

TECHNICAL DATASHEET AND GUIDELINE

LSG419
Title 9 Kt

Master alloy for soldering of 375‰ (9Kt) yellow gold

GENERAL INFORMATION

Typology	Solder for gold
Production process	Soldering
Color	Yellow
Color shade	Green yellow
Density [g/cm ³]	11.3
Melting temperatures	
Solidus [°C]	620
Liquidus [°C]	680

Commercial composition	
Ag (%)	50
Cu (%)	28
In (%)	6
Zn (%)	16



FULL CHARACTERIZATION DATA

General characteristics	
As cast grain size [μm]	120
Color coordinates	
L*	87.7
a*	-0.9
b*	14.4
c*	14.4

Mechanical characteristics	
Tensile strength (Rm) [MPa]	781
Yield strength (Rp0.2) [MPa]	540
Elongation at rupture (A) [%]	2
As cast hardness [HV 0.2]	183
Hardness after 70% area red. [HV 0.2]	267
Hardness after 70% area red. [HV 0.2]	231

MECHANICAL WORKING PARAMETERS

Casting temperature	Temperature - from [°C]	Temperature - to [°C]	Recommended reductions	
Ingot making	760	800	Sheet - area or thickness [%]	50
Continuous casting	780	860	Wire - diameter [%]	30

Mechanical working recommended annealing	Temperature - from [°C]	Temperature - to [°C]	Time [min]
> 5 mm	500	530	25
1 - 5 mm	500	530	20
< 1 mm	500	530	15