

**GENERAL INFORMATION**
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Production process	Universal
Color	Red
Color shade	Pink yellow
Typology	Master alloy for gold

**Melting temperatures**

Liquidus [°C]	925.0
Solidus [°C]	900.0
Melting range [°C]	25.0

**Commercial composition**

Silver (%)	18,00
Copper (%)	77,00
Zinc (%)	5,00



GOLD line

**FULL CHARACTERIZATION DATA**
**Color coordinates**

L*	87.0
a*	8.2
b*	23.5

**Mechanical characteristics**

As cast hardness [HV 0.2]	110.0
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**Product applications**

Casting without stones
Casting in closed systems
Hand production
Stamping production
Massive chain production
Wire production
Continuous casting
Sheet production
Ingot casting

**RELATED PRODUCTS LIST**
**Related Products**

CUT10X2	Copper tube, 10.0 mm diameter, 2.0 mm wall thickness, 2500 mm length, cold worked
L1A	Powder for soldering of gold and silver chains
LSR490	Master alloy for soldering of 375-585-750‰ (9-14-18 Kt) red gold
LSR500	Master alloy for soldering of 585-750‰ (14-18 Kt) red gold

**Alternative Products**

YA223W	All-purpose master alloy for 875-917‰ (21-22 Kt) yellow gold
YA22U	All-purpose master alloy for 375-585-750-917‰ (9-14-18-22 Kt) yellow gold

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1045.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	650.0	700.0	1025.0	1055.0
0.5 - 1.2 mm	600.0	650.0	1005.0	1025.0
> 1.2 mm	550.0	600.0	985.0	1005.0

**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.)

**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 1045.0

POURING TEMPERATURES	Countinous from [°C]	Countinous to [°C]	Ingot from [°C]	Ingot to [°C]
Temperatures	1025.0	1105.0	1005.0	1045.0

MECHANICAL WORKING ANNEALING	Temp. from [°C]	Temp. to [°C]	Time [min]
<1 mm	620.0	660.0	20.0
1 - 5 mm	620.0	660.0	25.0
>5 mm	620.0	660.0	30.0

**Mechanical working quenching**

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