

ALLOY RED GOLD 18KT

**R4X2**
**RECOMMENDED APPLICATIONS**

**WORKING:** UNIVERSAL- CONTINUOUS CASTING – INGOT CASTING – CASTING

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

**CHARACTERIZATION DATA**

**COLOR** INTENSE RED

**PERCENT SILVER** 4%

**DENSITY [g/cm<sup>3</sup>]** 14,63

**MELTING TEMPERATURES °C** 910

**CASTING PROCESSING PARAMETERS**

MELTING TEMPERATURES °C 1030

| CASTING TEMPERATURES [°C]   | METAL [°C] | FLASK [°C] |
|-----------------------------|------------|------------|
| THIN (BELOW. 0,5MM)         | 990-1020   | 620-700    |
| MEDIUM (FROM 0,50 TO 1,2MM) | 980-990    | 580-650    |
| THICK (ABOVE 1,2MM)         | 970-980    | 540-620    |

**TREES WITHOUT STONES:** LET THE FLASK COOL FOR 5 MINUTES, THEN QUENCH IN WATER.

**TREES WITH STONES:** LET THE FLASK COOL FOR 35-40 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] 1030

| CASTING TEMPERATURE [°C]         | ANNEALING TEMPERATURE[°C] | TIME MINUTES ANNEALING |
|----------------------------------|---------------------------|------------------------|
| INGOT MAKING [°C] 970-1010       | > 5 MM 620-630            | 30                     |
| CONTINUOS CASTING [°C] 1020-1060 | < 5 MM 620-630            | 30                     |
|                                  | < 1 MM 610-620            | 25                     |

**HARDENING TREATMENT:**

275 °C FOR 180 MINUTES, COOL VERY SLOWLY

**TECHNICAL CHARACTERISTICS**

**AS CAST HARDNESS HV AC 180**

**HARDNESS AFTER AGE-HARDENING HV AH 285**