

PRODUCT CODE	SY10 UAG
FINENESS	375 (9K)
COLOR	YELLOW



Brief description

Master alloy for 9 and 10K yellow gold mechanical works. Gold produced with SY10 UAG has an orange-yellow shade. This alloy is the perfect solution for low carats mechanical productions. The hardness of gold produced with SY10 UAG can be slightly increased with proper 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	12%	Amount of silver <u>contained</u> in the alloy (%)
Density	11.1	(g/cm ³)
Melting Range	855-930	Solidus - Liquidus (°C)
Hardness	110-135	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 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

When using a continuous casting machine, it is preferable to pre-melt gold and alloy. Alloyed gold can then be poured in a mould or in water and re-melted in the continuous casting machine, or poured directly in the machine's crucible, heating it until it reaches alloy's liquidus temperature. Always protect the melting using a reducing flame over the molten metal. Machine's speed should be as high as possible.

Mechanical work

For the best mechanical results, reduce the section of the wire or plate at least of 50% before proceeding with the annealing process. The first reduction steps should be strong enough to ensure the metal inner part compacting.

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 90% water and 10% alcohol or in warm water (≈40°C).

Hardening

Heat the metal in protective atmosphere at 250°C for 1-3 hours, then let it cool slowly in protective atmosphere until room temperature is reached.

Casting

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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. Always pay attention to the cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.

PRODUCT CODE	SY10 UAG
FINENESS	417 (10K)
COLOR	YELLOW



Brief description

Master alloy for 9 and 10K yellow gold mechanical works. Gold produced with SY10 UAG has an orange-yellow shade. This alloy is the perfect solution for low carats mechanical productions. The hardness of gold produced with SY10 UAG can be slightly increased with proper 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	12%	Amount of silver contained in the alloy (%)
Density	11.4	(g/cm ³)
Melting Range	900-920	Solidus - Liquidus (°C)
Hardness	100-125	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 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

When using a continuous casting machine, it is preferable to pre-melt gold and alloy. Alloyed gold can then be poured in a mould or in water and re-melted in the continuous casting machine, or poured directly in the machine's crucible, heating it until it reaches alloy's liquidus temperature. Always protect the melting using a reducing flame over the molten metal. Machine's speed should be as high as possible.

Mechanical work

For the best mechanical results, reduce the section of the wire or plate at least of 50% before proceeding with the annealing process. The first reduction steps should be strong enough to ensure the metal inner part compacting.

Annealing

Heat the metal in protective atmosphere at 670°C for 10-30min (depending on the quantity), then quickly cool it in a solution of 90% water and 10% alcohol or in warm water (≈40°C).

Hardening

Heat the metal in protective atmosphere at 250°C for 1-3 hours, then let it cool slowly in protective atmosphere until room temperature is reached.

Casting

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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. Always pay attention to the cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.