

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

Color	Yellow
Production process	Soldering and brazing
Typology	Solder for gold
Color shade	Green yellow

**Melting temperatures**

Melting range [°C]	90.0
Liquidus [°C]	745.0
Solidus [°C]	655.0

**Working temperatures**

Working temperature [°C]	735.0
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**Commercial composition**

Silver (%)	34,00
Copper (%)	31,00
Zinc (%)	25,00
Indium (%)	10,00



# JOINING line

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

L*	89.1
a*	-0.7
b*	18.2
c*	18.2

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	12.3
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**Mechanical characteristics**

As cast hardness [HV 0.2]	195.0
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**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 865.0

**Reductions**

Sheet - area or thickness (%) 50.0

Wire - diameter (%) 30.0

**POURING TEMPERATURES**

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

845.0

925.0

865.0

825.0

**MECHANICAL WORKING ANNEALING**

Temp. from [°C]

Temp. to [°C]

Time [min]

<1 mm

530.0

560.0

20.0

1 - 5 mm

530.0

560.0

25.0

>5 mm

530.0

560.0

30.0

**Mechanical working quenching**

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