

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	905.0
Solidus [°C]	865.0

Commercial composition

Silver (%)	18,00
Zinc (%)	1,00
Copper (%)	81,00

GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	84.2
a*	8.0
b*	16.1

Physical characteristics

Density [g/cm ³]	13.1
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Mechanical characteristics

As cast hardness [HV 0.2]	165.0
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Product applications

Continuous casting
Casting without stones
Ingot casting
Stamping production
CNC and lathe production
Sheet production
Casting in closed systems

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1025.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	650.0	720.0	995.0	1025.0
0.5 - 1.2 mm	600.0	650.0	975.0	995.0
> 1.2 mm	560.0	600.0	955.0	975.0

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 30-45 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] 1025.0

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	1005.0	1085.0	985.0	1025.0

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

AGE HARDENING PROCESSING PARAMETERS

SINGLE STEP AGE-HARDENING TREATMENT	Temperature [°C]	Time [min]	Quenching
Age-hardening	300.0	90.0	Air or in furnace