MASTER ALLOY

TECHNICAL SHEET

OR134UL 585‰

ALL-PURPOSE MASTER ALLOY FOR 750‰ (18 KT) RED GOLD

GENERAL INFORMATION

General information	
Production process	Universal
Color	Red
Typology	Master alloy for gold

Melting temperatures	
Liquidus [°C]	935.0
Solidus [°C]	920.0
Melting range [°C]	15.0

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

GOLD line

FULL CHARACTERIZATION DATA

Color coordinates	
L*	81.2
a*	9.5
b*	14.4

Mechanical characteristics	
As cast hardness [HV 0.2]	130.0

Product applications
Stamping production
Casting in closed systems
Casting without stones
Continuous casting
Wire production
Hollow chain production
Ingot casting
Cladding production
TIG tube production
Hand production
Massive chain production
Sheet production

Print Date 05/06/2019

LEGOR GROUP S.P.A. - Via del Lavoro, 1 - 36050 (VI) - Italy - Tel. +39 0444 467911 - Fax +39 0444 660677 - info@legor.com - www.legor.com

LEGOR MASTER ALLOY

TECHNICAL SHEET

OR134UL 585‰

ALL-PURPOSE MASTER ALLOY FOR 750‰ (18 KT) RED GOLD

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C]	1060.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1040.0	1070.0
0.5 - 1.2 mm	580.0	650.0	1020.0	1040.0
> 1.2 mm	460.0	600.0	1000.0	1020.0

Trees without stones

Remove the flask within 1 minute after pouring, then quench immediately 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]	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

Print Date 05/06/2019

LEGOR GROUP S.P.A. - Via del Lavoro, 1 - 36050 (VI) - Italy - Tel. +39 0444 467911 - Fax +39 0444 660677 - info@legor.com - www.legor.com