

TECHNICAL DATA SHEET

JOINEX678S + Ag10% - 585 ‰

Master alloy for the production of red 375 - 585 ‰ 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 10 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	136	HV
Hardness hardened	n.d.	
Tensile strength	405	MPa
Yield strength	215	MPa
Elongation	52	%

TAB.2 - Physical data

Color	yellow
Colour Coordinates	L*: 85.84 a*: 5.42 b*: 18.08
Density	12.62 g/cm ³
Melting Range	Solidus: 777 °C Liquidus: 838 °C

TAB.3 - Heat treatments

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

TAB.4 - Mechanical working parameters

Premelting temperature		938	°C
Casting Temperature	Min:	888	°C
	Max:	988	°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