

TECHNICAL DATA SHEET

JOINEX677M + Ag05% - 750 ‰

Master alloy for the production of red 375 - 417 - 585 - 750 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a medium soldering and it can be casted in mould or by continuous casting. The use is suggested with the addition of 5 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	140	HV
Hardness hardened	n.d.	
Tensile strength	394	MPa
Yield strength	267	MPa
Elongation	44	%

TAB.2 - Physical data

Color	yellow
Colour Coordinates	L*: 82.05 a*: 4.21 b*: 18.04
Density	14.42 g/cm ³
Melting Range	Solidus: 793 °C Liquidus: 893 °C

TAB.3 - Heat treatments

Solution annealing	540 20	°C min
Recrystallization Annealing	540 20	°C min
Hardening	n.d.	

TAB.4 - Mechanical working parameters

Premelting temperature		993	°C
Casting Temperature	Min:	943	°C
	Max:	1043	°C
First thickness reduction	Lamination:	20	%
	Drawing:	10	%
Following thickness reductions	Lamination:	40	%
	Drawing:	20	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min