

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	940.0
Solidus [°C]	910.0

Commercial composition

Silver (%)	12,00
Copper (%)	87,00
Zinc (%)	1,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	86.0
a*	9.0
b*	15.5

Mechanical characteristics

As cast hardness [HV 0.2]	140.0
Single step age-hardening hardness [HV 0.2]	175.0

Product applications

Casting in closed systems
Casting without stones
Continuous casting
Ingot casting
Wire production
Sheet production
Stamping production
Hand production

RELATED PRODUCTS LIST
Related Products

GFRED	Red gold flash solution for bath plating 0.8 g/l (ready-to-use)
LSR490	Master alloy for soldering of 375-585-750‰ (9-14-18 Kt) red gold

Alternative Products

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