

## TECHNICAL DATA SHEET

### JOINEX678S + Ag10% - 750 ‰

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	161	HV
Hardness hardened	n.d.	
Tensile strength	425	MPa
Yield strength	310	MPa
Elongation	41	%

TAB.2 - Physical data

Color	yellow		
Colour Coordinates	L*:	84.64	
	a*:	6.42	
	b*:	19.78	
Density	14.58	g/cm <sup>3</sup>	
Melting Range	Solidus:	743	°C
	Liquidus:	843	°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		943	°C
Casting Temperature	Min:	893	°C
	Max:	993	°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