

**RECOMMENDED APPLICATIONS**

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

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

**CHARACTERIZATION DATA**

**COLOR** PINK

**PERCENT SILVER** 5 %

**DENSITY [g/cm<sup>3</sup>]** 14,65

**MELTING TEMPERATURES °C** 905

**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)	980-1000	580-650
THICK (ABOVE 1,2MM)	970-980	540-620

**TREES WITHOUT STONES:** REMOVE THE FLASK WITHIN 3 MINUTE AFTER POURING THEN QUENCH IMMEDIATELY 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] 1020

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 970-1010	> 5 MM 620-630	30
CONTINUOUS CASTING [°C] 990-1060	< 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 218

HARDNESS AFTER AGE-HARDENING HV AH 300