

## TECHNICAL DATA SHEET

### SPARK695LR + Ag3,8% - 585 ‰

Master alloy for the production of red <CARATURA> ‰ 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. The use is suggested with the addition of 0 - 20 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	130	HV
Hardness hardened	n.d.	
Tensile strength	358	MPa
Yield strength	197	MPa
Elongation	48	%

TAB.2 - Physical data

Color	Russian red		
Colour Coordinates	L*:	82.74	
	a*:	8.48	
	b*:	15.53	
Density	12.85	g/cm <sup>3</sup>	
Melting Range	Solidus:	900	°C
	Liquidus:	920	°C

TAB.3 - Heat treatments

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

TAB.4 - Investment casting parameters

Premelting temperature		1020	°C
Casting Temperature	Min:	970	°C
	Max:	1070	°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