

GENERAL INFORMATION
General information

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

Melting temperatures

Liquidus [°C]	985.0
Solidus [°C]	950.0
Melting range [°C]	35.0

Commercial composition

Silver (%)	5,00
Copper (%)	92,00
Zinc (%)	3,00



GOLD line

FULL CHARACTERIZATION DATA
Color coordinates

L*	85.0
a*	9.6
b*	14.3
c*	16.9

Physical characteristics

Density [g/cm ³]	11.1
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General characteristics

As cast grain size [μm]	270.0
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Product applications

Casting without stones
Sheet production
TIG tube production
Massive chain production
Stamping production
Casting in closed systems
Wire production
Continuous casting

Mechanical characteristics

As cast hardness [HV 0.2]	100.0
Hardness after annealing [HV 0.2]	120.0
Hardness after 70% area red. [HV 0.2]	240.0
Tensile strength (Rm) [Mpa]	414.0
Yield strength (Rp0.2) [MPa]	208.0
Elongation at rupture (A) [%]	29.0

RELATED PRODUCTS LIST
Related Products

GFRED	Red gold flash solution for bath plating 0.8 g/l (ready-to-use)
LSR490	Master alloy for soldering of 375-585-750‰ (9-14-18 Kt) red gold

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1105.0

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1085.0	1115.0
0.5 - 1.2 mm	580.0	650.0	1065.0	1085.0
> 1.2 mm	460.0	600.0	1045.0	1065.0

Trees without stones

Remove the flask within 1 minute after pouring, then quench immediately 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] 1105.0

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	1085.0	1165.0	1065.0	1105.0

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