

EXTRA5N45/ECO



High Performance Casting
 High Performance Mechanical

18kt

GENERAL INFORMATION

Colour: 5N red (**EN28654** Compliant)
 colour coordinates: L*=83.2 a*=10.3 b*=20.3

Advised use: universal (both casting and mechanical works)

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

Density: 14,92 g/cm³
 Hardness (as cast): 192 HV
 Hardness (after cold work 70%): 280 HV
 Hardness (after annealing): 190 HV
 Hardness (age hardening): 307 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °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 machines.
 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.

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

Ingot-mould temperature: 150 °C

Cooling casted objects: in water after 10 minutes.

Cooling casted objects (with stones): in water after 30/40 minutes.

Cooling of ingots: quick in lukewarm water (about 40 °C)

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

Age hardening: Step 1: solubilization
 680°C for 30 minutes. Cooling quickly in warm water (about 40°C).
 Step 2: hardening
 300°C for 2 hours. Cooling at room temperature.

HINTS

❖ Recommended Pandora Alloys 18kt 5N red solders: TR5NJ (soft), MR5NJ (medium), FR5NJ (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.