

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	940.0
Solidus [°C]	920.0
Melting range [°C]	20.0

Commercial composition

Silver (%)	5,00
Copper (%)	92,00
Zinc (%)	3,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	86.6
a*	9.7
b*	14.7
c*	17.6

General characteristics

As cast grain size [µm]	30
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Mechanical characteristics

As cast hardness [HV 0.2]	130.0
Hardness after annealing [HV 0.2]	145.0
Hardness after 70% area red. [HV 0.2]	270.0
Tensile strength (Rm) [Mpa]	491.0
Yield strength (Rp0.2) [MPa]	258.0
Elongation at rupture (A) [%]	33.0

Product applications

Casting in closed systems
Casting without stones
Continuous casting
Massive chain production
Sheet production
Stamping production
TIG tube production
Wire production

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1060.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1040.0	1070.0
0.5 - 1.2 mm	580.0	650.0	1020.0	1040.0
> 1.2 mm	460.0	600.0	1000.0	1020.0

Trees without stones

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

Stone-in-place casting trees

Remove the flask immediately from the machine. Dip only the bottom part of the tree in cold water and keep under ventilation for 15 minutes. 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] 1060.0

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	1040.0	1120.0	1020.0	1060.0

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.