

RECOMMENDED APPLICATIONS

CASTING: CLOSED SYSTEMS – OPEN SYSTEMS
WITHOUT STONES -

CHARACTERIZATION DATA

COLOR	WHITE
PERCENT SILVER	3%
PERCENT NICKEL	34%
DENSITY [g/cm³]	17,1
MELTING TEMPERATURES °C	1070

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1140

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1100-1130	680-720
MEDIUM (FROM 0,50 TO 1,2MM)	1080-1090	640-670
THICK (ABOVE 1,2MM)	1070-1080	630-650

TREES WITHOUT STONES: LET THE FLASK COOL FOR 20 MINUTES, THEN QUENCH IN WATER.

PICKLING: DIP IN RADIAL SOLUTION 50g/l, °C60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 10 MINUTES.

HARDENING TREATMENT: 310 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS	HV AC 225
HARDNESS AFTER AGE-HARDENING	HV AH -255