

TECHNICAL DATA SHEET

JOINEX636HS + Ag30% - 750 ‰

Master alloy for the production of yellow 750 - 875 - 917 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a very soft soldering and it can be casted in mould or by continuous casting. The use is suggested with the addition of 30 % of pure silver to the master alloy.

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	16.85 g/cm ³
Melting Range	Solidus: 640 °C Liquidus: 753 °C

TAB.3 - Heat treatments

Solution annealing	525 °C 20 min
Recrystallization Annealing	525 °C 20 min
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature		853	°C
Casting Temperature	Min:	803	°C
	Max:	903	°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