

TECHNICAL DATA SHEET

JOINEX330MS - 585 ‰

Master alloy for the production of yellow 585 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a soft 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	yellow
Colour Coordinates	
Density	13.08 g/cm ³
Melting Range	Solidus: 650 °C Liquidus: 750 °C

TAB.3 - Heat treatments

Solution annealing	500 °C 20 min
Recrystallization Annealing	500 °C 20 min
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature		850	°C
Casting Temperature	Min:	800	°C
	Max:	900	°C
First thickness reduction	Lamination:	20	%
	Drawing:	10	%
Following thickness reductions	Lamination:	30	%
	Drawing:	15	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min