

5P18/3



High Performance Mechanical
High Performance Casting

9 kt

GENERAL INFORMATION

Carats: 9 kt, suitable also for 14 kt (see specific tech data sheet) and 18 kt (see specific tech data sheet)

Colour: intense red
colour coordinates: L*=85.3 a*=10.9 b*=14.0

Advised use: universal (both mechanical works and casting)
Special alloy for extra light items

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

Density: 10,71 g/cm³

Hardness (as cast): 114 HV

Hardness (after cold work 70%): 212 HV

Hardness (after annealing): 110 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 960 °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.

Ingot-mould temperature: 150 °C

Cylinders temperature: from 600 °C to 700 °C depending on the machine and objects dimensions.

Cooling of ingots: quick in lukewarm water (about 40 °C)

Cooling casted objects: in water after 10 minutes

Cooling casted objects (with stones): in water after 30/40 minutes

Annealing: 680 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

❖ Recommended Pandora Alloys 9 kt red solders: TR9 (soft), MR9 (medium)

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.