

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

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

**Melting temperatures**

Liquidus [°C]	910.0
Solidus [°C]	890.0

**Commercial composition**

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



GOLD line

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

L*	83.5
a*	8.5
b*	17.3

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	14.9
------------------------------	------

**Mechanical characteristics**

As cast hardness [HV 0.2]	180.0
---------------------------	-------

**Product applications**

Sheet production
CNC and lathe production
Casting without stones
Stamping production
Continuous casting
Blanking production
Age-hardening
Ingot casting
Casting in closed systems

**CASTING PROCESSING PARAMETERS**

Pre-mixing temperature [°C] 1030.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	650.0	720.0	1010.0	1040.0
0.5 - 1.2 mm	600.0	650.0	990.0	1010.0
> 1.2 mm	550.0	600.0	970.0	990.0

**Trees without stones**

Remove the flask within 1 minute after pouring, then quench immediately in water.

**Stone-in-place casting trees**

Remove the flask immediately from the machine. Dip only the bottom part of the tree in cold water and keep under ventilation for 15 minutes. Quench in warm water.

**MECHANICAL WORKING PARAMETERS**

Pre-mixing temperature [°C] 1030.0

**Reductions**

Sheet - area or thickness (%)	75.0
Wire - diameter (%)	45.0

POURING TEMPERATURES	Countinous from [°C]	Countinous to [°C]	Ingot from [°C]	Ingot to [°C]
Temperatures	1010.0	1090.0	990.0	1030.0

MECHANICAL WORKING ANNEALING	Temp. from [°C]	Temp. to [°C]	Time [min]
<1 mm	620.0	660.0	20.0
1 - 5 mm	620.0	660.0	25.0
>5 mm	620.0	660.0	30.0

**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	275.0	90.0	Air or in furnace