

## 2P14/PO



Classic Casting

**14 kt**

### GENERAL INFORMATION

Carats: 14 kt, suitable also for 9 kt (see specific tech data sheet)  
 Colour: yellow  
 Advised use: casting  
 Secondary use: mechanical works

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

Density: 12,65 g/cm<sup>3</sup>  
 Hardness (as cast): 115 HV  
 Hardness (after cold work 70%): 212 HV  
 Hardness (after annealing): 112 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 860 °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.

Cylinders temperature: from 500 °C to 600 °C depending on the machine and objects dimensions.

Ingot-mould temperature: 150 °C

Cooling casted objects: in water after 15 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 14 kt 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](http://www.pandoralloys.com)