

Rose Gold 18 Karat – Beginner Guide (Brush, Swab & Bath Plating)

Composition: 75 % gold – 25 % copper

Fineness: 18 karat

Gold content in electrolyte: approx. 10.1 g gold per liter

This beginner-friendly guide follows established international practice

Purpose and Properties of Rose Gold

Rose gold is a **decorative gold alloy** with a warm reddish tone. Due to its copper content, it is **more sensitive to contamination** than pure gold. Proper surface preparation is therefore essential.

Typical applications:

- Jewellery
- Watch cases
- Decorative metal parts

⚠ Safety Information

- Not classified as hazardous, but **irritating**
- Wear **protective gloves and safety goggles**
- Work in a well-ventilated area

Suitable Substrates

Recommended:

- Nickel
- Copper
- Brass
- Silver

Important:

- Always apply a **thin gold underlayer** (gold flash or 24 kt gold) before rose gold
- This improves adhesion and colour stability

Equipment & Electrical Setup

- **Normal polarity**
- Positive: handpiece with electrode and fabric pad
- Negative: crocodile clip on the workpiece

Recommended electrodes:

- Platinum electrode (best results)
- Graphite electrode (alternative)

Process Parameters

- **Voltage:** from 3 volts
- **Temperature:** room temperature is sufficient
- **Consistency:** liquid or thickened (with gelling agent)
- **Rinsing water:** distilled water only

Step-by-Step Instructions

1. Polishing

- Polish the surface to a high gloss
- The better the base finish, the more uniform the rose gold colour

2. Degreasing

- Thoroughly clean with electrocleaner
- Rinse with distilled water
- Do not touch the surface afterwards

3. Activation

- Activate at **2.7 volts**
- Short and even treatment
- Rinse with distilled water

4. Gold Underlayer

- Apply a thin **gold flash or 24 kt gold** layer
- Only a closed, very thin layer is required
- Rinse

5. Rose Gold Plating

- Wash fabric pad with warm water **before use**
- Soak pad well
- Plate using gentle circular movements
- Even movement ensures uniform colour

Note:

- No drying time required
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Troubleshooting

Black discolouration during plating:

- Cause: insufficient cleaning or rinsing
 - Action:
 - Stop immediately
 - Remove dark areas with polishing compound
 - Rinse again and continue plating
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Post-Treatment

- Rinse with distilled water
 - Polish to high gloss with a soft cloth and care product
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Care & Notes

- Always wash fabric pads with warm water before use
 - Use separate pads for different metals
 - Rose gold is decorative and not designed for heavy mechanical wear
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Training Video

<https://youtu.be/jNkAMUDrCu0>