

1PAG/D



925

GENERAL INFORMATION

Carats: 925‰, suitable also for 800‰ and 950‰
 Colour: white
 colour coordinates: L*=95.2 a*=-0.4 b*=5.6
 Advised use: casting
 Secondary use: mechanical works

| | | | | | | | | |
|------------------|----------------|---|--------------|---|----------------|---|--------|---|
| CASTING | closed systems | ■ | open systems | ■ | pre-set stones | ■ | | |
| MECHANICAL WORKS | stamping | ■ | chains | ■ | tube | ■ | spring | ■ |

Density: 10,16 g/cm³
 Hardness (as cast): 66 HV
 Hardness (after cold work 70%): 161 HV
 Hardness (after annealing): 67 HV
 Hardness (after age hardening): 97 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900 °C

Casting temperature:

80 °C over its melting temperature for continuous casting with sinker thermocouple.
 100 °C over its melting temperature to cast into ingot-mould and continuous casting.
 100 °C over its melting temperature to cast with centrifugal machines.
 120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere.
 140 °C over its melting temperature to cast in outdoor cylinders with vacuum.

Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions.

Cooling casted objects: in water after 5 minutes.
 Cooling casted objects (with stones): in water after 30/40 minutes.

Annealing: 650 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

Age hardening: *step 1: solubilization*
 720 °C for 30 minutes followed by quick cooling in hot water (min. 40 °C), better if with alcohol

step 2: hardening
 300 °C for 2 hours. Cooling at room temperature. **HINTS**

- ❖ Recommended Pandora Alloys silver solders: TA (soft), MA (medium), FA (hard)
- ❖ Suggested Pandora Alloys silver alloy for Classic Mechanical works: 1PAG/CA

The above directions are only indicative. Strong variations to the above data are possible, depending on personal experience. Please, do not hesitate to contact us for further information.
 Tech Chart and Safety Data Sheet available on our website www.pandoralloys.com