

2P18S/ECO



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/cm³
 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