

EL/A

GENERAL INFORMATION

Carats: 18 kt, suitable also for 14 kt (see specific tech data sheet)
 Colour: white
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: n.a.

Hardness: n.a.

Nickel release UNI EN 1811:2011: 0,158 µg/cm²/week

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890° C

Casting temperature:
 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: 620° C for 20 minutes followed by a quick cooling in hot water (40° C min.)

Hardening: 300° C for 120 minutes

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.