

Gold Plating

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Common Name	Also Known as	Typical Bath Constituents	Power Supply Recommendations	Typical Pulse Settings (if Used)	Typical Operating Parameters
Antique Gold (Green-Black)	Classes A, B	Gold as $\text{KAu}(\text{CN})_2$ (2 g/L)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: 316 SS
		Silver as Potassium Silver CN (0.3 g/L)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 50%	Filter Periodically
		Ammonium Carbonate (38 g/L)	Straight DC (Pulse Optional, but not Typical)	1 ms ON Time	Agitation: Not Required
		Sodium Cyanide (15 g/L)	Totalizer (tracks gold usage to prevent misuse or theft)	1 ms OFF Time	Operating temp: 70 to 90 F
					Typical pH (range): 10 to 11
					Output Voltage (Power Supply Max Rating): 6 VDC
					Current Density: 10 ASF (1.0 ASD)