

**MASTER  
ALLOY**
**C185N1 750‰**

MASTER ALLOY FOR CASTING OF 375-585-750‰ (9-14-18 KT) RED GOLD

**GENERAL INFORMATION**
**General information**

Color	Red
Color shade	Pink
Typology	Master alloy for gold
Production process	Casting

**Melting temperatures**

Liquidus [°C]	900.0
Solidus [°C]	840.0

**Commercial composition**

Silver (%)	11,00
Copper (%)	87,00
Zinc (%)	2,00



GOLD line

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

a*	8.5
b*	16.5

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	14.7
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**Mechanical characteristics**

As cast hardness [HV 0.2]	160.0
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**Product applications**

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

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

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**

OR133	All-purpose master alloy for 585-750‰ (14-18 Kt) red gold
OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1020.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1000.0	1030.0
0.5 - 1.2 mm	580.0	650.0	980.0	1000.0
> 1.2 mm	460.0	600.0	960.0	980.0

**Trees without stones**

Remove the flask within 1 minute after pouring, then quench immediately in water.

**Stone-in-place casting trees**

Remove the flask immediately from the machine. Dip only the bottom part of the tree in cold water and keep under ventilation for 15 minutes. Quench in warm 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.)