

2P2022



High Performance Casting

21 kt

GENERAL INFORMATION

Carats: 21 kt, suitable also for 22 kt (see specific tech data sheet)
Colour: rich yellow colour coordinates: L*=85.7 a*=9.3 b*=25.5
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: 16,52 g/cm³
Hardness (as cast): 103 HV
Hardness (after cold work 70%): 213 HV
Hardness (after annealing): 100 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 940 °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 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 ingots: quick in lukewarm water (about 40 °C)

Annealing: 660 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

❖ Recommended Pandora Alloys 21 kt yellow solder: TG21

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