

LEGA EL



Classic Mechanical

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: white - standard
Advised use: mechanical works

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|------------------|----------|---|--------|---|------|---|--------|---|
| MECHANICAL WORKS | stamping | ■ | chains | ■ | tube | ■ | spring | ■ |
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Density: 10,83 g/cm³
Hardness (as cast): 113 HV
Hardness (after cold work 70%): 219 HV

Nickel release UNI EN 1811:2011: Nickel release test on finished objects is required

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 1050°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: 730°C for 20 minutes followed by a quick cooling in hot water (40°C min.)

HINTS

- ❖ Recommended Pandora white 9kt solders: TB9 (soft), MB9 (medium), FB9 (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.