

ALLOY RED GOLD 9 KT

**RM2**
**RECOMMENDED APPLICATIONS**

**CASTING:** OPEN SYSTEMS – CLOSED SYSTEMS  
WITHOUT STONES

**CHARACTERIZATION DATA**

**COLOR** INTENSE RED

**PERCEN SILVER** 2%

**DENSITY [g/cm<sup>3</sup>]** 11,09

**MELTING TEMPERATURES °C** 1000

**CASTING PROCESSING PARAMETERS**

MELTING TEMPERATURES [°C] 1100

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1060-1080	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	1050-1070	580-650
THICK (ABOVE 1,2MM)	1020-1030	500-600

**TREES WITHOUT STONES:** LET THE FLASK COOL FOR 5 MINUTES, THEN QUENCH IN WATER.

**TREES WITH STONES:** REMOVE THE FLASK IMMEDIATELY. IMMERSE ONLY THE BOTTOM PART OF THE TREE IN COLD WATER AND KEEP UNDER VENTILATION FOR 15 MINUTES. 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.

**HARDENING TREATMENT:** 250 °C FOR 180 MINUTES, COOL VERY SLOWLY

**TECHNICAL CHARACTERISTICS**

**AS CAST HARDNESS** HV AC 102

**HARDNESS AFTER AGE-HARDENING** HV AH 148