

RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL- CONTINUOUS CASTING – INGOT CASTING – CASTING

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

CHARACTERIZATION DATA

COLOR WHITE

PERCENT SILVER ---

PERCENT NICKEL 14%

DENSITY [g/cm³] 10,8

MELTING TEMPERATURES °C 1055

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1060

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1000-1020	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	980-1000	580-650
THICK (ABOVE 1,2MM)	970-980	540-600

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 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] 1080-1100	> 5 MM 640-650	30
CONTINUOS CASTING [°C] 1060-1200	< 5 MM 640-650	30
	< 1 MM 640-650	25

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

THECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 115

HARDNESS AFTER AGE-HARDENING HV AH 140