

TECHNICAL DATA SHEET

SPARK318H - 917 ‰

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	97	HV
Hardness hardened	n.d.	
Tensile strength	325	MPa
Yield strength	158	MPa
Elongation	28	%

TAB.2 - Physical data

Color	Deep yellow		
Colour Coordinates	L*:	86.47	
	a*:	8.85	
	b*:	24.05	
Density	17.38	g/cm ³	
Melting Range	Solidus:	945	°C
	Liquidus:	960	°C

TAB.3 - Heat treatments

Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1060	°C
Casting Temperature	Min: Max:	1010 1110	°C °C
Water investment powder ratio		36-38	%
Flask temperature	Min: Max:	450 700	°C °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