

1PW45

GENERAL INFORMATION

Colour: shining white
 Carats: Ready-to-use alloy: Silver 925‰
 Advised use: universal (both casting and mechanical works)

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

Density: 10,10 g/cm³
 Hardness (as cast): 65HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 880 °C

Casting temperature:

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.

Ingot-mould temperature: 150 °C

Cylinders temperature: from 600 °C to 700 °C depending on the machine and objects dimensions.

Cooling of ingots: quick in lukewarm water (about 40 °C)

Cooling casted objects: in water after 10 minutes.

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

Annealing: 600 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol.

HINTS

- ❖ Recommended Pandora Alloys silver solders: TA (soft), MA (medium), FA (hard)

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