

2P18UNI/U



High Performance Casting

18 kt

GENERAL INFORMATION

Colour: Deep yellow
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,90 g/cm³
 Hardness (as cast): 158 HV
 Hardness (after annealing): 155 HV
 Hardness (after age hardening): 247 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °C

Casting temperature:

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 550 °C to 650 °C depending on the machine and objects dimensions.

Cooling casted objects: in water after 10 minutes.

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

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)

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