

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

Color	Red
Color shade	Red
Production process	Mechanical working
Typology	Master alloy for gold

**Melting temperatures**

Liquidus [°C]	910.0
Solidus [°C]	890.0
Melting range [°C]	20.0

**Commercial composition**

Zinc (%)	3,00
Silver (%)	8,00
Copper (%)	89,00



GOLD line

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

L*	86.6
a*	9.1
b*	16.5
c*	18.8

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	15.3
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**Product applications**

Production of tube from continuous casting
Continuous casting
Hand production
Wire production
Age-hardening
Massive chain production
Ingot casting
Hollow chain production
Stamping production
Sheet production
CNC and lathe production
TIG tube production

**Mechanical characteristics**

As cast hardness [HV 0.2]	150.0
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**RELATED PRODUCTS LIST**
**Related Products**

L1A	Powder for soldering of gold and silver chains
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
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**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 1030.0

**Reductions**

Sheet - area or thickness (%) 75.0

Wire - diameter (%) 45.0

**POURING TEMPERATURES**

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

1020.0

1100.0

1000.0

1040.0

**MECHANICAL WORKING ANNEALING**

Temp. from [°C]

Temp. to [°C]

Time [min]

&lt;1 mm

620.0

660.0

25.0

1 - 5 mm

620.0

660.0

30.0

&gt;5 mm

620.0

660.0

35.0

**Mechanical working quenching**

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

**AGE HARDENING PROCESSING PARAMETERS**
**SINGLE STEP AGE-HARDENING TREATMENT**

Temperature [°C]

Time [min]

Quenching

Age-hardening

250.0

90.0

Air or in furnace