

GENERAL INFORMATION
General information

Typology	Gold solder
Color	Red
Color shade	Pink
Production process	Brazing
Grain refinement level	Minimum
Deoxidation level	Minimum

Commercial composition (%)

CU	75.6
IN	20.0
AG	4.4

Melting Temperatures

Solidus [°C]	745.0
Liquidus [°C]	845.0
Melting range [°C]	100.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
84.6	6.4	19.7	20.7	

Mechanical characteristics

As cast hardness [HV 0.2]	160.0
Tensile strength (Rm) [Mpa]	426.0
Yield strength (Rp0.2) [MPa]	308.0
Elongation at rupture (A) [%]	41.0

Physical characteristics

Density [g/cm ³]	14.5
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General characteristics

As cast grain size [μm]	180.0
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Product applications

Soldering in belt furnace

LSR489 750‰

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

MECHANICAL WORKING PARAMETERS
Pre-melting temperature

Temperature [°C] 965

Reductions

Wire - diameter (%)	45.0
Sheet - area or thickness (%)	70.0

POURING TEMPERATURES

Countinous from [°C]

Countinous to [°C]

Ingot to [°C]

Ingot from [°C]

Temperatures

945

1025

925

965

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

< 1 mm

570

600

20

1 - 5 mm

570

600

25

> 5 mm

570

600

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.