

ALLOY YELLOW GOLD 14KT

P5X26
RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL– CONTINUOUS CASTING – INGOT CASTING – CASTING

PRODUCTION: STAMPING – SHEARED – TUBE – SOLID CHAINS – HOLLOW CHAINS – OPEN SYSTEM CASTING

CHARACTERIZATION DATA

COLOR YELLOW/GREEN

PERCEN SILVER 5%

DENSITY [g/cm³] 12,7

MELTING TEMPERATURES °C 910

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 990

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	940-960	630-680
MEDIUM (FROM 0,50 TO 1,2MM)	930-950	600-610
THICK (ABOVE 1,2MM)	900-930	540-600

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

PICKLING: DIP IN RADIAL SOLUTION 50g/l, 60°C FOR 2 MINUTES, OR IN SULPHURIC ACID

10% CONC, AT °C 50 FOR 5 MINUTES.

MECHANICAL WORKING PARAMETERS

MELTING TEMPERATURE[°C] 1000

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 980-1000	> 5 MM 610-640	30
CONTINUOUS CASTING [°C] 1010-1060	< 5 MM 610-640	30
	< 1 MM 610-620	30

HARDENING TREATMENT: 260 °C FOR 180 MINUTES, COOL VERY SLOWLY

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 108

HARDNESS AFTER AGE-HARDENING HV AH 125