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AURUNA[®] 215

GOLD IRON INDIUM ELECTROLYTE



Gold Alloy Electrolyte Free of Nickel and Cobalt

AURUNA[®] 215 is a colour gold alloy electrolyte for decorative applications, preferably for parts coming into contact with the skin such as jewellery and watches. The essential advantage of the coatings is their freedom from nickel and cobalt, excluding skin allergies caused by these metals.

The weakly acidic gold electrolyte is easy to operate and suitable for rack and barrel, it works very colour-constant. Across a wide operating range, the coating colour (1N - 2N) is independent of pH-value and current density. By adding indium, a uniform colour is achieved.



Advantages

- Weakly acidic colour gold electrolyte
- Pale to light yellow coatings
- Colour-constant across a wide operating range
- Uniform colour
- For decorative applications
- Non-allergenic since free of nickel and cobalt
- The coatings are RoHS compliant
- Suitable for rack and barrel

Applications

- Jewellery
- Watches
- Spectacle frames
- Writing implements
- Accessories

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TECHNICAL SPECIFICATIONS

Electrolyte characteristics		Coating characteristics	
Electrolyte type	Weakly acidic	Coating	Gold-iron-indium
Metal content	2.5 (2.0 - 3.0) g/l Au 0.5 (0.4 - 0.6) g/l Fe 1.0 (0.8 - 1.2) g/l In	Alloy composition	98.5 weight % Au 1.4 weight % Fe 0.05 weight % In
pH value	4.0 (3.8 - 4.5)	Colour of deposit	Approx. 1N - 2N
Operating temperature	35 (30 - 35) °C	Brightness	Bright
Current density range	1.5 (0.5 - 2.0) A/dm ²	Hardness of deposit HV 0.015 (Vickers) approx. values	220 HV
Plating speed	Approx. 0.14 µm/ min at 1.5 A/dm ²	Max. coating thickness	3 µm
Anode material	Pt-Ti, MMO (type PLATINODE® 147)	Density of the coating	Approx. 17.5 g/cm ³

Intergro Co., Ltd

107-107/1 อ.สุตประเสริฐ (ฝั่งซ้าย) แขวงบางโกลน เขตบางคอกนครหลวง กรุงเทพฯ 10120

107-107/1 Sudprasert Rd.(Left), Bangkhlo, Bangkholaem, Bangkok 10120 Thailand

Tel : (662) 6885080-3, Fax : (662) 688-5095, E-mail : sales@intergro.co.th

www.intergro.co.th

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Electroplating

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