Your jewelry technology provider LEGOR GROUP MASTER ALLOY DIVISION

WA1482B Master alloy for mechanical working of

Technical datasheet and guideline for 9 Kt

GENERAL INFORMATION AND RECOMMENDED APPLICATIONS

Typology	**Master alloy for gold**
Production process	**Mechanical working**
Color	**White**

Color	**Standard white**
Density [g/cm³]	**10.8**
Melting temperatures	**Solidus [°C] 900** **Liquidus [°C] 1035**
As cast hardness [HV 0.2]	**120**

Product applications

Ingot casting
Continuous casting
Sheet production
Wire production
Hollow chain production
TIG tube production
Cladding production

FULL CHARACTERIZATION DATA

General characteristics

As cast grain size [µm]	120

Color coordinates

L*	85.4
a*	0.6
b*	11.6
c*	11.6
Color shade	Standard white

Mechanical characteristics

Tensile strength (Rm) [MPa]	435
Yield strength (Rp0.2) [MPa]	208
Elongation at rupture (A) [%]	38
As cast hardness [HV 0.2]	120
Hardness after 70% area red. [HV 0.2]	285
Hardness after annealing [HV 0.2]	125

CASTING PROCESSING PARAMETERS

Pre-mixing temperature [°C] 1155

Casting temperature	Metal - from	Metal - to [°C]	Flask - from	Flask - to [°C]

Casting temperatures	[°C]	Metal - to [°C]	[°C]	Flask - to [°C]

MECHANICAL WORKING PARAMETERS

Pre-mixing temperature [°C]	1155

Casting temperature	Metal - from [°C]	Metal - to [°C]
Ingot making	**1115**	**1145**
Continuous casting	**1135**	**1215**

Reccomended reductions	
Sheet - area or thickness [%]	**60**
Wire - diameter [%]	**40**

Mechanical working recommended annealing	Temperature - from [°C]	Temperature - to [°C]	Time [min]
> 5 mm	660	700	40
1 - 5 mm	660	700	35
< 1 mm	660	700	30