

**RECOMMENDED APPLICATIONS**

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

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

**CHARACTERIZATION DATA**

**COLOR** PINK

**PERCENT SILVER** **NEED ADD** 10%

**DENSITY [g/cm<sup>3</sup>]** 11,29

**MELTING TEMPERATURES** °C 998

**CASTING PROCESSING PARAMETERS**

MELTING TEMPERATURES °C 1045

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1000-1040	620-700
MEDIUM (FROM 0,50 TO 1,2MM)	990-1010	580-650
THICK (ABOVE 1,2MM)	980-1000	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] 1050

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 1040-1050	> 5 MM 620-630	30
CONTINUOUS CASTING [°C] 1050-1090	< 5 MM 620-630	30
	< 1 MM 610-620	25

**HARDENING TREATMENT:**

265 °C FOR 180 MINUTES, COOL VERY SLOWLY

**TECHNICAL CHARACTERISTICS**

**AS CAST HARDNESS HV AC 98**

**HARDNESS AFTER AGE-HARDENING HV AH 138**