

2P2022/U

GENERAL INFORMATION

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

CASTING	closed systems	■	open systems	■	pre-set stones			■
MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■

Density: 16,68 g/cm³
 Hardness (as cast): 124 HV
 Hardness (after cold work 70%): 221 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 920 °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 of ingots: quick in lukewarm water (about 40 °C)

Annealing: 650 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

- ❖ Recommended Pandora yellow 21 kt 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.