

ALLOY YELLOW GOLD 18 KT **M15X15**

RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS – CLOSED SYSTEMS - WITHOUT STONES .

CHARACTERIZATION DATA

COLOR INTENSE YELLOW

PERCENT SILVER 15%

DENSITY [g/cm³] 11

MELTING TEMPERATURES °C 875

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1020

CASTING TEMPERATURES[°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1010-1020	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	990 -1000	600-640
THICK (ABOVE 1,2MM)	970 - 980	500-600

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 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 5 MINUTES.

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 120

HARDNESS AFTER AGE-HARDENING HV AH ---