

**GENERAL INFORMATION**
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Color	Yellow
Color shade	Rich yellow
Typology	Master alloy for gold
Production process	Casting

**Melting temperatures**

Liquidus [°C]	875.0
Solidus [°C]	820.0
Melting range [°C]	55.0

**Commercial composition**

Zinc (%)	17,00
Copper (%)	70,50
Silver (%)	12,50



GOLD line

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

L*	85.7
a*	2.7
b*	18.0
c*	18.2

**General characteristics**

As cast grain size [µm]	330.0
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**Product applications**

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

**Mechanical characteristics**

As cast hardness [HV 0.2]	120.0
Hardness after annealing [HV 0.2]	135.0
Hardness after 70% area red. [HV 0.2]	250.0
Tensile strength (Rm) [Mpa]	447.0
Yield strength (Rp0.2) [MPa]	242.0
Elongation at rupture (A) [%]	33.0

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

LSG409	Master alloy for soldering of 585‰ (14 Kt) yellow gold
LSG409D	Master alloy for soldering of 585‰ (14 Kt) yellow gold
LSG417F	Master alloy for soldering of 375-585‰ (9-14 Kt) yellow gold
LSG419	Master alloy for soldering of 375‰ (9Kt) yellow gold

**Alternative Products**

OG130A	Master alloy for casting of 375-585‰ (9-14 Kt) yellow gold
B145	Master alloy for mechanical working of 375-585‰ (9-14 Kt) yellow gold

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 995.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	975.0	1005.0
0.5 - 1.2 mm	580.0	650.0	955.0	975.0
> 1.2 mm	460.0	600.0	935.0	955.0

**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.)