

PRODUCT CODE	SF302Y
FINENESS	750 (18K)
COLOR	YELLOW



Brief description

Master alloy for yellow gold 18K. The formulation of SF302Y makes it suitable for casting in open or closed systems. The most notable feature of this alloy is its high brightness after polishing. The composition of gold produced with SF302Y complies to 2N standard. The hardness of gold produced with SF302Y can be increased with heat treatment.

Suitable applications

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

Silver Quantity	57%	Amount of silver contained in the alloy (%)
Density	14.9	(g/cm ³)
Melting Range	860-910	Solidus - Liquidus (°C)
Hardness	130-195	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 200 - 250°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

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Mechanical work

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Annealing

Heat the metal in protective atmosphere at 640°C for 10-30min (depending on the quantity), then quickly cool it in a solution of 50% water and 50% alcohol or in warm water (≈40°C).

Hardening

Heat the metal in protective atmosphere at 275°C from 1 up to 3 hours, then let it cool slowly in protective atmosphere until room temperature is reached.

Casting

Flasks' temperature should be between 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. After casting wait 5-20 min before cooling the metal in warm water (≈40°C). In case of casting with stones, wait 30-45 min.

Pickling

Sulfuric acid (H₂SO₄) 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.