

**MASTER
ALLOY**
WB149C 375‰

MASTER ALLOY FOR CASTING OF 585-750‰ (14-18 KT) WHITE GOLD

GENERAL INFORMATION
General information

Color	White
Color shade	Standard white
Typology	Master alloy for gold
Production process	Casting

Melting temperatures

Solidus [°C]	950.0
Melting range [°C]	50.0
Liquidus [°C]	1000.0

Commercial composition

Copper (%)	68,00
Nickel (%)	13,00
Zinc (%)	19,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	87.6
a*	1.3
b*	10.6
c*	10.6
Yellow index	21.6

Mechanical characteristics

As cast hardness [HV 0.2]	110.0
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Product applications

Casting in open systems
Casting without stones
Stone-in-place casting

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1120.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1080.0	1100.0
0.5 - 1.2 mm	580.0	650.0	1050.0	1080.0
> 1.2 mm	460.0	600.0	1020.0	1050.0

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 45-60 minutes, then quench in water.

Pickling

Dip in RADIAL solution (50 g/l conc. at 60°C for 5-10 min.), or in sulphuric acid (10% conc. at 50°C for 10 min.)