

NF508 375‰

NICKEL-FREE ALL-PURPOSE MASTER ALLOY FOR 585-750‰ (14-18 KT) WHITE GOLD

GENERAL INFORMATION
General information

Typology	Master alloy for gold
Color	White, nickel-free
Color shade	Premium white
Production process	All-purpose
Grain refinement level	High
Deoxidation level	Minimum

Commercial composition (%)

AG	62.0
PD	30.8
ZN	4.0
CU	3.2

Melting Temperatures

Solidus [°C]	1030.0
Liquidus [°C]	1055.0
Melting range [°C]	25.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
82.4	1.5	8.1	8.2	18.1

Mechanical characteristics

As cast hardness [HV 0.2]	180.0
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Physical characteristics

Density [g/cm ³]	11.6
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Product applications

Casting in closed systems
Casting without stones

CASTING PROCESSING PARAMETERS
Pre-melting temperature

Temperature [°C] 1170

POURING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1140	1170
> 1.2 mm	460	600	1100	1120
0.5 - 1.2 mm	580	650	1120	1140

MECHANICAL WORKING PARAMETERS
Pre-melting temperature

Temperature [°C] 1170

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	1130	1210	1110	1150

MECHANICAL WORKING ANNEALING	Temp. from [°C]	Temp. to [°C]	Time [min]
< 1 mm	680	720	25
1 - 5 mm	680	720	30
> 5 mm	680	720	35

Mechanical working quenching

Quench directly in water.