

ALLOY WHITE GOLD 21 KT

BM40C18
RECOMMENDED APPLICATIONS

CASTING: CLOSED SYSTEMS – OPEN SYSTEMS
WITHOUT STONES -

CHARACTERIZATION DATA

COLOR WHITE

PERCENT NICKEL 40%

DENSITY [g/cm³] 16,90

MELTING TEMPERATURES °C 1030

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: 320 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 230

HARDNESS AFTER AGE-HARDENING HV AH -260