

ALLOY RED GOLD 9KT

EKR1
RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL- CONTINUOUS CASTING – INGOT CASTING – CASTING

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

CHARACTERIZATION DATA

COLOR RED

PERCENT SILVER 4%

DENSITY [g/cm³] 11,21

MELTING TEMPERATURES °C 1010

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1070

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1020-1050	640-700
MEDIUM (FROM 0,50 TO 1,2MM)	1000-1020	610-640
THICK (ABOVE 1,2MM)	990-1000	550-600

TREES WITHOUT STONES: LET THE FLASK COOL FOR 8 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] 1080

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 115

HARDNESS AFTER AGE-HARDENING HV AH 140