

RECOMMENDED APPLICATIONS
WORKING: UNIVERSAL – – INGOT CASTING – CASTING

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

CHARACTERIZATION DATA
COLOR WHITE

PERCENT SILVER 13%

PERCENT NICKEL 7%

DENSITY [g/cm³] 10,82

MELTING TEMPERATURES °C 1010

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1100

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1080-1100	660-720
MEDIUM (FROM 0,50 TO 1,2MM)	1050-1090	580-650
THICK (ABOVE 1,2MM)	1035-1070	480-600

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

TREES WITH STONES: LET THE FLASK COOL FOR 45 MINUTES, THEN QUENCH IN WATER

PICKLING: DIP IN RADIAL SOLUTION 50g/l, 60°C FOR 5-10 MINUTES, OR IN SULPHURIC ACID

10% CONC, AT °C 50 FOR 10 MINUTES.

MECHANICAL WORKING PARAMETERS

MELTING TEMPERATURE[°C] 1100

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 1180-1110	> 5 MM 640-650	30
CONTINUOUS CASTNG (°c) 1100-1150	< 5 MM 640-650	30
	< 1 MM 640-650	25

HARDENING TREATMENT: 230 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 112

HARDNESS AFTER AGE-HARDENING HV AH 138