

GENERAL INFORMATION
General information

Color	Yellow
Production process	Soldering and brazing
Typology	Solder for gold
Color shade	Light yellow

Melting temperatures

Liquidus [°C]	855.0
Melting range [°C]	85.0
Solidus [°C]	770.0

Working temperatures

Working temperature [°C]	845.0
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Commercial composition

Silver (%)	28,00
Copper (%)	27,00
Indium (%)	25,00
Zinc (%)	20,00



JOINING line

FULL CHARACTERIZATION DATA
Color coordinates

L*	81.1
a*	1.4
b*	26.5
c*	26.5

Physical characteristics

Density [g/cm ³]	16.4
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General characteristics

As cast grain size [μm]	50.0
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Mechanical characteristics

Elongation at rupture (A) [%]	56.0
Yield strength (Rp0.2) [MPa]	122.0
As cast hardness [HV 0.2]	90.0
Hardness after annealing [HV 0.2]	90.0
Hardness after 70% area red. [HV 0.2]	190.0
Tensile strength (Rm) [Mpa]	286.0

MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C] 975.0

Reductions

Wire - diameter (%) 15.0

Sheet - area or thickness (%) 40.0

POURING TEMPERATURES

Countinous from [°C]

Countinous to [°C]

Ingot from [°C]

Ingot to [°C]

Temperatures

955.0

1035.0

975.0

935.0

MECHANICAL WORKING ANNEALING

Temp. from [°C]

Temp. to [°C]

Time [min]

<1 mm

500.0

530.0

15.0

1 - 5 mm

500.0

530.0

20.0

>5 mm

500.0

530.0

25.0

Mechanical working quenching

Quench directly in a 50% water/50% alcohol solution or in water

PRODUCT TECHNICAL GUIDELINES**Preliminary checks**

Please note that in order to correctly evaluate the alloy's hardness to solderability, it is advised to make a numerical calculation by subtracting the base metal solidus temperature value from the solder liquidus temperature value. The higher the number resulting, the more solderable (or the less hard) the alloy can be considered. Please refer to the technical guideline for solders available in the website for further information.