

**MASTER
ALLOY**
BR10

BRASS FOR CASTING

GENERAL INFORMATION
General information

Typology	Brass
Color	Yellow
Color shade	Pinkish yellow
Production process	Casting
Grain refinement level	Low
Deoxidation level	Very high

Commercial composition (%)

CU	92.0
ZN	4.0
SI	4.0

Melting Temperatures

Solidus [°C]	880.0
Liquidus [°C]	985.0
Melting range [°C]	105.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
85.5	3.3	13.5	13.9	

Mechanical characteristics

As cast hardness [HV 0.2]	125.0
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Physical characteristics

Density [g/cm ³]	8.6
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Product applications

Stone-in-place casting
 Casting in closed systems
 Casting in open systems

CASTING PROCESSING PARAMETERS
Pre-melting temperature

Temperature [°C] 1105

POURING TEMPERATURES

	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1085	1115
0.5 - 1.2 mm	580	650	1065	1085
> 1.2 mm	460	600	1045	1065

Trees without stones

Let the flask cool down for 5 minutes, then quench it in water.

Stone-in-place casting trees

Let the flask cool down for 30-45 minutes, then quench it in water.

Pickling

Dip in RADIAL solution (50 g/l conc. at 60°C) for 2 minutes, or in sulphuric acid (10% concentration at 50°C) for 5 minutes.