

GENERAL INFORMATION
General information

Color	Yellow
Production process	Universal
Color shade	Rich yellow
Typology	Master alloy for gold

Melting temperatures

Liquidus [°C]	900.0
Solidus [°C]	874.0
Melting range [°C]	26.0

Commercial composition

Silver (%)	50,00
Copper (%)	50,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	86.0
a*	5.3
b*	23.8
c*	24.4

Physical characteristics

Density [g/cm ³]	15.2
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General characteristics

As cast grain size [µm]	150.0
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Product applications

Age-hardening
Ingot casting
Stamping production
Hand production
Wire production
Casting without stones
Casting in closed systems
Massive chain production
Continuous casting
Sheet production

Mechanical characteristics

As cast hardness [HV 0.2]	140.0
Hardness after annealing [HV 0.2]	155.0
Hardness after 70% area red. [HV 0.2]	250.0
Single step age-hardening hardness [HV 0.2]	245.0
Tensile strength (Rm) [Mpa]	427.0
Yield strength (Rp0.2) [MPa]	298.0
Elongation at rupture (A) [%]	42.0

RELATED PRODUCTS LIST
Related Products

LSG406B	Master alloy for soldering of 750‰ (18 Kt) yellow gold
LSG409V	Master alloy for soldering of 750‰ (18 Kt) yellow gold

Alternative Products

B183N	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] 1020.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1000.0	1030.0
0.5 - 1.2 mm	580.0	650.0	980.0	1000.0
> 1.2 mm	460.0	600.0	960.0	980.0

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 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] 1020.0

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	1000.0	1080.0	980.0	1020.0

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 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