

**MASTER
ALLOY**
C185N 375‰

MASTER ALLOY FOR CASTING OF 375-585-750‰ (9-14-18 KT) RED GOLD

GENERAL INFORMATION
General information

Typology	Master alloy for gold
Color	Red
Color shade	Red
Production process	Casting
Grain refinement level	High
Deoxidation level	Medium

Commercial composition (%)

CU	92.1
AG	4.4
ZN	3.5

Melting Temperatures

Solidus [°C]	950.0
Liquidus [°C]	980.0
Melting range [°C]	30.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
83.5	9.2	15.0		

Mechanical characteristics

As cast hardness [HV 0.2]	120.0
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Physical characteristics

Density [g/cm ³]	11.0
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Product applications

Stone-in-place casting
 Casting in closed systems
 Casting in open systems
 Casting without stones

CASTING PROCESSING PARAMETERS

POURING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1080	1110
0.5 - 1.2 mm	580	650	1060	1080
> 1.2 mm	460	600	1040	1060

Trees without stones

Let the flask cool down for 10-15 minutes, then quench it in water.

Stone-in-place casting trees

Let the flask cool down for 45-60 minutes, then quench it in water.

Pickling

Dip in RADIAL solution (50 g/l conc. at 60°C) for 2 minutes, or in sulphuric acid (10% concentration at 50°C) for 5 minutes.