



Master Alloys Technical Specifications

Doc No
MA/YG/01

YG801

General Purpose Alloy for 22Kt and 18Kt Yellow Gold

General Information

1	Suitable Karatage	18KT/22KT	4	Application	Mechanical
2	Color	Yellow	5	Solid State Hardness After Melting	22 KT : 76HRB
3	Color Shade	Deep Yellow			18KT : 81.5HRB

Melting Parameters

	Karatage	Temperature *C	Time min.sec
1	22KT	900	4.5
2	18KT	850	4

Mechanical Working Parameters

	Thickness	Temperature *C	Time
Annealing	>5	500	30
	1-5mm	500	25
	<1mm	500	20

Color Coordinates

22KT			18KT		
L	a	b	L	a	b
89.42	10.12	32.78	90.56	9.5	27.3

Technical Guidelines

1	For mixing, place master alloy grains under the gold in the crucible.
2	Ensure an inert atmosphere of N2 Gas over the metal during melting.
3	On reaching the melting temperature, hold metal for few minutes and stir with graphite stirrer before pouring into mould.
4	Induction melting is strongly recommended.
5	After casting, leave flask for atleast 15 minutes and then quench in normal water.
6	Pickling in sulfuric acid (10% conc. At 60°C for 5 min.)
7	Ideal alloy for 22Kt handmade jewellery. Also recommended for 18 Kt chains.

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

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