

## ELA2



High Performance Mechanical  
High Performance Casting

**14 kt**

### GENERAL INFORMATION

Carats: 14 kt , suitable also for 18 kt (see specific tech data sheet)  
 Colour: white – standard  
 colour coordinates: L\*=88.0 a\*=2.6 b\*=13.8  
 Advised use: universal (both mechanical works and casting)

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

Density: 12,90 g/cm<sup>3</sup>  
 Hardness (as cast): 180 HV  
 Hardness (after cold work 70%): 276 HV  
 Hardness (after annealing): 175 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900 °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 machine  
 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 550 °C to 650 °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

Annealing: 650 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

Nickel release UNI EN 1811:2015: 0.12 µg/cm<sup>2</sup>/week - **COMPLIANT** (max. 0.88 µg/cm<sup>2</sup>/week)  
 Nickel release test on finished objects is required

### HINTS

- ❖ Recommended Pandora Alloys 14 kt white solders: TB14 (soft), MB14 (medium), FB14 (hard)
- ❖ Suggested Pandora Alloys plating solutions: Rhodium P2 and 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.