

2P8/G



High Performance Mechanical

14kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 9kt (see specific tech data sheet)
 Colour: light yellow
 colour coordinates: L*=89.2 a*=3.1 b*=20.7
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains (hollow)	■	tube	■	spring	■
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Density: 12,95 g/cm³
 Hardness (as cast): 133 HV
 Hardness (after cold work 70%): 247 HV
 Hardness (after annealing): 135 HV
 Hardness (after age hardening): 194 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 870 °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: 620 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

Age hardening: *Step 1: solubilization*
 680 °C for 30 minutes. Cooling quickly in lukewarm water (about 40 °C).
Step 2: hardening
 300 °C for 2 hours. Cooling at room temperature.

HINTS

- ❖ Recommended Pandora Alloys 14kt yellow solders: TG14 (soft), MG14 (medium), FG14 (hard)
- ❖ Recommended Pandora Alloys 14kt yellow alloy for casting: 2P8/GS

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