

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

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

**Melting temperatures**

Liquidus [°C]	980.0
Solidus [°C]	950.0
Melting range [°C]	30.0

**Commercial composition**

Silver (%)	6,00
Copper (%)	91,00
Zinc (%)	3,00



GOLD line

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

L*	83.5
a*	9.2
b*	15.0

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	11.0
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**Mechanical characteristics**

As cast hardness [HV 0.2]	120.0
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**Product applications**

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

**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**

OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold
OR134C	Master alloy for casting of 375-585-750‰ (9-14-18 Kt) red gold

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1100.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1080.0	1110.0
0.5 - 1.2 mm	580.0	650.0	1060.0	1080.0
> 1.2 mm	460.0	600.0	1040.0	1060.0

**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 45-60 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.)