

**GENERAL INFORMATION**
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Color	White
Color shade	Standard white
Production process	Soldering and brazing
Typology	Solder for gold

**Melting temperatures**

Melting range [°C]	80.0
Liquidus [°C]	780.0
Solidus [°C]	700.0

**Working temperatures**

Working temperature [°C]	770.0
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**Commercial composition**

Silver (%)	76,00
Copper (%)	15,00
Zinc (%)	5,00
Indium (%)	4,00



# JOINING line

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

L*	88.8
a*	-1.7
b*	12.0
c*	12.1
Yellow index	21.6

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	11.5
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**Mechanical characteristics**

Elongation at rupture (A) [%]	10.0
Yield strength (Rp0.2) [MPa]	442.0
As cast hardness [HV 0.2]	180.0
Hardness after annealing [HV 0.2]	200.0
Hardness after 70% area red. [HV 0.2]	230.0
Tensile strength (Rm) [Mpa]	544.0

**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 900.0

**Reductions**

Wire - diameter (%)	15.0
Sheet - area or thickness (%)	40.0

**POURING TEMPERATURES**

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

880.0

960.0

900.0

860.0

**MECHANICAL WORKING ANNEALING**

Temp. from [°C]

Temp. to [°C]

Time [min]

&lt;1 mm

540.0

560.0

15.0

1 - 5 mm

540.0

560.0

20.0

&gt;5 mm

540.0

560.0

25.0

**Mechanical working quenching**

Quench directly in water

**PRODUCT TECHNICAL GUIDELINES****Preliminary checks**

Please note that in order to correctly evaluate the alloy's hardness to solderability, it is advised to make a numerical calculation by subtracting the base metal solidus temperature value from the solder liquidus temperature value. The higher the number resulting, the more solderable (or the less hard) the alloy can be considered. Please refer to the technical guideline for solders available in the website for further information.