

ALLOY YELLOW GOLD 18 KT **M44X7**

RECOMMENDED APPLICATIONS

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

CHARACTERIZATION DATA

COLOR INTENSE YELLOW

PERCENT SILVER 44%

DENSITY [g/cm³] 15

MELTING TEMPERATURES °C 875

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1010

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1000-1010	660-720
MEDIUM (FROM 0,50 TO 1,2MM)	980-990	600-640
THICK (ABOVE 1,2MM)	960-970	500-600

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 MINUTES, THEN QUENCH IN WATER.

TREES WITH STONES : LET THE FLASK COOL FOR 30-45 MINUTES; THEN QUENCH IN WATER.

PICKLING: DIP IN RADIAL SOLUTION 50g/l, °C 60 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 170

HARDNESS AFTER AGE-HARDENING HV AH 240