

RECOMMENDED APPLICATIONS

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

CHARACTERIZATION DATA

COLOR OFF WHITE

PERCENT SILVER 7%

PERCENT NICKEL 20%

DENSITY [g/cm³] 14,70

MELTING TEMPERATURES °C 900

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1050

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1020-1050	660-720
MEDIUM (FROM 0,50 TO 1,2MM)	1005-1025	600-650
THICK (ABOVE 1,2MM)	985-1005	480-600

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

TREES WITH STONES: LET THE FLASK COOL FOR 45-60 MINUTES, THEN QUENCH IN WATER.

PICKLING: DIP IN RADIAL SOLUTION 50g/l, °C60 FOR 5-10 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 10 MINUTES.

HARDENING TREATMENT: 270 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 175

HARDNESS AFTER AGE-HARDENING HV AH 205