

TECHNICAL DATASHEET AND GUIDELINE

LSG408
Title 18 Kt

Master alloy for soldering of 750‰ (18 Kt) yellow gold

GENERAL INFORMATION

Typology	Solder for gold
Production process	Soldering
Color	Yellow
Color shade	Green yellow
Density [g/cm ³]	14.4
Melting temperatures	
Solidus [°C]	670
Liquidus [°C]	760

Commercial composition	
Ag (%)	26
Cu (%)	33
In (%)	16
Zn (%)	25



FULL CHARACTERIZATION DATA

General characteristics	
As cast grain size [μm]	120
Color coordinates	
L*	88
a*	0.2
b*	20.5
c*	20.5

Mechanical characteristics	
Tensile strength (Rm) [MPa]	394
Yield strength (Rp0.2) [MPa]	318
Elongation at rupture (A) [%]	13
As cast hardness [HV 0.2]	189
Hardness after 70% area red. [HV 0.2]	217
Hardness after annealing [HV 0.2]	199

MECHANICAL WORKING PARAMETERS

Casting temperature	Temperature - from [°C]	Temperature - to [°C]	Recommended reductions	
Ingot making	840	880	Sheet - area or thickness [%]	50
Continuous casting	860	940	Wire - diameter [%]	30

Mechanical working recommended annealing	Temperature - from [°C]	Temperature - to [°C]	Time [min]
> 5 mm	520	550	30
1 - 5 mm	520	550	25
< 1 mm	520	550	20