

TECHNICAL DATA SHEET

JOINEX676S + Ag17% - 750 ‰

Master alloy for the production of yellow 375 - 417 - 585 - 750 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a soft soldering and it can be casted in mould or by continuous casting. The use is suggested with the addition of 17 % 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	3N yellow		
Colour Coordinates			
Density	16.68	g/cm ³	
Melting Range	Solidus:	730	°C
	Liquidus:	822	°C

TAB.3 - Heat treatments

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

TAB.4 - Mechanical working parameters

Premelting temperature		922	°C
Casting Temperature	Min:	872	°C
	Max:	972	°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