

RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL- CONTINUOUS CASTING – INGOT CASTING – CASTING
PRODUCT: STAMPING – SHEARED – TUBE – SOLID CHAINS – HOLLOW CHAINS

CHARACTERIZATION DATA

| | |
|-----------------------------------|-------|
| COLOR | WHITE |
| PERCENT SILVER | 10% |
| PERCENT NICKEL | 15% |
| DENSITY [g/cm³] | 10,83 |
| MELTING TEMPERATURES °C | 970 |

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1100

| CASTING TEMPERATURES [°C] | METAL [°C] | FLASK [°C] |
|-----------------------------|------------|------------|
| THIN (BELOW. 0,5MM) | 1080-1100 | 660-700 |
| 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] 1100-1120 | > 5 MM 640-650 | 30 |
| CONTINUOUS CASTING [°C] 1160-1190 | < 5 MM 640-650 | 30 |
| | < 1 MM 640-650 | 25 |

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 138

HARDNESS AFTER AGE-HARDENING HV AH ---