

**MASTER
ALLOY**
OR134 875‰

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

GENERAL INFORMATION
General information

Production process	Universal
Color	Red
Color shade	Red
Typology	Master alloy for gold

Melting temperatures

Liquidus [°C]	930.0
Solidus [°C]	920.0
Melting range [°C]	10.0

Commercial composition

Copper (%)	92,00
Zinc (%)	3,00
Silver (%)	5,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	85.6
a*	10.0
b*	19.7
c*	22.1

Physical characteristics

Density [g/cm ³]	16.5
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General characteristics

As cast grain size [μm]	50.0
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Mechanical characteristics

As cast hardness [HV 0.2]	110.0
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CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1050.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1030.0	1060.0
0.5 - 1.2 mm	580.0	650.0	1010.0	1030.0
> 1.2 mm	460.0	600.0	990.0	1010.0

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 45-60 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] 1050.0

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	1030.0	1110.0	1010.0	1050.0

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