

GENERAL INFORMATION
General information

Color	Yellow
Production process	Mechanical working
Typology	Master alloy for gold
Color shade	Light yellow

Melting temperatures

Liquidus [°C]	820.0
Solidus [°C]	795.0
Melting range [°C]	25.0

Commercial composition

Silver (%)	47,00
Copper (%)	51,00
Zinc (%)	2,00

GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	90.2
a*	3.7
b*	17.8
c*	18.2

Physical characteristics

Density [g/cm ³]	13.0
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General characteristics

As cast grain size [μm]	60.0
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Product applications

Ingot casting
Continuous casting
Sheet production
Wire production

Mechanical characteristics

As cast hardness [HV 0.2]	225.0
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RELATED PRODUCTS LIST
Related Products

L1A	Powder for soldering of gold and silver chains
LSG406B	Master alloy for soldering of 750‰ (18 Kt) yellow gold
LSG409V	Master alloy for soldering of 750‰ (18 Kt) yellow gold

Alternative Products

Y142W	Master alloy for mechanical working of 750‰ (18 Kt) yellow gold
C183N	Master alloy for casting of 750‰ (18 Kt) yellow gold

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 950.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	920.0	950.0
0.5 - 1.2 mm	580.0	650.0	900.0	920.0
> 1.2 mm	460.0	600.0	880.0	900.0

Trees without stones

Let the flask cool down for 5 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] 950.0

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	930.0	1010.0	910.0	950.0

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