

3NE



Classic Mechanical

18 kt

GENERAL INFORMATION

Colour: 3N yellow (**EN28654** Compliant)
Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 15,08 g/cm³
Hardness (as cast): 141 HV
Hardness (after cold work 70%): 245 HV
Hardness (after annealing): 140 HV
Hardness (after age hardening): 248 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °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: 640 °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 warm water (about 40 °C).

Step 2: hardening
300 °C for 2 hours. Cooling at room temperature.

HINTS

- ❖ Recommended Pandora Alloys 18 kt 3N yellow solders: T3NJ (soft), M3NJ (medium), F3NJ (hard)
- ❖ Recommended Pandora Alloys 18 kt 3N yellow alloy for casting: EXTRA3NS

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