

METALOR[®]**Data sheet for alloy****Au 375/429**

Division Watches and Jewelry

Colour **yellow**Code **429**

General description 9 ct standard yellow gold alloy, for universal use. It can easily be cupped, stamped, rolled, polished, drawn and machined. Suitable for casting in air.

Physical properties Specific gravity [g/cm³] **11.15** Melting range [°C] **805-895**

Mechanical properties			Annealed	20% cold worked	75% cold worked
Vickers hardness		[HV1]	130	180	250
Yield hardness	Rm	[Mpa]	500	600	1000
Elastic limit	Rp0.2	[MPa]	300	500	900
Plastic elongation	A	[%]	40	5	1

Processing guidelines

ANNEALING 625 °C for 20 to 30 minutes then quenched in water or cooling under protective atmosphere (in this case it can harden a light). In order to avoid oxidation, work under reducing atmosphere.

COLD WORKING The amount of coldwork completed before annealing should be between 30% and 75% reduction in area.

SOLDERING By torch or furnace. The cadmium-free solders N° 331 (775-785 °C) - 332 (700-750 °C) and 335 (655-700 °C) are strongly recommended. For alternatives please see list of solders.

PICKLING with DESOXYD (following operating instructions) or with hot 10% sulphuric acid.

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18.03.2005 [METALOR Technologies SA](http://www.metalor.com) - Av. du Vignoble - CH-2009 Neuchâtel
Phone: +41(0)32 720 61 11 - <http://www.metalor.com/watch>

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