



ALLOY YELLOW GOLD 14 KT **NEED ADD SILVER** GM75X

RECOMMENDED APPLICATIONS

CASTING: OPEN SYSTEMS
WITH AND WITHOUT STONES -

CHARACTERIZATION DATA

COLOR LIGHT YELLOW

PERCENT ADD SILVER 28%

DENSITY [g/cm³] 12,65

MELTING TEMPERATURES °C 860

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 995

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	960-990	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	940-960	600-640
THICK (ABOVE 1,2MM)	920-940	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: 265 °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 125

HARDNESS AFTER AGE-HARDENING HV AH 165