

## TECHNICAL DATA SHEET

### SPARK318H - 875 ‰

Master alloy for the production of yellow 875 - 917 ‰ gold jewellery obtained by investment casting. The elements contained in this product ensure a high deoxidation in casting and a high surface quality, making it suitable for castings with and without stones in place.

TAB.1 - Mechanical data

Hardness as cast	120	HV
Hardness hardened	n.d.	
Tensile strength	360	MPa
Yield strength	156	MPa
Elongation	53	%

TAB.2 - Physical data

Color	Deep yellow		
Colour Coordinates	L*:	87.21	
	a*:	8.84	
	b*:	21.89	
Density	16.54	g/cm <sup>3</sup>	
Melting Range	Solidus:	915	°C
	Liquidus:	932	°C

TAB.3 - Heat treatments

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

TAB.4 - Investment casting parameters

Premelting temperature		1032	°C
Casting Temperature	Min:	982	°C
	Max:	1082	°C
Water investment powder ratio		36-38	%
Flask temperature	Min:	450	°C
	Max:	700	°C
Quenching time without stones in place	Min:	5	min
	Max:	20	min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4:	20	%
	Temp:	50	°C
	Time:	50	min