

TECHNICAL DATA SHEET

SPARK352H - 750 ‰

Master alloy for the production of yellow 750 ‰ 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	135	HV
Hardness hardened	220	HV
Tensile strength	450	MPa
Yield strength	267	MPa
Elongation	33	%

TAB.2 - Physical data

Color	Pale yellow		
Colour Coordinates	L*:	89.87	
	a*:	2.91	
	b*:	23.95	
Density	16.86	g/cm ³	
Melting Range	Solidus:	865	°C
	Liquidus:	894	°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		994	°C
Casting Temperature	Min:	944	°C
	Max:	1044	°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