

AG950PD



High Performance Mechanical
High Performance Casting

Silver
950

GENERAL INFORMATION

Colour: shining white **ANTI-TARNISH SURFACE**
 colour coordinates: L*=94.9 a*=0.1 b*=4.1
 Carats: Ready-to-use alloy: Silver 950‰, Palladium 25‰
 Advised use: universal (both mechanical works and casting)

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

Density: 10,42 g/cm³
 Hardness (as cast): 75 HV
 Hardness (after cold work 70%): 189 HV
 Hardness (after annealing): 70 HV
 Hardness (after heat treatment): 105 HV

DIRECTIONS FOR SUGGESTED USE

Temperature in continuous casting: 1060 °C
 Temperature in ingot-moulds: 1080 °C
 Casting temperature: 1100 °C ÷ 1120 °C
 Ingot-mould temperature: 150 °C
 Cylinders temperature: from 660 °C to 720 °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: 720 °C for 20 minutes (or 550 °C for 40 minutes) followed by a quick cooling in hot water (min. 40 °C).
 Pickling: suggested use of acid solutions sulfur-free. Use citric acid (concentration 10%-15%) set on a temperature of 60 °C. Change the solution frequently.
 Heat treatment: 730 °C for 30 minutes followed by quick cooling in hot water (min. 40 °C), better if with alcohol.

HINTS

- ❖ Recommended Pandora Alloys silver solders: TA (soft), MA (medium), FA (hard)

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.