

2P2022/A

21 kt

GENERAL INFORMATION

Carats: 21 kt, suitable also for 22 kt (see specific tech data sheet)
Colour: rich yellow
Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains (hollow)	■	tube	■	spring	■
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Density: 16,82 g/cm³
Hardness (as cast): 135 HV
Hardness (after cold work 70%): 236 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 950 °C

Casting temperature:
100 °C over its melting temperature to cast into ingot-mould and continuous casting.

Ingot-mould temperature: 150 °C

Cooling of ingots: quick in lukewarm water (about 40 °C)

Annealing: 680 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

Age hardening: 300 °C for 2 hours, cooling at room temperature. This procedure allows to increase hardness.

HINTS

- ❖ Recommended Pandora yellow 21kt solder: TG21
- ❖ Recommended Pandora yellow 21kt alloy for casting: 2P2022

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.