

GENERAL INFORMATION
General information

Typology	Gold solder
Color	Red
Color shade	Pink
Production process	Brazing
Grain refinement level	Minimum
Deoxidation level	Minimum

Commercial composition (%)

CU	74.0
IN	20.0
AG	5.0
ZN	1.0

Melting Temperatures

Solidus [°C]	635.0
Liquidus [°C]	820.0
Melting range [°C]	185.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
86.5	3.5	18.6	18.9	

Mechanical characteristics

As cast hardness [HV 0.2]	160.0
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Physical characteristics

Density [g/cm ³]	12.1
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Product applications

LSR490 585‰

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

MECHANICAL WORKING PARAMETERS
Pre-melting temperature

Temperature [°C] 940

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

920

1000

900

940

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

< 1 mm

570

600

20

1 - 5 mm

570

600

25

> 5 mm

570

600

30

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.