

**RECOMMENDED APPLICATIONS**

**CASTING:** CLOSED SYSTEMS – OPEN SYSTEMS  
WITHOUT STONES -

**CHARACTERIZATION DATA**

**COLOR** OFF WHITE

**PERCENT NICKEL** 26%

**DENSITY [g/cm<sup>3</sup>]** 16,88

**MELTING TEMPERATURES °C** 1030

**CASTING PROCESSING PARAMETERS**

MELTING TEMPERATURES [°C] 1130

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1100-1110	680-720
MEDIUM (FROM 0,50 TO 1,2MM)	1080-1090	640-670
THICK (ABOVE 1,2MM)	1070-1080	630-650

**TREES WITHOUT STONES:** LET THE FLASK COOL FOR 20 MINUTES, THEN QUENCH IN WATER.

**PICKLING:** DIP IN RADIAL SOLUTION 50g/l, °C60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 10 MINUTES.

**HARDENING TREATMENT:** 300 °C FOR 180 MINUTES, COOL VERY SLOWLY

**TECHNICAL CHARACTERISTICS**

**AS CAST HARDNESS** HV AC 202

**HARDNESS AFTER AGE-HARDENING** HV AH -220