

TECHNICAL DATA SHEET

PRIMA680L + Ag20% - 375 ‰

Master alloy for the production of yellow 375 - 417 - 585 ‰ gold jewellery obtained by investment casting. This product, thanks to its complex composition made of numerous different special elements, ensures an extreme level of deoxidation, an extreme surface quality, an enhanced fluidity and a long lasting of this features also after many reuses of casting scraps, making it the most advanced solution for castings with and without stones in place. The use is suggested with the addition of 10 - 30 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	121	HV
Hardness hardened	249	HV
Tensile strength	375	MPa
Yield strength	169	MPa
Elongation	48	%

TAB.2 - Physical data

Color	Deep yellow		
Colour Coordinates	L*:	91.68	
	a*:	1.09	
	b*:	18.55	
Density	11.08	g/cm ³	
Melting Range	Solidus:	777	°C
	Liquidus:	869	°C

TAB.3 - Heat treatments

Solution annealing	675 20	°C min
Recrystallization Annealing	675 20	°C min
Hardening	275 180	°C min

TAB.4 - Investment casting parameters

Premelting temperature		969	°C
Casting Temperature	Min:	919	°C
	Max:	1019	°C
Water investment powder ratio		36-38	%
Flask temperature	Min:	450	°C
	Max:	700	°C
Quenching time without stones in place	Min:	5	min
	Max:	20	min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4:	20	%
	Temp:	50	°C
	Time:	50	min