

Heimerle + Meule GmbH Dennigstr. 16, D - 75179 Pforzheim Phone: + 49 (0) 7231-940-0 www.heimerle-meule.com	<h2>Material data</h2>	WKD – 137.585
		Date: 05/2014

Alloy	Au 585 Pd 4	(Ni free)
Item-no.	137 - 585	
Colour	white Mn	
Precious metals	Au 58,5 Ag 28,5 Pd 4,0	[%]
Density	13,5	[g/cm ³]
Melting range	915 - 985	[°C]

Annealing:	Protective atmosphere (if need be salt bath)	
Annealing temperature	700	[°C]
Cooling	Slowly up to 350 °C under protective atmosphere, after that cooling in water	
Pickling	Diluted sulphuric acid or phosphoric acid, Vitrex	
Material properties:	soft - annealed	
Hardness	120-160	[HV]
Tensile strength	450 - 550	[MPa]
Yield point	280 - 360	[MPa]
Elongation	> 35	[%]
Solder:	Pretreatment Deoxidize areas to be soldered	
Treatment	Hydrozon	
Flux	Boraxin, flux H, partially Fluoron	
Cleaning / pickling	Diluted sulphuric acid or phosphoric acid, Vitrex	

Portrait of alloy

- Hard, white gold alloy, non-hardening
- Reduced Pd contents, Ni – free
- Excellent workability for jewellery fabrication (high ductility, good cutting properties)
- Suitable for sintering technologies
- Do not plate with rhodium
- Ring blanks, delivery hardness: approx. 140 HV
- Because of oxidizing of alloy components special procedures are required during any heat treatment (reducing atmosphere, using flux)

For memoire-rings and tension rings we recommend using our Pd – white gold alloys 131-585 and 136-585.