

2P14/ES



High Performance Casting

9kt

GENERAL INFORMATION

Carats: 9kt, suitable also for 14kt (see specific tech data sheet)
 Colour: deep yellow
 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: 11,07 g/cm³
 Hardness (as cast): 105 HV
 Hardness (after annealing): 100 HV
 Hardness (after age hardening): 180 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 with centrifugal machines
 100 °C over its melting temperature to cast into ingot-mould and continuous casting
 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 ingot: 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 lukewarm water (about 40 °C).

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

HINTS

❖ Recommended Pandora Alloys 9kt yellow solders: TG9 (soft), MG9 (medium), FG9 (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