MASTER ALLOY

TECHNICAL SHEET

OG160A 585‰

MASTER ALLOY FOR CASTING OF 375-585‰ (9-14 KT) YELLOW GOLD

GENERAL INFORMATION

General information	
Color	Yellow
Color shade	Rich yellow
Typology	Master alloy for gold
Production process	Casting
Melting temperatures	
Liquidus [°C]	870.0
Solidus [°C]	810.0
Melting range [°C]	60.0

Commercial composition	
Silver (%)	16,00
Copper (%)	69,00
Zinc (%)	15,00

GOLD line

FULL CHARACTERIZATION DATA

Color coordinates	
L*	88.2
a*	2.7
b*	17.0
c*	18.1

Mechanical characteristics	
As cast hardness [HV 0.2]	110.0
Single step age-hardening hardness [HV 0.2]	150.0

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

RELATED PRODUCTS LIST

Related Products	
LSG409	Master alloy for soldering of 585‰ (14 Kt) yellow gold
LSG409D	Master alloy for soldering of 585‰ (14 Kt) yellow gold
LSG417F	Master alloy for soldering of 375-585‰ (9-14 Kt) yellow gold
LSG419	Master alloy for soldering of 375‰ (9Kt) yellow gold
Alternative Products	
SCA5	Master alloy for casting of 375-585‰ (9-14 Kt) yellow gold
C141US	Master alloy for casting of 375-585‰ (9-14 Kt) yellow gold

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LEGOR GROUP S.P.A. - Via del Lavoro, 1 - 36050 (VI) - Italy - Tel. +39 0444 467911 - Fax +39 0444 660677 - info@legor.com - www.legor.com

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CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 990.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	970.0	1000.0
0.5 - 1.2 mm	580.0	650.0	950.0	970.0
> 1.2 mm	460.0	600.0	930.0	950.0

Trees without stones

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

Stone-in-place casting trees

Let the flask cool down for 30-45 minutes, then quench in 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	250.0	90.0	Air or in furnace

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