

Heimerle + Meule GmbH Dennigstr. 16, D - 75179 Pforzheim Phone: + 49 (0) 7231-940-0 www.heimerle-meule.com	<h2>Material data</h2>	WKD – 137.750
		Date: 08/2016

Alloy	Au750Pd4Mn	(Ni-free)
Item-no.	137 - 750	
Colour	white Mn	
Precious metals	Au 75,0 Ag 9,0 Pd 4,0	[%]
Density	14,8	[g/cm ³]
Melting range	930 – 1000	[°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	135 - 155	[HV]
Tensile strength	520 – 620	[MPa]
Yield point	310 – 390	[MPa]
Elongation	> 35	[%]
Solder:	deoxidize areas to be soldered	
Pretreatment	hydrozon	
Treatment	boraxin, flux H, partially fluoron	
Flux	diluted sulphuric acid or phosphoric acid, Vitrex	
Cleaning / pickling		

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
- Because of oxidizing of alloy components special procedures are required during any heat treatment (reducing atmosphere, using flux)
- Raw rings, delivery hardness: approx. 160 HV

For memoire-rings and tension rings we recommend our Pd – white gold alloy 133-750.