



Master Alloys Technical Specification

Doc No:MA/WG/05

MA1074

General Purpose Alloy for 18Kt White Gold

General Information

1	Suitable Karatage	18KT	4	Application	General/Casting Purpose
2	Color	White	5	Solid State Hardness After Melting	18KT : 95HRB
3	Color Shade	Off White			

Melting Parameters

	Karatage	Temperature *C	Time min.sec
1	18KT	910	4.2

Casting Parameters

	Karatage	Melting Casting Temperature		Investment Flask Temperature	
		Temp	Quenching Time	Temp	Type of Casting
1	18KT	1020	15 minutes	600	Vacuum Casting

Mechanical Working Parameters

	Thickness	Temperature *C	Time
Annealing	>5	650	35
	1-5mm	650	30
	<1mm	650	25

Color Coordinates

18KT		
L	a	b
89.5	4.02	17.2

Technical Guidelines

1	To optimize homogenization of the elements in the alloy, pre-mix material, by granulation or by casting of a semifinished bar.
2	Ensure an inert atmosphere of N2 Gas over the metal during melting.
3	After casting, wait for 5 minutes , then quench in normal water.
4	Upon reaching melting temperature, hold metal for few minutes and stir with graphite stirrer before pouring into mold.
5	Induction melting is strongly recommended.
6	Very Good for Machining, Sheet production, Stamping Production and Casting w/o stones.
7	After casting, leave flask for 20 to 30 minutes , then quench in normal water.
8	Pickling in sulfuric acid (10% conc. At 60°C for 5 min.).

Remarks: The information is for reference only. The parameters should be adjusted according to the particular casting conditions.

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