



Master Alloys Technical Specifications

Doc No
MA/YG/04

PY1111-PX4

General Purpose Alloy for 22Kt Yellow Gold

General Information

1	Suitable Karatage	22KT	4	Application	General-Hand made and Machine Made
2	Color	Yellow	5	Solid State Hardness After Melting	22 KT : 79HRB
3	Color Shade	Pinkish Yellowish			

Melting Parameters

	Karatage	Temperature *C	Time min.sec
1	22KT	900	3.5

Casting Parameters

	Karatage	Melting Casting Temperature		Investment Flask Temperature	
		Temp	Quenching Time	Temp	Type of Casting
1	22KT	960	15 minutes	650	Vacuum Casting

Mechanical Working Parameters

	Thickness	Temperature *C	Time
Annealing	>5	450	35
	1-5mm	450	30
	<1mm	450	25

Color Coordinates

22KT					
L	a	b			
91.34	11.74	29.2			

Technical Guidelines

1	For mixing, place master alloy grains under the gold in the crucible.
2	For better results during melting, the metal should be in an inert atmosphere of N2 Gas.
3	After reaching the melting temperature hold metal for few minutes and stir it with graphite stirrer before
4	Induction melting is highly recommended.
5	After casting, leave flask in the machine for a minimum of 15 minutes, then quench in normal water.
6	Pickling in sulfuric acid (10% conc. At 60°C for 5 min.)
7	Very Good for Chains, Balls, Wires, Bangles etc.

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

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