

ALLOY YELLOW GOLD 21-22KT **NEED ADD SILVER** R94

RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL– INGOT CASTING – CONTINUOUS CASTING – CASTING

PRODUCTION: STAMPING – SHEARED – TUBE – SOLID CHAINS – HOLLOW CHAINS

CHARACTERIZATION DATA

COLOR RICH YELLOW

PERCEN SILVER ADD 10%

DENSITY [g/cm³] 16,65

MELTING TEMPERATURES °C 1060

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1085

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1055-1085	660-720
MEDIUM (FROM 0,50 TO 1,2MM)	1035-1055	620-650
THICK (ABOVE 1,2MM)	1015-1035	580-620

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 MINUTES, THEN QUENCH IN WATER.

PICKLING: DIP IN RADIAL SOLUTION 50g/l, 60°C FOR 2 MINUTES, OR IN SULPHURIC ACID

10% CONC, AT °C 50 FOR 5 MINUTES.

MECHANICAL WORKING PARAMETERS

MELTING TEMPERATURE[°C] 1080

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 1050-1080	> 5 MM 670	35
CONTINUOUS CASTING 1090-1150	< 5 MM 660	30
	< 1 MM 650	30

HARDENING TREATMENT:

⑩ 300 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 78

HARDNESS AFTER AGE-HARDENING HV AH 108