

**MASTER
ALLOY**
WA1481T 375‰

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

GENERAL INFORMATION
General information

Color	White
Color shade	Standard white
Production process	Mechanical working
Typology	Master alloy for gold

Melting temperatures

Solidus [°C]	960.0
Melting range [°C]	95.0
Liquidus [°C]	1055.0

Commercial composition

Copper (%)	70,00
Nickel (%)	13,00
Zinc (%)	17,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	84.5
a*	0.9
b*	10.4
c*	10.4
Yellow index	21.8

General characteristics

As cast grain size [µm]	230.0
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Product applications

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

Mechanical characteristics

As cast hardness [HV 0.2]	115.0
Hardness after annealing [HV 0.2]	130.0
Hardness after 70% area red. [HV 0.2]	285.0
Tensile strength (Rm) [Mpa]	465.0
Yield strength (Rp0.2) [MPa]	228.0
Elongation at rupture (A) [%]	36.0

RELATED PRODUCTS LIST
Related Products

FE5	Iron wire, 5.0 mm diameter, annealed
L1A	Powder for soldering of gold and silver chains
LSB442	Nickel-free master alloy for soldering of 375‰ (9 Kt) white gold
LSB475A	Master alloy for soldering of 750‰ (18 Kt) white gold
LSG409D	Master alloy for soldering of 585‰ (14 Kt) yellow gold
LSG409V	Master alloy for soldering of 750‰ (18 Kt) yellow gold

Alternative Products

NI1811-04	Low nickel release master alloy for mechanical working of 750‰ (18 Kt) white gold
NI1811-05	Low nickel release master alloy for mechanical working of 585‰ (14 Kt) white gold

MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 1175.0

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

1155.0

1235.0

1135.0

1175.0

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

<1 mm

660.0

700.0

30.0

1 - 5 mm

660.0

700.0

35.0

>5 mm

660.0

700.0

40.0

Mechanical working quenching

Let cool in air down to 550°C, then quench in a 50% water/50% alcohol solution or in water