

## 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
<b>Pure Gold</b>	Low Alkaline Gold	Gold (0.9-1.3 tr. oz/Gal)	<1% ripple	High Frequency (HFP); Do Not Use Low Frequency Pulse (LFP)	Anodes: Platinum-Clad Columbium or Titanium
		Auxiliary Salts (4-6 oz/Gal)	Amp-hr meter (gold metal additions based on A-hr meter readings)	Duty Cycle: 10% on a resistive seed layer or 70% on conductive metal	Heaters: Titanium
			Pulse Recommended	10% Duty Cycle: 0.1 ms ON Time 70% Duty Cycle: 0.7 ms ON Time	Filter Continuously
			Totalizer (tracks gold usage to prevent misuse or theft)	10% Duty Cycle: 0.9 ms OFF Time 70% Duty Cycle: 0.3 ms ON Time	Carbon Treat (Sensitive to Organics)
					Agitation: Vigorous
					Operating temp: 145 to 160 F (150 F Nominal)
					Typical pH (range): 5.8 to 6.4
					Output Voltage (Power Supply Max Rating): 6 VDC Current Density: 1-3 ASF (0.1-0.3 ASD)