

T13



High Performance Mechanical

14 kt

GENERAL INFORMATION

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

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 12,65 g/cm³
 Hardness (as cast): 135 HV
 Hardness (after cold work 70%): 246 HV
 Hardness (after annealing): 127 HV

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 950 °C

Casting temperature:
 80 °C over its melting temperature for continuous casting with sinker thermocouple.
 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: 680 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

- ❖ Recommended Pandora Alloys 14kt 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.