

GENERAL INFORMATION
General information

Typology	Master alloy for gold
Color	White
Color shade	Standard white
Production process	Casting
Grain refinement level	Minimum
Deoxidation level	High

Commercial composition (%)

CU	68.0
ZN	19.0
NI	13.0

Melting Temperatures

Solidus [°C]	950.0
Liquidus [°C]	1000.0
Melting range [°C]	50.0

FULL CHARACTERIZATION DATA
Color coordinates

L *	a*	b*	c*	Yellow Index
87.6	1.3	10.6	10.6	21.6

Mechanical characteristics

As cast hardness [HV 0.2]	110.0
---------------------------	-------

Physical characteristics

Density [g/cm ³]	10.8
------------------------------	------

Product applications

Stone-in-place casting
 Casting in open systems
 Casting without stones

CASTING PROCESSING PARAMETERS
Pre-melting temperature

Temperature [°C] 1120

POURING TEMPERATURES

	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660	720	1080	1100
0.5 - 1.2 mm	580	650	1050	1080
> 1.2 mm	460	600	1020	1050

Trees without stones

Let the flask cool down for 10-15 minutes, then quench it in water.

Stone-in-place casting trees

Let the flask cool down for 45-60 minutes, then quench it in water.

Pickling

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