

TECHNICAL DATA SHEET

JOINEX677M + Ag05% - 585 ‰

Master alloy for the production of red 375 - 417 - 585 - 750 ‰ gold soldering sheets and wires. The resulting alloy is categorized as a medium soldering and it can be casted in mould or by continuous casting. The use is suggested with the addition of 5 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	162	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	yellow
Colour Coordinates	L*: 84.55 a*: 3.51 b*: 18.64
Density	12.12 g/cm ³
Melting Range	Solidus: 801 °C Liquidus: 888 °C

TAB.3 - Heat treatments

Solution annealing	570 °C 20 min
Recrystallization Annealing	570 °C 20 min
Hardening	n.d.

TAB.4 - Mechanical working parameters

Premelting temperature		988	°C
Casting Temperature	Min:	938	°C
	Max:	1038	°C
First thickness reduction	Lamination:	20	%
	Drawing:	10	%
Following thickness reductions	Lamination:	40	%
	Drawing:	20	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min