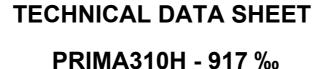




Metaltech srl | Via Saviabona 113/G | 36010 | Cavazzale di Monticello Conte Otto (VI) | ITALIA C.F. e P.IVA 03955300243 | Reg. Imprese VI: 03955300243 | REA: VI - 367516 | Cap. Soc. € 10.000,00 i.v.





Master alloy for the production of yellow 375 - 417 - 585 - 917 ‰ gold jewellery obtained by investment casting. This product, thanks to its complex composition made of numerous different special elements, ensures an extreme level of deoxidation, an extreme surface quality, an enhanced fluidity and a long lasting of this features also after many reuses of casting scraps, making it the most advanced solution for castings with and without stones in place.

TAB.1 - Mechanical data

Hardness as cast		84	HV	
Hardness hardened		n.d.		
Tensile strength		n.d.		
Yield strength		n.d.		
Elongation		n.d.		
TAB.2 - Physical data				

Color	Deep yellow		
Colour Coordinates	L*: 86.84 a*: 7.34 b*: 24.28		
Density	17.85 g/cm3		
Melting Range	Solidus: 913 °C Liquidus: 952 °C		

TAB.3 - Heat treatments

Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	275 180	°C min











TAB.4 - Investment casting parameters

Premelting temperature		1052	°C
Casting Temperature	Min: Max:	1002 1102	°C
Water investment powder ratio		36-38	%
Flask temperature	Min: Max:	450 700	°C
Quenching time without stones in place	Min: Max:	5 20	min min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4: Temp: Time:	20 50 50	% °C min