PRODUCT CODE	**SR106**
FINENESS	**375 (9K)**
COLOR	**KOREAN RED**

Brief description

Master alloy for red gold 9, 10, 14 K. The formulation of SR106 is suitable for casting in open and closed systems. This alloy combines a KOREAN red colour with a bright casted tree. The colour obtained with SR106 is KOREAN red. The hardness of gold produced with SR106 cannot be increased with heat treatment.

Suitable applications

Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting
□□□□□	□□□□□	□□□□□	□□□□□	□□□□□	■■■■□	■■■■□	■■■■□

Proprieties

Commercial composition	Cu96 Ag2 Zn2	Alloy's main elements (%)
Density	11.1	(g/cm³)
Melting Range	965-990	Solidus - Liquidus (°C)
Hardness	90-N.A.	Annealed - Hardened (HV)

Mould casting

Put first the alloy in the crucible and cover it with pure gold. Heat the metal 50-100°C more than Liquidus temperature, while protecting the melting with a reducing flame or keeping it in protective atmosphere. Heat the mould at 150 - 200°C and, when the melting temperature is reached, stir the metal and pour it in the mould; after casting, open the mould and cool the metal immediately.

Continuous casting

Not suitable.

Mechanical work

Not suitable.

Annealing

Heat the metal in protective atmosphere at 700°C for 15-30min (depending on the quantity), then cool it in a solution of 90% water and 10% alcohol or in warm water (~40°C).

Hardening

Not suitable.

Casting

Cylinders' temperature should be 500-700°C, based on casted items' size and models' intricacy. It is preferable to pre-melt the alloy with gold before casting. Casting temperature is 50-100°C higher than the liquidus temperature of the alloy. After casting wait 15-20 min before cooling the metal in warm water (≃35°C). In case of wax setting of stones wait from 30 to 45 min.

Pickling

Sulfuric acid (H_2SO_4) at 10% concentration and 50-60°C can be used to remove surface oxide. Rinse with attention the metal after pickling.

Scraps reuse

Up to 50% scraps can be added to the melting, removal of sprue button is suggested. Always pay attention to the cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.

PRODUCT CODE	**SR106**
FINENESS	**417 (10K)**
COLOR	**KOREAN RED**

Brief description

Master alloy for red gold 9, 10, 14 K. The formulation of SR106 is suitable for casting in open and closed systems. This alloy combines a KOREAN red colour with a bright casted tree. The colour obtained with SR106 is KOREAN red. The hardness of gold produced with SR106 cannot be increased with heat treatment.

Suitable applications

Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting
□□□□□	□□□□□	□□□□□	□□□□□	□□□□□	■■■■□	■■■■□	■■■■□

Proprieties

Commercial composition	Cu96 Ag2 Zn2	Alloy's main elements (%)
Density	11.4	(g/cm³)
Melting Range	965-985	Solidus - Liquidus (°C)
Hardness	100-N.A.	Annealed - Hardened (HV)

Mould casting

Put first the alloy in the crucible and cover it with pure gold. Heat the metal 50-100°C more than Liquidus temperature, while protecting the melting with a reducing flame or keeping it in protective atmosphere. Heat the mould at 150 - 200°C and, when the melting temperature is reached, stir the metal and pour it in the mould; after casting, open the mould and cool the metal immediately.

Continuous casting

Not suitable.

Mechanical work

Not suitable.

Annealing

Heat the metal in protective atmosphere at 690°C for 15-30min (depending on the quantity), then cool it in a solution of 90% water and 10% alcohol or in warm water (~40°C).

Hardening

Not suitable.

Casting

Cylinders' temperature should be 500-700°C, based on casted items' size and models' intricacy. It is preferable to pre-melt the alloy with gold before casting. Casting temperature is 50-100°C higher than the liquidus temperature of the alloy. After casting wait 15-20 min before cooling the metal in warm water (≃35°C). In case of wax setting of stones wait from 30 to 45 min.

Pickling

Sulfuric acid (H_2SO_4) at 10% concentration and 50-60°C can be used to remove surface oxide. Rinse with attention the metal after pickling.

Scraps reuse

Up to 50% scraps can be added to the melting, removal of sprue button is suggested. Always pay attention to the cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.

PRODUCT CODE	**SR106**
FINENESS	**585 (14K)**
COLOR	**KOREAN RED**

Brief description

Master alloy for red gold 9, 10, 14 K. The formulation of SR106 is suitable for casting in open and closed systems. This alloy combines a KOREAN red colour with a bright casted tree. The colour obtained with SR106 is KOREAN red. The hardness of gold produced with SR106 cannot be increased with heat treatment.

Suitable applications

Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting
□□□□□	□□□□□	□□□□□	□□□□□	□□□□□	■■■■□	■■■■□	■■■■□

Proprieties

Commercial composition	Cu96 Ag2 Zn2	Alloy's main elements (%)
Density	12.8	(g/cm³)
Melting Range	920-945	Solidus - Liquidus (°C)
Hardness	110-N.A.	Annealed - Hardened (HV)

Mould casting

Put first the alloy in the crucible and cover it with pure gold. Heat the metal 50-100°C more than Liquidus temperature, while protecting the melting with a reducing flame or keeping it in protective atmosphere. Heat the mould at 150 - 200°C and, when the melting temperature is reached, stir the metal and pour it in the mould; after casting, open the mould and cool the metal immediately.

Continuous casting

Not suitable.

Mechanical work

Not suitable.

Annealing

Heat the metal in protective atmosphere at 690°C for 15-30min (depending on the quantity), then cool it in a solution of 90% water and 10% alcohol or in warm water (~40°C).

Hardening

Not suitable.

Casting

Cylinders' temperature should be 500-700°C, based on casted items' size and models' intricacy. It is preferable to pre-melt the alloy with gold before casting. Casting temperature is 50-100°C higher than the liquidus temperature of the alloy. After casting wait 15-20 min before cooling the metal in warm water (≃35°C). In case of wax setting of stones wait from 30 to 45 min.

Pickling

Sulfuric acid (H_2SO_4) at 10% concentration and 50-60°C can be used to remove surface oxide. Rinse with attention the metal after pickling.

Scraps reuse

Up to 50% scraps can be added to the melting, removal of sprue button is suggested. Always pay attention to the cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.