

**MASTER  
ALLOY**
**WB149C 750‰**

MASTER ALLOY FOR CASTING OF 585-750‰ (14-18 KT) WHITE GOLD

**GENERAL INFORMATION**
**General information**

Color	White
Color shade	Off-white
Typology	Master alloy for gold
Production process	Casting

**Melting temperatures**

Liquidus [°C]	900.0
Solidus [°C]	880.0
Melting range [°C]	20.0

**Commercial composition**

Copper (%)	68,00
Nickel (%)	13,00
Zinc (%)	19,00



GOLD line

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

L*	84.5
a*	3.2
b*	15.0
c*	15.3
Yellow index	31.5

**General characteristics**

As cast grain size [µm]	270
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**Product applications**

Casting in open systems
Casting without stones
Stone-in-place casting

**Mechanical characteristics**

As cast hardness [HV 0.2]	175.0
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**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1020.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	990.0	1020.0
0.5 - 1.2 mm	580.0	650.0	970.0	990.0
> 1.2 mm	460.0	600.0	950.0	970.0

**Trees without stones**

Let the flask cool down for 10-15 minutes, then quench 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 5-10 min.), or in sulphuric acid (10% conc. at 50°C for 10 min.)