

TECHNICAL DATA SHEET

JOINEX636HS + Ag30% - 875 ‰

Master alloy for the production of yellow 750 - 875 - 917 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a very soft soldering and it can be casted in mould or by continuous casting. The use is suggested with the addition of 30 % of pure silver to the master alloy.

TAB.1 - Mechanical data

| | |
|-------------------|------|
| Hardness as cast | n.d. |
| Hardness hardened | n.d. |
| Tensile strength | n.d. |
| Yield strength | n.d. |
| Elongation | n.d. |

TAB.2 - Physical data

| | |
|--------------------|-------------------------------------|
| Color | yellow |
| Colour Coordinates | |
| Density | 16.68 g/cm ³ |
| Melting Range | Solidus: 786 °C Liquidus: 886 °C |

TAB.3 - Heat treatments

| | |
|-----------------------------|------------------|
| Solution annealing | 525 °C 20 min |
| Recrystallization Annealing | 525 °C 20 min |
| Hardening | n.d. |

TAB.4 - Mechanical working parameters

| | | | |
|--------------------------------|-------------|------|-----|
| Premelting temperature | | 986 | °C |
| Casting Temperature | Min: | 936 | °C |
| | Max: | 1036 | °C |
| First thickness reduction | Lamination: | 20 | % |
| | Drawing: | 10 | % |
| Following thickness reductions | Lamination: | 30 | % |
| | Drawing: | 15 | % |
| Pickling after annealing | H2SO4: | 20 | % |
| | Temp: | 50 | °C |
| | Time: | 5 | min |