

## 2P2022/G



High Performance Mechanical

**21kt**

### GENERAL INFORMATION

Carats: 21kt, suitable also for 22kt (see specific tech data sheet)  
Colour: rich yellow  
colour coordinates: L\*=84.8 a\*=9.1 b\*=22.9  
Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 16,42 g/cm<sup>3</sup>  
Hardness (as cast): 122 HV  
Hardness (after cold work 70%): 235 HV  
Hardness (after annealing): 115 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 930 °C

Casting temperature:  
80 °C over its melting temperature for continuous casting with sinker thermocouple.  
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: 660 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

### HINTS

- ❖ Recommended Pandora Alloys 21kt yellow solder: TG21
- ❖ Recommended Pandora Alloys 21kt yellow 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.  
Tech Chart and Safety Data Sheet available on our website [www.pandoralloys.com](http://www.pandoralloys.com)