

ALLOY YELLOW GOLD 18 KT **M12X17**

RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS – CLOSED SYSTEMS - WITHOUT STONES .

CHARACTERIZATION DATA

COLOR YELLOW/PINK

PERCENT SILVER 12%

DENSITY [g/cm³] 12,74

MELTING TEMPERATURES °C 880

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1010

CASTING TEMPERATURES[°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1000-1020	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	995 -1000	600-640
THICK (ABOVE 1,2MM)	975 - 990	510-600

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: 280 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 145

HARDNESS AFTER AGE-HARDENING HV AH 240