

LSG404 875‰

MASTER ALLOY FOR SOLDERING OF 875-917‰ (21 -22KT) YELLOW GOLD

GENERAL INFORMATION
General information

Typology	Gold solder
Color	Yellow
Color shade	Light yellow
Production process	Brazing
Grain refinement level	Minimum
Deoxidation level	Minimum

Commercial composition (%)

AG	28.0
CU	29.0
IN	25.0
ZN	18.0

Melting Temperatures

Solidus [°C]	770.0
Liquidus [°C]	855.0
Melting range [°C]	85.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
81.1	1.4	26.5	26.5	

Mechanical characteristics

As cast hardness [HV 0.2]	90.0
Hardness after 70% area red. [HV 0.2]	190.0
Hardness after annealing [HV 0.2]	90.0
Tensile strength (Rm) [Mpa]	286.0
Yield strength (Rp0.2) [MPa]	122.0
Elongation at rupture (A) [%]	56.0

Physical characteristics

Density [g/cm ³]	16.4
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General characteristics

As cast grain size [μm]	50.0
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Product applications

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MECHANICAL WORKING PARAMETERS
Pre-melting temperature

Temperature [°C] 975

Reductions

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

POURING TEMPERATURES

Countinous from [°C]

Countinous to [°C]

Ingot to [°C]

Ingot from [°C]

Temperatures

955

1035

935

975

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

< 1 mm

500

530

15

1 - 5 mm

500

530

20

> 5 mm

500

530

25

Mechanical working quenching

Quench directly in 50%/50% water/alcohol solution or in water.

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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.