

RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS
WITH AND WITHOUT STONES -

CHARACTERIZATION DATA

COLOR SILVER WHITE

PERCENT NICKEL 28%

DENSITY [g/cm³] 8,9

MELTING TEMPERATURES °C 990

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1040

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1020-1030	680-700
MEDIUM (FROM 0,50 TO 1,2MM)	1010-1020	650-700
THICK (ABOVE 1,2MM)	990-1000	550-630

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

TREES WITH STONES: LET THE FLASK COOL FOR 40-50 MINUTES, THEN QUENCH IN THE WATER

PICKLING: DIP IN RADIAL SOLUTION 50g/l, °C60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 5 MINUTES.

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 85

HARDNESS AFTER AGE-HARDENING HV AH ---