

ALLOY RED GOLD 9 KT

EKRMX
RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS – CLOSED SYSTEMS
WITH AND WITHOUT STONES

CHARACTERIZATION DATA

COLOR RED

PERCEN SILVER 5%

DENSITY [g/cm³] 11,11

MELTING TEMPERATURES °C 985

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1080

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 108

HARDNESS AFTER AGE-HARDENING HV AH -158--