

## TECHNICAL DATA SHEET

### SPARK696LIR + Ag12% - 417 ‰

Master alloy for the production of red 375 - 417 - 585 ‰ gold jewellery obtained by investment casting. The elements contained in this product ensure a high deoxidation in casting and a high surface quality, making it suitable for castings with and without stones in place. The use is suggested with the addition of 10 - 20 % of pure silver to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	102	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	Deep red		
Colour Coordinates	L*:	86.55	
	a*:	6.96	
	b*:	17.57	
Density	11.45	g/cm <sup>3</sup>	
Melting Range	Solidus:	867	°C
	Liquidus:	929	°C

TAB.3 - Heat treatments

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

TAB.4 - Investment casting parameters

Premelting temperature		1029	°C
Casting Temperature	Min:	979	°C
	Max:	1079	°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