

**GENERAL INFORMATION**
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Production process	Universal
Color	Red
Typology	Master alloy for gold

**Melting temperatures**

Liquidus [°C]	990.0
Solidus [°C]	950.0

**Commercial composition**

Silver (%)	3,00
Zinc (%)	2,00
Copper (%)	95,00

## GOLD line

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

L*	85.0
a*	9.6
b*	14.3
c*	16.9

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	11.1
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**Product applications**

Sheet production
Massive chain production
Stamping production
Casting in closed systems
Wire production
Casting without stones
Continuous casting

**Mechanical characteristics**

As cast hardness [HV 0.2]	110.0
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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

**Alternative Products**

OR133	All-purpose master alloy for 585-750‰ (14-18 Kt) red gold
OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold
OR134U	All-purpose master alloy for 750‰ (18 Kt) red gold

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1110.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1085.0	1115.0
0.5 - 1.2 mm	580.0	650.0	1065.0	1085.0
> 1.2 mm	460.0	600.0	1045.0	1065.0

**Trees without stones**

Remove the flask within 1 minute after pouring, then quench immediately in water.

**Stone-in-place casting trees**

Let the flask cool down for 30-45 minutes, then quench in water.

**Pickling**

Dip in RADIAL solution (50 g/l conc. at 60°C for 2 min.), or in sulphuric acid (10% conc. at 50°C for 5 min.)

**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 1110.0

**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	1090.0	1170.0	1070.0	1110.0

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