

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	935.0
Solidus [°C]	900.0
Melting range [°C]	35.0

Commercial composition

Silver (%)	6,00
Copper (%)	91,00
Zinc (%)	3,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	85.0
a*	9.4
b*	15.3

Physical characteristics

Density [g/cm ³]	12.8
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Mechanical characteristics

As cast hardness [HV 0.2]	125.0
Hardness after annealing [HV 0.2]	140.0
Hardness after 70% area red. [HV 0.2]	245.0

Product applications

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

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

OR134	All-purpose master alloy for 375-585-750‰ (9-14-18 Kt) red gold
OR134C	Master alloy for casting of 375-585-750‰ (9-14-18 Kt) red gold

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1055.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1035.0	1065.0
0.5 - 1.2 mm	580.0	650.0	1015.0	1035.0
> 1.2 mm	460.0	600.0	995.0	1015.0

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 45-60 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.)