

2P2022/A

22 kt

GENERAL INFORMATION

Carats: 22 kt, suitable also for 21 kt (see specific tech data sheet)
 Colour: rich yellow
 colour coordinates: L*=82.64 a*=6.14 b*=25.68
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains (hollow)	■	tube	■	spring	■
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Density: 17,75 g/cm³
 Hardness (as cast): 121 HV
 Hardness (after cold work 70%): 225 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 980 °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: 720 °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.