655.0
Liquidus [°C]	745.0
Melting range [°C]	90.0

**FULL CHARACTERIZATION DATA**
**Color coordinates**

L *	a*	b*	c*	Yellow Index
89.1	-0.7	18.2	18.2	

**Mechanical characteristics**

As cast hardness [HV 0.2]	195.0
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**Physical characteristics**

Density [g/cm <sup>3</sup> ]	12.3
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**Product applications**

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**MECHANICAL WORKING PARAMETERS**
**Pre-melting temperature**

Temperature [°C] 865

**Reductions**

Wire - diameter (%)	30.0
Sheet - area or thickness (%)	50.0

**POURING TEMPERATURES**

Countinous from [°C]

Countinous to [°C]

Ingot to [°C]

Ingot from [°C]

Temperatures

845

925

825

865

**MECHANICAL WORKING ANNEALING**

Temp. from [°C]

Temp. to [°C]

Time [min]

&lt; 1 mm

530

560

20

&gt; 5 mm

530

560

25

1 - 5 mm

530

560

30

**Mechanical working quenching**

Quench directly in 50%/50% water/alcohol solution or in water.

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**Preliminary checks**

Please note that in order to correctly evaluate the alloy's hardness to solderability, it is advised to make a numerical calculation by subtracting the base metal solidus temperature value from the solder liquidus temperature value. The higher the number resulting, the more solderable (or the less hard) the alloy can be considered. Please refer to the technical guideline for solders available in the website for further information.