

TECHNICAL DATA SHEET

JOINEX180HD - 750 ‰

Master alloy for the production of red 750 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a hard soldering and it can be casted in mould or by continuous casting.

TAB.1 - Mechanical data

Hardness as cast	n.d.
Hardness hardened	n.d.
Tensile strength	n.d.
Yield strength	n.d.
Elongation	n.d.

TAB.2 - Physical data

Color	red
Colour Coordinates	
Density	16.59 g/cm ³
Melting Range	Solidus: 816 °C Liquidus: 870 °C

TAB.3 - Heat treatments

Solution annealing	575 °C 20 min
Recrystallization Annealing	575 °C 20 min
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature		970	°C
Casting Temperature	Min:	920	°C
	Max:	1020	°C
First thickness reduction	Lamination:	20	%
	Drawing:	10	%
Following thickness reductions	Lamination:	50	%
	Drawing:	25	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min