

**MASTER
ALLOY**
OR129W 375‰

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

GENERAL INFORMATION
General information

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

Melting temperatures

Melting range [°C]	95.0
Liquidus [°C]	940.0
Solidus [°C]	845.0

Commercial composition

Silver (%)	16,00
Copper (%)	82,00
Zinc (%)	2,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	85.6
a*	7.4
b*	15.3
c*	17.0

Physical characteristics

Density [g/cm ³]	11.2
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General characteristics

As cast grain size [μm]	200.0
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Product applications

Wire production
Massive chain production
Cladding production
CNC and lathe production
TIG tube production
Blanking production
Hollow chain production
Production of tube from continuous casting
Sheet production
Continuous casting
Ingot casting
Stamping production

Mechanical characteristics

As cast hardness [HV 0.2]	135.0
Hardness after annealing [HV 0.2]	145.0
Hardness after 70% area red. [HV 0.2]	260.0
Tensile strength (Rm) [Mpa]	478.0
Yield strength (Rp0.2) [MPa]	288.0
Elongation at rupture (A) [%]	29.0

RELATED PRODUCTS LIST
Related Products

CUT10X2	Copper tube, 10.0 mm diameter, 2.0 mm wall thickness, 2500 mm length, cold worked
FE5	Iron wire, 5.0 mm diameter, annealed
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
TOMBACP	Tombac plate, 10.0 mm thickness, 100.0 mm width

Alternative Products

OR129WE	Master alloy for mechanical working of 375-585‰ (9-14 Kt) red gold
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MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 1060.0

Reductions

Sheet - area or thickness (%) 70.0

Wire - diameter (%) 45.0

POURING TEMPERATURES

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

1040.0

1120.0

1020.0

1060.0

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

<1 mm

620.0

660.0

25.0

1 - 5 mm

620.0

660.0

30.0

>5 mm

620.0

660.0

35.0

Mechanical working quenching

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