

ALLOY YELLOW GOLD 18 KT **M50X10**

#### RECOMMENDED APPLICATIONS

**CASTING:** OPEN SYSTEMS  
WITH AND WITHOUT STONES -

#### CHARACTERIZATION DATA

**COLOR** YELLOW/GREEN

**PERCENT SILVER** 50%

**DENSITY [g/cm<sup>3</sup>]** 15.0

**MELTING TEMPERATURES °C** 875

#### CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1020

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1000-1010	650-700
MEDIUM (FROM 0,50 TO 1,2MM)	990-1000	600-640
THICK (ABOVE 1,2MM)	970-990	500-600

**TREES WITHOUT STONES:** LET THE FLASK COOL FOR 10-15 MINUTES, THEN QUENCH IN WATER.

**TREES WITH STONES :** LET THE FLASK COOL FOR 30-45 MINUTES; THEN QUENCH IN WATER.

**PICKLING:** DIP IN RADIAL SOLUTION 50g/l, °C 60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 5 MINUTES.

**HARDENING TREATMENT:** 270 °C FOR 180 MINUTES, COOL VERY SLOWLY

#### TECHNICAL CHARACTERISTICS

**AS CAST HARDNESS** HV AC 132

**HARDNESS AFTER AGE-HARDENING** HV AH 228