

2NL



High Performance Mechanical

18 kt

GENERAL INFORMATION

Colour: 2N light yellow (**EN28654** Compliant)
colour coordinates: L*=84.0 a*=5.1 b*=36.4

Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 15,35 g/cm³
Hardness (as cast): 125 HV
Hardness (after cold work 70%): 230 HV
Hardness (after annealing): 120 HV
Hardness (after age hardening): 180 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910 °C

Casting temperature:
100 °C over its melting temperature to cast into ingot-mould and continuous casting.

Ingot-mould temperature: 150 °C

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

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

Age hardening: *Step 1: solubilization*
680 °C for 30 minutes. Cooling quickly in warm water (about 40 °C).

Step 2: hardening
300 °C for 2 hours. Cooling at room temperature

HINTS

- ❖ Recommended Pandora Alloys 18 kt yellow solders: TG18 (soft), MG18 (medium), FG18 (hard)
- ❖ Recommended Pandora Alloys 18 kt 2N-yellow High Performance Casting alloy: EXTRA2N

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