

WHITE BRASS FOR CASTING
AL20S
RECOMMENDED APPLICATIONS
CASTING: CLOSED SYSTEMS – OPEN SYSTEMS
WITH AND WITHOUT STONES -

CHARACTERIZATION DATA
COLOR WHITE

PERCENT NICKEL 14%

DENSITY [g/cm³] 8,4

MELTING TEMPERATURES °C 980

CASTING PROCESSING PARAMETERS
MELTING TEMPERATURES [°C] 1080

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1080-1100	680-710
MEDIUM (FROM 0,50 TO 1,2MM)	1040-1070	650-700
THICK (ABOVE 1,2MM)	1000-1020	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 118

HARDNESS AFTER AGE-HARDENING HV AH ---