

ALLOY YELLOW GOLD 18 KT **M29X3**

RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS – CLOSED SYSTEMS
WITH STONES - WITHOUT STONES -

CHARACTERIZATION DATA

COLOR YELLOW 4N
PERCEN SILVER 29%
DENSITY [g/cm³] 14,80
MELTING TEMPERATURES °C 940

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1030

CASTING TEMPERATURES[°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1010-1020	660-710
MEDIUM (FROM 0,50 TO 1,2MM)	1000-1010	600-640
THICK (ABOVE 1,2MM)	980-1000	500-600

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 MINUTES, THEN 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: 270 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 187
HARDNESS AFTER AGE-HARDENING HV AH -300--