

OTT.67/33

GENERAL INFORMATION

Carats: NONE- to be used without gold
 Color: yellow
 Advised use: universal (both mechanical works and casting)

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

Density: 8,55 g/cm³
 Hardness (as cast): 90 HV
 Hardness (after cold work 70%): 160 HV
 Hardness (after annealing): 85 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 860 °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.

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 5/10 minutes.

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

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.