

2P14/ES



High Performance Casting

14kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 9kt (see specific tech data sheet)
 Colour: deep yellow
 colour coordinates: L*=88.9 a*=3.8 b*=20.0
 Advised use: casting
 Secondary use: mechanical works (if necessary usage of one alloy only)

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

Density: 12,88 g/cm³
 Hardness (as cast): 124 HV
 Hardness (after annealing): 120 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 870 °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

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

Ingot-mould temperature: 150 °C

Cooling casted objects: in water after 10 minutes

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

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

Annealing: 620 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

❖ Recommended Pandora Alloys 14kt yellow solders: TG14 (soft), MG14 (medium), FG14 (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