

GENERAL INFORMATION
General information

Color	Yellow
Typology	Master alloy for gold
Color shade	Green yellow
Production process	Casting

Melting temperatures

Liquidus [°C]	940.0
Solidus [°C]	890.0
Melting range [°C]	50.0

Commercial composition

Silver (%)	69,00
Copper (%)	31,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	88.2
a*	1.9
b*	25.2
c*	25.3

Mechanical characteristics

As cast hardness [HV 0.2]	100.0
Hardness after 70% area red. [HV 0.2]	155.0
Hardness after annealing [HV 0.2]	110.0
Tensile strength (Rm) [Mpa]	366.0
Yield strength (Rp0.2) [MPa]	223.0
Elongation at rupture (A) [%]	43.0

Product applications

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

RELATED PRODUCTS LIST
Related Products

LSG406B	Master alloy for soldering of 750‰ (18 Kt) yellow gold
LSG409V	Master alloy for soldering of 750‰ (18 Kt) yellow gold

Alternative Products

C18VN	Master alloy for casting of 750‰ (18 Kt) yellow gold
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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

Let the flask cool down for 5 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] 1060.0

Reductions

Sheet - area or thickness (%) 75.0

Wire - diameter (%) 45.0

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 water

PRODUCT TECHNICAL GUIDELINES**Processing temperatures**

While using in title 375, make quick quenching in water to minimize hardening on the alloy after mechanical deformation.