

## 2P18/S



High Performance Casting

18kt

### GENERAL INFORMATION

Carats: 18kt, suitable also for 22kt  
Colour: italian yellow  
colour coordinates: L\*=87.0 a\*=4.8 b\*=26.5  
Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 15,22 g/cm<sup>3</sup>  
Hardness (as cast): 128 HV  
Hardness (after annealing): 120 HV  
Hardness (after age hardening): 215 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900 °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 18kt 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](http://www.pandoralloys.com)