

GENERAL INFORMATION
General information

Production process	Universal
Color	Red
Color shade	Pink
Typology	Master alloy for gold

Melting temperatures

Liquidus [°C]	905.0
Solidus [°C]	865.0
Melting range [°C]	40.0

Commercial composition

Zinc (%)	2,00
Copper (%)	80,00
Silver (%)	18,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	84.3
a*	8.2
b*	17.6
c*	19.4

General characteristics

As cast grain size [µm]	20.0
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Mechanical characteristics

As cast hardness [HV 0.2]	165.0
Hardness after annealing [HV 0.2]	175.0
Hardness after 70% area red. [HV 0.2]	285.0
Single step age-hardening hardness [HV 0.2]	190.0
Tensile strength (Rm) [Mpa]	543.0
Yield strength (Rp0.2) [MPa]	360.0
Elongation at rupture (A) [%]	27.0

Product applications

Casting in closed systems
Casting without stones
CNC and lathe production
Continuous casting
Ingot casting
Sheet production
Stamping production

RELATED PRODUCTS LIST
Related Products

LSR490	Master alloy for soldering of 375-585-750‰ (9-14-18 Kt) red gold
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Alternative Products

OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold
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CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1025.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	650.0	720.0	1010.0	1040.0
0.5 - 1.2 mm	600.0	650.0	990.0	1010.0
> 1.2 mm	560.0	600.0	970.0	990.0

Trees without stones

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

MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 1025.0

Reductions

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

POURING TEMPERATURES	Countinous from [°C]	Countinous to [°C]	Ingot from [°C]	Ingot to [°C]
Temperatures	1005.0	1085.0	985.0	1025.0

MECHANICAL WORKING ANNEALING	Temp. from [°C]	Temp. to [°C]	Time [min]
<1 mm	620.0	660.0	25.0
1 - 5 mm	620.0	660.0	30.0
>5 mm	620.0	660.0	35.0

Mechanical working quenching

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

AGE HARDENING PROCESSING PARAMETERS

SINGLE STEP AGE-HARDENING TREATMENT	Temperature [°C]	Time [min]	Quenching
Age-hardening	300.0	90.0	Air or in furnace