

DRAGONWHITE/18



HIGH PERFORMANCE CASTING
LOW MELT LOSS

18kt

GENERAL INFORMATION

Carats: 18 kt
 Colour: white – standard
 Advised use: casting

CASTING	closed systems	■	open systems	■	torch	■	pre-set stones	■
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Density: 14,6 g/cm³

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890° C

Casting temperature:

100° C over its melting temperature to cast with centrifugal machines.

140° C over its melting temperature to cast in outdoor cylinders with vacuum.

120° C over its melting temperature to cast in vacuum machines with controlled atmosphere.

Cylinders temperature: from 550° C to 650° C depending on the machine and objects dimensions.

Cooling casted objects: in water after 10 - 20 minutes.

Nickel release UNI EN 1811:2015 Nickel release test on finished objects is required

HINTS

- ❖ Recommended Pandora white 18kt solders: TB18 (soft), MB18 (medium), FB18 (hard)
- ❖ Suggested plating solutions Pandora rhodium P2 and Pandora palladium PDSOL/BE

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