

## TECHNICAL DATA SHEET

### JOINEX643HS + Ag08% - 750 ‰

Master alloy for the production of white 750 ‰ 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. The use is suggested with the addition of 8 ‰ 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	white
Colour Coordinates	n.d.
Density	16.56 g/cm <sup>3</sup>
Melting Range	Solidus: 661 °C Liquidus: 788 °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		888	°C
Casting Temperature	Min:	838	°C
	Max:	938	°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