

GENERAL INFORMATION
General information

Color	Yellow
Production process	Mechanical working
Typology	Master alloy for gold
Color shade	Light yellow

Melting temperatures

Liquidus [°C]	910.0
Solidus [°C]	860.0
Melting range [°C]	50.0

Commercial composition

Silver (%)	58,00
Copper (%)	38,00
Zinc (%)	4,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	87.4
a*	3.0
a*	3.0
b*	24.5
c*	24.7

Physical characteristics

Density [g/cm ³]	15.0
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Product applications

Massive chain production
Sheet production
Wire production
Continuous casting
Ingot casting
Hollow chain production
Production of tube from continuous casting
Stamping production
CNC and lathe production
TIG tube production
Cladding production
Blanking production

Mechanical characteristics

As cast hardness [HV 0.2]	140.0
Hardness after annealing [HV 0.2]	150.0
Hardness after 70% area red. [HV 0.2]	245.0
Single step age-hardening hardness [HV 0.2]	215.0
Tensile strength (Rm) [Mpa]	402.0
Yield strength (Rp0.2) [MPa]	272.0
Elongation at rupture (A) [%]	41.0

RELATED PRODUCTS LIST
Related Products

L1A	Powder for soldering of gold and silver chains
LSG406B	Master alloy for soldering of 750‰ (18 Kt) yellow gold
LSG409V	Master alloy for soldering of 750‰ (18 Kt) yellow gold

Alternative Products

OG604Z	Master alloy for mechanical working of 750‰ (18 Kt) yellow gold
C182N	Master alloy for casting of 750‰ (18 Kt) yellow gold

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1030.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	620.0	700.0	990.0	1020.0
0.5 - 1.2 mm	560.0	650.0	980.0	1000.0
> 1.2 mm	500.0	620.0	970.0	980.0

Trees without stones

Let the flask cool down for 5 minutes, then quench in water.

MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 1030.0

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	1010.0	1090.0	990.0	1030.0

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

AGE HARDENING PROCESSING PARAMETERS

SINGLE STEP AGE-HARDENING TREATMENT	Temperature [°C]	Time [min]	Quenching
Age-hardening	275.0	90.0	Air or in furnace