

ALLOY YELLOW GOLD 9 KT **NEED ADD SILVER** GM75X

#### RECOMMENDED APPLICATIONS

**CASTING:** OPEN SYSTEMS  
WITH AND WITHOUT STONES -

#### CHARACTERIZATION DATA

**COLOR** YELLOW/GREEN

**PERCENT ADD SILVER** 20%

**DENSITY [g/cm<sup>3</sup>]** 11,1

**MELTING TEMPERATURES °C** 838

### CASTING PROCESSING PARAMETERS

#### MELTING TEMPERATURES[°C]990

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	940-980	650-680
MEDIUM (FROM 0,50 TO 1,2MM)	930-960	600-640
THICK (ABOVE 1,2MM)	910-950	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, °C60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 5 MINUTES.

**HARDENING TREATMENT:** 260 °C FOR 180 MINUTES, COOL VERY SLOWLY. POSSIBLY INSIDE THE FURNACE WITH A PROTECTION OF HYDROGEN; TO OBTAIN FURTHER HARDENING INCREASE THE TIME IN THE FURNACE.

#### TECHNICAL CHARACTERISTICS

**AS CAST HARDNESS** HV AC 110

**HARDNESS AFTER AGE-HARDENING** HV AH 145