

**MASTER
ALLOY**
C185N1 375‰

MASTER ALLOY FOR CASTING OF 375-585-750‰ (9-14-18 KT) RED GOLD

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	960.0
Solidus [°C]	930.0

Commercial composition

Silver (%)	11,00
Copper (%)	87,00
Zinc (%)	2,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	83.8
a*	8.6
b*	14.3

Mechanical characteristics

As cast hardness [HV 0.2]	140.0
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Product applications

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

RELATED PRODUCTS LIST
Related Products

LSR490	Master alloy for soldering of 375-585-750‰ (9-14-18 Kt) red gold
LSR500	Master alloy for soldering of 585-750‰ (14-18 Kt) red gold

Alternative Products

OR133	All-purpose master alloy for 585-750‰ (14-18 Kt) red gold
OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1080.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1060.0	1090.0
0.5 - 1.2 mm	580.0	650.0	1040.0	1060.0
> 1.2 mm	460.0	600.0	1020.0	1040.0

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.

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.)