

RECOMMENDED APPLICATIONS

CASTING: CLOSED SYSTEMS – OPEN SYSTEMS
WITHOUT STONES -

CHARACTERIZATION DATA

COLOR WHITE

PERCENT NICKEL 30%

DENSITY [g/cm³] 16,90

MELTING TEMPERATURES °C 1050

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 210

HARDNESS AFTER AGE-HARDENING HV AH -245